

IMRON® MARINE DP6940 Imron® Super Flow HS Clearcoat

Description

2-component clear based on Low Emission resin high solids technology, to be used in clear over base system.
Composition based on acrylic copolymer.

Products

| | |
|--------|--------------------------------|
| DP6940 | Imron® Super Flow HS Clearcoat |
| DP2100 | HS Activator Standard |
| DP2110 | HS Activator Slow |
| TH61 | Thinner Large Surfaces |
| TH101 | Standard Thinner |
| TH102 | Slow Thinner |

Auxiliary products

| | |
|------|------------------|
| TH50 | Blending Thinner |
|------|------------------|

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 Imron® Marine Manual and in particular:

- Imron® Basecoat.

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PRODUCT PREPARATION

| | | | | | |
|--|---|--------------------|--------|----------------------|--------|
|  Mixing ratio | DP6940 DP2100 DP2110 TH61/TH101/TH102 | Standard | | Large surface | |
| | | Volume | Weight | Volume | Weight |
| | | 5 | 100 | 5 | 100 |
| | | 2 | 45 | - | - |
| | | - | - | 2 | 45 |
| | | - | - | 0.3 - 0.5 | 9 - 12 |
| VOC | 450 to 480 g/l | | | | |
|  Pot life at 20°C | DP2100 | 1 hr. | | | |
| | DP2110 | 2 hr. | | | |
|  Spray viscosity at 20°C | DIN 4 | 17-18 s | | | |
| | FORD 4 AFNOR 4 | 17-19 s 19-21 s | | | |
|  Spray equipment | Gravity feed | Fluid tip | | Distance | |
| | Suction feed | 1.4-1.6 mm | | 15-20 cm | |
| | HVLP | 1.6-1.8 mm | | 15-20 cm | |
| | Pressure feed | 1.3-1.5 mm | | 10-15 cm | |
| | | 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 30 min and maximum 2 hr. between coats. | | | | |
| DFT | 50 to 70 μ | | | | |
|  Drying | Dust-free Tape-free and dry to handle Complete hardening | DP2100 | | DP2110 | |
| | | 20°C | | 20°C | |
| | | 1 hr. | | 1 hr. 30 min | |
| | | 6 hr. | | 8 hr. | |
| | | 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 following specifications listed in the Imron® Marine Manual.

Clearcoat application

Apply 1 light coat followed immediately by a full coat or 2 medium coats. Flash minimum 30 min and maximum 2 hr. between coats.

Chemical resistance

When fully cured, DP6940 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 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 TH50 at very low spray pressure. This should be done at the latest 10 min after clear application and should be avoided on horizontal parts.
- Adequate ventilation will be maintained during the first 6 hours of drying to avoid humidity blushing.
- 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.



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Recoatability

At any time after tape-free and dry to handle time following specifications listed in the Imron® Marine Manual.

Equipment cleaning

Use a suitable nitrocellulose thinner.

Product data

Package viscosity: 57 cP
 Volume solids: 48 ± 2% - ready-to-spray
 Theoretical coverage: 8.2 m²/l at recommended DFT ready-to-spray

| Products | Packages (l) | Storability at 20°C (Months) | VOC (g/l) ± 5 | Density (kg/l) ± 0.01 | Flash Point (°C) |
|----------|-----------------|------------------------------------|---------------------|-----------------------------|---------------------|
| DP6940 | 5 | 48 | 475 | 0.99 | 31 |
| DP2100 | 1 | 36 | 314 | 1.06 | 23 |
| DP2110 | 1 | 36 | 320 | 1.08 | 41 |
| TH61 | 5 | 60 | 905 | 0.91 | 25 |
| TH101 | 1 | 60 | 925 | 0.93 | 10 |
| TH102 | 1 | 60 | 923 | 0.92 | 46 |
| TH50 | 1 | 60 | 883 | 0.91 | 20 |

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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.

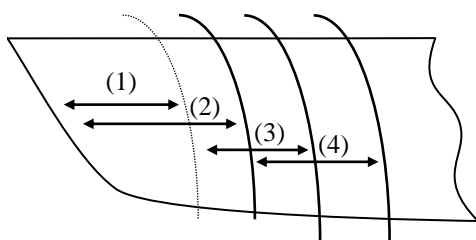
Spot repair: TH50 Blending Thinner method

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:

- (1) Apply 1 coat of DP6940 over the basecoat, extending into the area surrounding the spot.
- (2) Apply a 2nd coat of DP6940, extending further into the area surrounding the spot.
- (3) OPTIONAL: Reduce 1 part of activated ready-for-use DP6940 with 1 part TH50 and apply 1 coat of reduced DP6940 over the blend-out area.
- (4) Blend in the fade-out area immediately with pure TH50.

! Surface should be carefully and correctly prepared before the basecoat application. See recommended use, paragraph surface preparation.

! Stay with the application of TH50 within the prepared area.



If necessary, balance out the gloss level by polishing with a non silicone containing polishing compound or a non silicone containing final glaze, after complete hardening of the repair



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Safety

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

Information

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.
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