

Technical Data Sheet



Product Name: Smoothseal

Product Number: IP9444

Product Description:

Smoothseal is an inorganic protective coating used as a barrier on Ipcote IP9183-R1, IP9253, PL219, Ipthin IP9356.

Smoothseal cures to provide an ultra-smooth finish to improve dirt shedding and air flow properties.

All of the Ipcote coatings are conductive, sacrificial coatings and inherently porous. Smoothseal seals this porosity without detracting from their sacrificial properties. It also creates an electrically non-conductive barrier coat. The use of Smoothseal on top of these products results in an ultra-smooth, harder coating which provides a barrier against carbon deposits etc, extending the useful life of the base coat, and ultra-smooth finish which enhances airflow characteristics and therefore engine efficiency.

When used to give an alternative system to Sermatech's 5380 system, it is applied over specially prepared Ipcote IP9183, (apply for Rolls process Spec 666/5)

A light golden yellow colour, it has similar appearance to 5380DP

Approvals/Specifications:

- Release to MSRR3010, similar to MSRR9140
 - RPS666/5
 - NSN: 8030-99-371-0990
 - Meets CPW 406
 - Siemens: 552208
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Performance:

- Smooth eggshell finish
 - Typical thickness 4-6 microns per coat (0.2 thoug#)
 - Operating temperature -40°C to 800°C (1420°F)
 - Less than 0.6% hexavalent chrome
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Components:

Single Pack Product. May be thinned with de-ionised water for spray application. Where low humidity is present within a spray facility the addition of 5-10% by volume of de-ionised water may be required.

Application:

Surface Preparation:

Ensure that surfaces are clean and free from dirt

Paint Preparation:

Stir well before use. All separated material must be re-incorporated into the bulk product. No time limits are specified for the mixing operation. The operator must be satisfied that the product including any thinning solvent is thoroughly mixed before use. Where mechanical mixing is employed care must be taken to not heat the product to above the maximum storage temperature. Mixing in open containers should be limited to <10 minute periods to ensure that solvent evaporation does not compromise the product. Shaking or rolling in closed containers is an acceptable mixing method for small volume products supplied ready for use.

Application Method:

Spray applied coating. Refer to application sheet IPAS666. Refer to RPS 666/5 for Rolls Royce parts.

Drying Curing:

Air Dry: 10 minutes

Heat Cure: Pre-bake for 30 minutes at 80-100°C, 30-60 minutes at 350°C

Technical Properties:

Supply Viscosity:	Ready for use
Solids:	32-36
Flash Point:	N/A
VOC Content:	0 g/l
Colour:	Yellow
Pack Size:	1 Litre
Density:	1.2 kg/l
Gloss:	N/A
Thinner:	Water
Solvent/Clean Up:	Water

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Theoretical Coverage: 33m²/l @ 6 microns

Storage:

Shelf Life: 6 months

Before use, refer to Product Safety Data Sheet

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Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

Tel: +44(0)121 702 2485

Email: sales@indestructible.co.uk