

Product Name

Chrome Free Alkali CFIPCOTE

Product Description

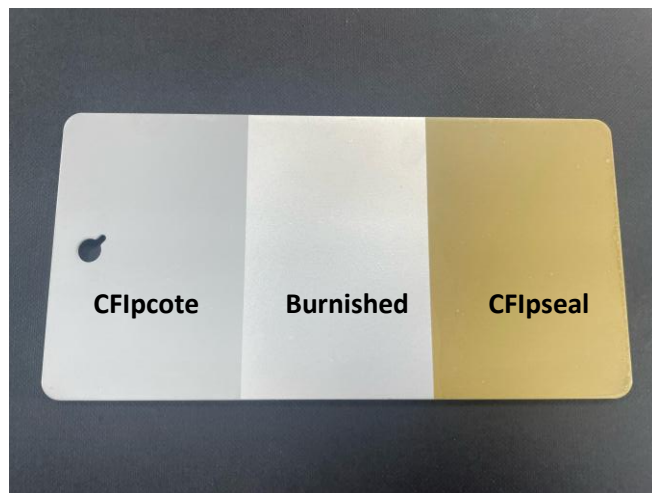
CFIPCOTE Alkali is a 2-part Alkali based Aluminium Sacrificial base coat. Fully EU and UK REACH Compliant, easy to mix and apply tested to comply with many of the major approvals.

Base coat used as a stand-alone sacrificial coating or overcoated with a seal coat

see separate technical data sheet.

Development of the product has considered the use of the chrome free product as a direct replacement for traditional chrome containing versions, with almost identical application parameters and the same curing temperatures and oven times.

This facilitates direct replacement of traditional chrome containing coatings without any major changes to application and curing equipment or schedules.



Approvals and Specifications/ Technical Performance

Samples of CF Ipcote are being evaluated for technical performance and application parameters at aerospace and industrial turbine engine primes and tier one manufacturers.

The following table details the test results on test panels and components conducted within the Indestructible Laboratories

Test	Applicable Standard	Result	Substrate
Adhesion	ISO 2409	1mm X-Hatch Class "0": no loss of adhesion	Mild Steel
Salt Spray Resistance	ASTM. B-117 ISO 9227	>1000hours at 40–50-micron film thickness	Mild steel
Dry Heat	a.) CPW88	a.) 20 hours @371°C (700°F) followed by 4 hours @ 580°C (1076°F) b.) 1224 hours @ 500°C (932°F)	Mild steel
Water Soak	552201	336 hours @ 80°C (176°F) with no loss of adhesion	Mild Steel
Cyclic Saltwater Fog/Dry Heat (450°C; 842°F)	MSRR9140 (MSRR9910)	10 Cycles: no corrosion	Low alloy steel
Surface conductivity	MSRR9910, test 16	a.) 350°C (662°F) cure: Electrically conductive post normal burnishing process b.) 540-560°C(1004-1040°F) cure: Electrically conductive post cure	Mild steel

Components

Part A: White Liquid Activating Agent
 Part B: Grey Coloured Aluminium Slurry
 Empty clear bottle to aid mixture of the 2 parts
 Filter Paper to aid application.

Spray Guns

Our applications team have carried out extensive trials with several currently available spray guns, and we suggest one of the following guns be used for the application of CFIPcoat

Manufacturer	Model	Fluid Tip	Air Cap	Atomising Pressure
Anest-Iwata	LPH-80	0.8-1.2mm	PH80-E4	1.6-2.0 bar
Anest-Iwata	W-300	1.2mm	W-300-WB1	1.2 bar
DeVilbiss	DV-1S	0.7-0.8mm	DV1-M1 Micro	2.0 bar
SATA	Jet 20B	0,8		1.6-2.0 bar
SATA	Minijet 4400B RP	RP 0,8	RP 0,8 SR	1.6-2.0 bar

Application

Refer to IPAS666-CF for full detailed instructions.

Surface Preparation	Degrease and Light Abrasive Blast as required. Ensure surfaces to be coated are clean and free from dust/dirt.
Paint Preparation	Roller speed should be approx. 60 rpm. Roll Part B (Aluminium) for 24 hours prior to mixing with Part A Ensure Part A is shaken or rolled for 15 minutes until white solids are thoroughly mixed. Once Parts A & B are mixed; roll or mix at slow speed for minimum 30 minutes maximum 2 hours
Mixing Ratio	Mix 1:1 Parts by Volume (Part A: Part B) Workable life 6-8 hours
Application Method	Application of mist coat followed by wet coat for each component, allow to air dry minimum 10-15 minutes and repeat application. Check film builds once air dry. (40 -50 microns) Video available on request. See the recommended guns for application: <i>Note: if any break in application, then ensure gun is cleaned thoroughly before resuming.</i> Application are controls to be within, Temperature – 15-25°C (55-77°F), Humidity – 35-55% RH (Below 50%RH is recommended)
Drying and Curing	Air dry before, cure at 80 °C for 30 minutes, ramp to final cure 350 °C for minimum 30 minutes, recommended 1 hour. Other Curing Schedules can be used: please contact Indestructible technical services team for more information.

Repair Touch Up

For unburnished Clpcote, use new CFIPPL177 chrome free Sacrificial Touch up
For burnished CFIPCOTE, use IP9138-R1, Aluminium Air-Dry Touch up

Liquid Technical Properties**

Mixed Viscosity	30 – 35 Seconds ISO3 23C
Flash Point	N/A
Mixed Density	1.38-1.42 g/cm ³
VOC Content	0 g/l
Non-Volatile Content Mixed	42-46%
Colour	Matt Grey
Gloss	Matt
Thinner	Demineralised Water
Solvent/Clean Up	Demineralised Water
Theoretical Coverage	7m ² per Litre at 40-micron DFT
Pack Size	1L Containers
Pot Life	6-8 Hours once mixed

** - The values referenced are obtained from Batch testing using controlled Quality techniques.

Storage

Shelf Life*:** Shelf life of CFIPCOTE is 6 months.

Before use, refer to Product Safety Data Sheet

*** - Indestructible Paint decline any responsibility deriving from improper storage of Product.

Contact

For Safety Data Sheets or other Information please contact our sales Department:

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