
Product Name:IP3-Range

Product Number:Please Refer to the Product Range for full colour range

Product Description:

Epoxy top coat (enamel) range developed to take account of EU, USA and emerging Global environmental pressures. IP3 coatings are particularly suited for application to United Technologies (Pratt and Whitney, Sikorsky and Hamilton Sunstrand) applications. This range contains not only low VOC's but also no Lead, Xylene or Toluene. The IP3 range provides a Chromate free system when used with IP3-6500, 6600 or 6700 Primer or a Chromate containing system using IP3-6362 Primer.

Approvals/Specifications:

- Rolls Royce MSRR 9064
- Def Stan 80-161
- Supersedes DTD 5555, 5580 etc
- HCP 355 – AEC's Paint Procedure
- Turbomeca LB 568
- BS2X33 (IP3-6362)
- Dowty PS5618

Specifications for IP3-0000 and IP3-CAT

- Technical Specification: AIMS04-32-000
 - Material Specification: AIMS04-32-004
 - Individual Product Specification: IPS04-32-004-01
 - Semi-finished Part Specification: ABS5941
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Performance:

- After 7 days air curing, or force cure for 30 minutes at 125°C, will pass:
 - Heat resistance for 48 hours at 400°F (204°C)
 - Heat resistance for 100 hours at 180°C
 - Hot oil; 8 hours in ASTM Fluid 101 (ASTM D 471) at 350°F (177°C) showing no peeling or softening
 - Hot lube oil for 100 hours at 150°C
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- Fuel resistance ASTM ref fuel B for 4 hours at room temperature without peeling or softening
- Fuel resistance for 100 hours
- Skydrol hydraulic for 3 hours at 70°C (160°F)
- Corrosion resistance; after exposure to heat (48 hours at 400°F) cross scratched X withstands 350 hours salt spray ASTM B117
- Resistant to 10 cycles of 4 hours at 250°C (300°F) 20 hours salt fog
- VOC below 420 Grams
- Resistant to temperatures of down to at least -40°C

Components:

- IP3-Base (part A)
- IP3-CAT (part B) or IP3-FASTCAT (part B)
- IP3-Reducer (may be added if required for coating complex unit geometry).

Application:

Surface Preparation:

Ensure that all surfaces are clean and free from dirt

Paint Preparation:

Pre-treatment: Usually applied over IP3-6500, 6600 or 6700 Chromate Free 2 Pack Low VOC Epoxy Primer

Mixing Instructions: Mix with either IP3-CAT, or for Fast Cure IP3-FASTCAT – Refer to mixing instruction sheet and base component can label for correct ratio. Allow 15 minutes induction time and re-stir before use.

Pot Life: 4 hours @ 60-80°F (15-26°C) using IP3-CAT
2-3 hours @ 60-80°F (15-26°C) using IP3-FASTCAT

Thinner/Reducer Addition: 5-10% of IP3-Reducer (if required)

Application Method:

Spray – Compliant guns recommended. Refer to gun manufacturers instructions regarding pressures etc.

Drying Curing:

Air Dry:

- *Standard Cat:* Touch Dry for 2-3 hours; Hard Dry for 16-24 hours
- *Fast Cat:* Touch Dry for 1-2 hours; hard dry for 4-5 hours (for full performance allow to Air Dry for 7 Days)

Heat Cure:

- *Flash Off:* 20-30 minutes at room temperature; Cure for 20-30 minutes at 125°C

This process provides a coating that can be handled for masking and inspection operations when the coating has cooled to room temperature.

Technical Properties:

Supply Viscosity:	Gloss – 60-80 Seconds, ISO5, 23 +/- 2°C
Flash Point:	27°C
VOC Content:	Range: 150-260 g/l
Colour:	Available in a variety of colours
Pack Size:	1 and 5 Litres
Density:	1.018-1.51kg/l
Gloss:	Available in a variety of gloss
Thinner:	IP3-REDUCER, IP-MEG-REDUCER
Solvent/Clean Up:	IP3-REDUCER, 40006 (Gun Wash)
Catalyst:	IP3-CAT or IP3-FAST-CAT
Theoretical Coverage:	N / A

Storage:

Highly flammable liquid store and use in accordance with the flammable liquid regulations.

Shelf Life: 12 months Temperate; 6 months Tropical

Before Use Please Refer to Product Safety Data Sheet

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Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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