



Effective 28 October, 2005

DP6910

IMRON® 2K TOPGLOSS CLEARCOAT

Description

2-component clear based on Low Emission resin technology, to be used in clear over base system.

Composition based on acrylic copolymer.

Products

DP6910	DuPont™ Marine Finishes Imron® 2K Topgloss Clearcoat
DP6912	DuPont™ Marine Finishes HS Activator
DP2100	DuPont™ Marine Finishes HS Activator Standard
DP2110	DuPont™ Marine Finishes HS Activator Slow
TH61	DuPont™ Marine Finishes Thinner Large Surfaces
TH101	DuPont™ Marine Finishes Standard Thinner
TH102	DuPont™ Marine Finishes Slow Thinner

Auxiliary products

AK350	DuPont™ Centari® Blending Thinner
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Properties

- Combines very easy application with little sagging risks.
- Gives a smooth, high build finish and has very fast drying properties.
- Has excellent mar, chemical and weather resistance.

Substrates

Following specifications listed in the DuPont™ Marine Finishes Manual and in particular:

- Imron® Basecoat DuPont™ Marine Finishes.











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PRODUCT PREPARATION

	Mixing ratio	Standard		Large surface		High build	
		Volume	Weight	Volume	Weight	Volume	Weight
	DP6910	3	100	3	100	3	100
	DP2100	1	37	-	-	-	-
	DP6912/DP2110	-	-	1	36	1	36
	TH61/TH101/TH102	-	-	0.3	9	-	-
	VOC	490 to 520 g/l					
	Pot life at 20°C	DP6912/DP2110	2 hr				
		DP2100	1 hr 30 min				
	Spray viscosity at 20°C	DIN 4	17-18 s				
		FORD 4	17-19 s				
		AFNOR 4	19-21 s				
	Spray equipment		Fluid tip		Distance		
		Gravity feed	1.4-1.6 mm		15-20 cm		
		Suction feed	1.6-1.8 mm		15-20 cm		
		HVLP	1.3-1.5 mm		10-15 cm		
		Pressure feed	1.0-1.2 mm		15-20 cm		
	Spray pressure	Gravity feed	3-4 bar				
		Suction feed	3-4 bar				
		HVLP	0.7 bar at nozzle				
		Pressure feed	4 bar				
	Number of coats	2					
	Flash time	Minimum 5 min and maximum 2 hr between coats.					
	DFT	40 to 60 μ					
	Drying		DP2100		DP6912/DP2110		
			20°C		20°C		
	Dust-free		1 hr		1 hr		
	Tape-free and dry to handle		6 hr		8 hr		
	Complete hardening		7 to 14 days		7 to 14 days		
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.							



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RECOMMENDED USE

Surface preparation

The entire panel has to be carefully prepared (before basecoat application) following specifications listed in the DuPont™ Marine Finishes Manual.

Clearcoat application

Apply 1 light coat followed immediately by a full coat or 2 medium coats. Flash minimum 5 min and maximum 2 hr between coats.

Chemical resistance

When fully cured, DP6910 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	tar
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	petrol

Remarks

- Close can of DP6912, DP2100 and DP2110 tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- Activated material should not be returned to original can of non-activated material.
- Dry spray spots in the clear can be worked off with AK350 at very low spray pressure. This should be done at the latest 10 min after clear application and should be avoided on horizontal parts.
- For structured and/or flat clears, see specific TDS.
- For flexible systems, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

Recoatability

At any time after tape-free and dry to handle time following specifications listed in the DuPont™ Marine Finishes Manual.



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RECOMMENDED USE (con'd)

Equipment cleaning

Use a suitable nitrocellulose thinner.

Product data

Package viscosity: 36 cp
 Theoretical coverage: 8.0 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Storability at 20°C (year)	Density (kg/l)
DP6910	5	2	0.965
DP6912	1 - 5	2	1.060
DP2100	1 - 5	2	1.059
DP2110	1 - 5	2	1.078
TH61	5	2	1.059
TH101	5	2	0.925
TH102	5	2	0.923
AK350	5	2	0.907

Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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REPAIR SYSTEMS

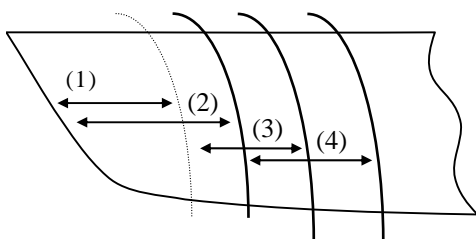
Overall repair

Pay attention to the application method. Spray procedure has to ensure proper overspray melt-in which is achieved within 2 min of the clear application. Plan the process to avoid dry overspray.

Spot repair: AK350 Centari® Blending Thinner method

When spot repairing with Imron® Basecoat, the clearcoat method as described below can be used. If blending out the clear in original areas is unavoidable, the melt-in of the clear can be achieved as described below:

- ← Apply 1 coat of DP6910 over the basecoat, extending into the area surrounding the spot.
- ↑ Apply a 2nd coat of DP6910, extending further into the area surrounding the spot.
- OPTIONAL: reduce 1 part of activated ready-for-use DP6910 with 1 part AK350 and apply 1 coat of reduced DP6910 over the blend-out area.
- ↓ Blend in the fade-out area immediately with pure AK350.
- ! Surface should be carefully and correctly prepared before the basecoat application. See recommended use, paragraph surface preparation.
- ! Stay with the application of AK350 within the prepared area.



If necessary, balance out the gloss level by polishing with 1500S or 3000S after complete hardening of the repair.