



Effective 28 October, 2005

IMRON® BASECOAT

LOW EMISSION BASECOAT

Description

Medium solids basecoat for use in clear over base systems for solid, metallic and pearl colours. Suitable for use on yachts and pleasure crafts. Composition based on acrylic copolymer.

Products

MB-...	DuPont™ Marine Finishes Imron® Basecoat Mixed Colours
DP2120	DuPont™ Marine Finishes Imron® Basecoat Activator
TH90	DuPont™ Marine Finishes Imron® Basecoat Thinner Fast
TH91	DuPont™ Marine Finishes Imron® Basecoat Thinner
DP162	DuPont™ Marine Finishes Imron® Basecoat Binder

Auxiliary products

600S	DuPont™ Medium Duty Compound
3911WB	DuPont™ Final Clean
3920S	DuPont™ Degreaser

Properties

- Imron® Basecoat provides ease of application.
- The excellent hiding, coverage balance gives significant savings in application time and consumption.

Substrates

Following specifications listed in the DuPont™ Marine Finishes Manual.

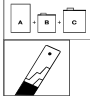








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PRODUCT PREPARATION

	Mixing ratio	Imron® Basecoat DP2120 TH90/TH91	Volume	
				2.4 0.6 1.5
	VOC	669 to 742 g/l		
	Pot life at 20°C	8 hr		
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	14-25 s 14-25 s 15-26 s	
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip	Distance
			1.2-1.4 mm	15-20 cm
			1.4-1.6 mm	15-20 cm
			1.2-1.4 mm	10-15 cm
			1.0-1.2 mm	15-20 cm
	Spray pressure	Gravity feed Suction feed HVLP Pressure feed	3-4 bar 3-4 bar 0.7 bar at nozzle 4-6 bar	
	Number of coats	2 to 3		
	Flash time	10 min between coats, maximum 4 hr.		
	DFT	15 to 30 μ		
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.

Basecoat application

Following specifications listed in the DuPont™ Marine Finishes Manual.

Clearcoat application

Following specifications listed in the DuPont™ Marine Finishes Manual.

Remarks

- Imron® Basecoat Mixed Colours have to be thoroughly mixed.
- Close can of DP2120 tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

Recoatibility

Following 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: 12.0-16.0 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Storability at 20°C (year)	Density (kg/l)
MB-...			
Imron® Basecoat Mixed Colours	-	1	-
DP2120	1 - 5	2	1.023
TH90	5	2	0.847
TH91	5	2	0.868
DP162	3.5	2	0.926
600S	1	2	1.403
3911WB	5	2	0.945
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 following specifications listed in the DuPont™ Marine Finishes Manual.
2. Repair with recommended undercoats.
3. Sand primed spots as recommended.
4. Prepare complete blending area with 600S or sand wet with P1200.
5. Rinse with water and wipe dry.
6. Degrease with 3920S or 3911WB.
7. Wipe dry and tack rag.
8. The following spot repair methods can be used:
 - with use of mid-coat;
 - without use of mid-coat.

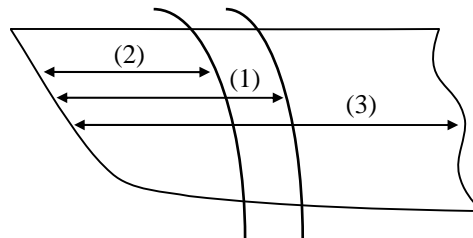
WITH use of mid-coat

Preparation of mid-coat: reduce DP162 with TH91: 2/1

← Apply mid-coat, flash till completely flat.

↑ Apply 2 coats of basecoat, extending 2nd coat beyond the previous one.
Flash time: 3 to 5 min.

→ Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.

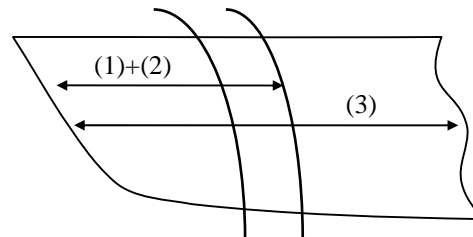


Spray pressure: spot repair area: 2-2.5 bar.

WITHOUT use of mid-coat

← Apply 2 to 3 coats Imron® Basecoat, extending each one beyond the previous one.

↑
→ Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



Spray pressure: spot repair area: 2-2.5 bar.