Effective 28 October, 2005

IMRON® 2K TOPGLOSS

2K P.U. TOPCOAT

Description

2-component topcoat system for solid colours for use on yachts and pleasure crafts. Composition based on a unique, patented “star” polymer technology.

Products

MI-…	DuPont™ Marine Finishes Imron® Topgloss Mixed Colours
DP2100	DuPont™ Marine Finishes HS Activator Standard
DP211	DuPont™ Marine Finishes Imron® Topcoat Activator Slow
TH61	DuPont™ Marine Finishes Thinner Large Surfaces
TH101	DuPont™ Marine Finishes Standard Thinner
TH102	DuPont™ Marine Finishes Slow Thinner
AD345	DuPont™ 1K Thinner

Auxiliary products

AK350	DuPont™ Centari® Blending Thinner
600S	DuPont™ Medium Duty Compound
1500S	DuPont™ One Step Polish
3000S	DuPont™ Highlighting Glaze
3910WB	DuPont™ Waterborne Degreaser
3911WB	DuPont™ Final Clean
3919S	DuPont™ Prepsol
3920S	DuPont™ Degreaser

Properties

Imron® 2K Topgloss gives excellent appearance, a high gloss finish, very good hiding and low consumption.

Substrates

Following specifications listed in the DuPont™ Marine Finishes Manual.

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PRODUCT PREPARATION

	Mixing ratio		**Standard**	**Large surface**
		Imron® 2K Topgloss	5	3
		DP2100	1	-
		DP211	-	1
		TH61/TH101/TH102/AD345	0.5 to 1.2	0.5 to 1.2
	VOC	550 to 620 g/l		
	Pot life at 20°C	DP2100	45 min	
		DP211	4 hr	
	Spray viscosity at 20°C	**DIN 4**	16-20 s	
		FORD 4	16-20 s	
		AFNOR 4	18-22 s	
	Spray equipment		**Fluid tip**	**Distance**
		Gravity feed	1.2-1.6 mm	20-25 cm
		Suction feed	1.4-1.8 mm	20-25 cm
		HVLP	1.2-1.5 mm	10-15 cm
		Pressure feed	1.0-1.2 mm	20-25 cm
	Spray pressure	**Gravity feed**	3-4 bar	
		Suction feed	3-4 bar	
		HVLP	0.7 bar at nozzle	
		Pressure feed	4-6 bar	
	Number of coats	2		
	Flash time	Standard: 10 to 15 min between coats. Large surface: 30 to 60 min between coats.		
	DFT	50 to 70 µ		
	Drying		**20°C**	**20°C**
		Dust-free	20 min	3 hr
		Tape-free and dry to handle	4 hr	16 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

Following specifications listed in the DuPont™ Marine Finishes Manual.

Topcoat application

Following specifications listed in the DuPont™ Marine Finishes Manual.

Chemical resistance

When fully cured, Imron® 2K Topgloss 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

- Imron® 2K Topgloss colours have to be thoroughly mixed.
- Close can of DP2100 and DP211 tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- For structured and/or flat colours, 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 according to specifications listed in the DuPont™ Marine Finishes Manual.

Equipment cleaning

Use a suitable nitrocellulose thinner.

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RECOMMENDED USE (con'd)

Product data

Theoretical coverage: 6.0-7.0 m²/l at recommended DFT - ready-to-spray

Products	**Packages** (l)	**Storability at 20°C** (year)	**Density** (kg/l)
MI-… Imron® Topgloss			
Mixed Colours	-	1	-
DP2100	1 - 5	2	1.062
DP211	1 - 5	2	0.976
TH61	5	2	0.900
TH101	5	2	0.925
TH102	1 - 5	2	0.923
AD345	1 - 5	2	0.846
AK350	5	2	0.907
600S	1	2	1.403
1500S	1	2	1.080
3000S	1	2	0.970
3910WB	5	2	0.975
3911WB	5	2	0.945
3919S	5 - 20	2	0.811
3920S	5 - 20	2	0.776

Safety

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

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REPAIR SYSTEMS

Spot repair

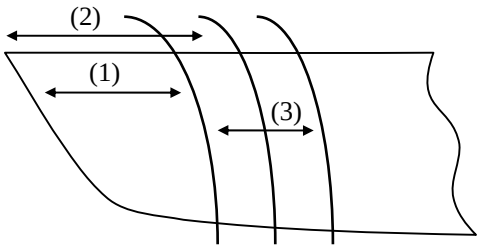
1. Clean surface with water and soap.
2. Degrease with 3919S or 3910WB and wipe dry with clean cloth.
3. Repair with recommended undercoats.
4. Sand primed spots as recommended.
5. Prepare complete blending area with 3M Scotch Brite® ultra fine sanding pad or with 600S.
6. Degrease with 3920S or 3911WB.
7. Wipe dry and tack rag.
8. The following spot repair methods can be used:
   - AK350 Centari® Blending Thinner method.

AK350 Centari® Blending Thinner method

← Apply 1st coat Imron® 2K Topgloss. Flash 10 to 15 min between coats.

↑ Extend 2nd coat Imron® 2K Topgloss beyond the previous one.

→ Blend in the fade-out area with AK350.



OPTIONAL: dilute 1 part ready-to-spray Imron® 2K Topgloss with 1 part AK350 in the 2nd or 3rd coat.
If necessary, balance out the gloss level by polishing with 1500S or 3000S after complete hardening of the repair.