



DuPont OEM/Fleet Finishes

TECHNICAL MANUAL

IMRON®

TYPE

Two-component polyurethane enamel.

DESCRIPTION

A two-component polyurethane enamel consisting of a pigmented base and activator. Imron® is available with a host of companion products to fit the need of the user, such as 189S Dry Time Accelerator, 259S Fish Eye Eliminator, and various Imron Reducers.

SUGGESTED USES

A high-gloss, extremely durable, chemical and solvent resistant air dry enamel that is available in both solid and metallic colors. It is an extremely versatile product and is recommended for use on aircraft, commercial vehicles, trucks, trailers, boats (above the water line), fleets, passenger cars, and other applications where superior performance and appearance are expected.

NOT RECOMMENDED FOR

- Immersion service.
- Use over old lacquer finishes.

COMPATIBILITY WITH OTHER COATINGS

Imron can be applied over a number of DuPont primers, namely:

- Corlar® Primers
- DuPont Uro® Primers and Sealers
- Prime 'N Seal™
- Tufcote™ Primers
- Many old finishes that are in good condition, except lacquers. It is recommended that the old surface to be painted first be spot tested for lifting potential.

DRY FILM CHARACTERISTICS

- Chemical Resistance -- EXCELLENT
- Humidity Resistance -- EXCELLENT
- Weatherability -- EXCELLENT
- Acid Resistance -- EXCELLENT
- Alkali Resistance -- EXCELLENT
- Solvent Resistance -- VERY GOOD
- Abrasion Resistance -- EXCELLENT
- Flexibility -- EXCELLENT

MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service.
- 300°F (148°C) in intermittent heat.

VOLUME SOLIDS (MIXED 3:1 W/ 192S)

- 34.0%; average which will vary with color selected.

WEIGHT SOLIDS (MIXED 3:1 W/ 192S)

- 47.5%; average which will vary with color selected.

SUGGESTED FILM THICKNESS

- 1.8 - 2.2 mils dry film thickness.

THEORETICAL COVERAGE PER GALLON

- 544 sq. ft./gal. @1 mil.

GLOSS

- High.
- 929-5050 Flattening Compound for Imron is available for use to obtain lower gloss values, if desired.

COLOR

- Available in solid and metallic colors.

FLASH POINT (CLOSED CUP)

- Below 80°F.

SHELF LIFE

- 12 months minimum.

APPLICATION SOLVENTS

- 8485S
- 8575S (65 - 75°F)
- 8585S (70 - 85°F)
- 8595S (80 - 95°F)

CLEANUP SOLVENTS

- DuPont Thinner 3602S.

POLYURETHANE ENAMEL

ACTIVATION

Shake Imron® for at least 90 seconds on a Cyclone® Paint Shaker before mixing. Add 3 parts Imron Enamel with 1 part 192S and mix thoroughly. Strain material prior to spray application. Activated material can be reduced 10 - 20% with appropriate Imron Reducer.

INDUCTION TIME

- No induction time is required.

POT LIFE

- 8 hours at 70°F.

ADDITIONAL COMMENTS

- Heating activated material above 110°F will cause gelation.
- When recoating Imron with itself, sanding is required if enamel has air dried more than 16 hours or been force dried.
- The use of 189S is recommended for improved pot life and dry time. Use up to 4 ounces per ready-to-spray gallon.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F above the dew point. Relative humidity should be below 90%.

APPLICATION

- Thoroughly mix Imron Enamel prior to activation. The use of a Cyclone® Paint Shaker is recommended.
- To 3 parts Imron add 1 part 192S Imron Activator; up to 4 ounces of 189S Imron Accelerator can be used to improve dry time.
- For siphon gun application, set air pressure to 50 - 55 psi at the gun for solid colors, and 60 - 65 psi for metallics.
- For pressure pot set air pressure at 60 - 70 psi at the gun for solid colors, and 65 - 75 psi for metallics. Fluid delivery should be set for 10 - 12 oz/min.
- For solid colors, apply a medium first coat. Allow to tack up. Apply a second light-medium coat. Apply the third coat medium to wet. The third coat can be reduced 15% with appropriate Imron Reducer. If desired, another light-medium coat of the reduced material may be used.

- In hot conditions, the use of 8100S up to 10% by volume can be used if needed.

CURE TIME AT RECOMMENDED THICKNESS (AT 77°F & 50% RH)

	without 189S	with 189S
■ Dry to Touch	1 hour	30 min.
■ Tack Free	2-3 hours	1-2 hours
■ Tape Free	6-10 hours	3-5 hours

Product may be force dried 30 minutes at 140 - 180°F.

APPLICATION EQUIPMENT

- Pressure Pot (recommended)
- Air-Assisted Airless
- Gravity Feed Gun
- Suction Spray
- HVLP

FOR VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

SAFETY AND HANDLING

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling or using. These products are for industrial use by trained professional painters only.

