



Effective 16 November, 2009

IMRON® 700

POLYURETHANE ENAMEL

Description

2-component topcoat system designed for application on trucks, buses and light commercial vehicles.

Composition based on functional polyurethane.

Products

AM	Centari® MasterTint®
AU170	Polyurethane Binder
AU270	Polyurethane Activator
256S	Activator Fast
AU370	Polyurethane Thinner

Properties

- Offers easy application on large surfaces with perfect flow and overspray melt-in, fast set up and dry to assemble times.
- Has excellent mechanical, chemical and weather resistance.
- Can be used for spot, panel and overall repair.

Substrates

- All OEM finishes, DuPont Refinish primer surfacers or DuPont Refinish surfacers.


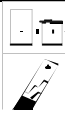









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PRODUCT PREPARATION

	DuPont Refinish colour tools	See colour formula.					
	Mixing ratio	Imron® 700 AU270 256S AU370	Standard		Fast		
			4	1	4		
			-	1			
			0.5-1	0.5-1			
	VOC	530-585 g/l					
	Pot life at 20°C	4 hr					
	Spray viscosity at 20°C	DIN 4	16-17 s				
		FORD 4	16-17 s				
		AFNOR 4	18-20 s				
	Spray equipment		Fluid tip	Distance	Pressure		
		Conventional guns					
		Gravity feed	1.2-1.5 mm	15-20 cm	3-4 bar		
		Suction feed	1.4-1.8 mm	15-20 cm	3-4 bar		
		Pressure feed	1.0-1.2 mm	15-20 cm	3-4 bar		
		Compliant guns (HVLPHTE)					
Gravity feed	1.2-1.4 mm	10-15 cm	According to supplier's specifications				
		Suction feed	1.4-1.6 mm	10-15 cm			
		Pressure feed	1.0-1.2 mm	10-15 cm			
	Number of coats	2					
	Flash time	10 min between coats. 10 min before bake.					
	DFT	50-60 µ					
	Drying		AU270		256S		
			20°C	30 min x 60°C	20°C	20 min x 60°C	
		Dust-free	30 min	imm.	25 min	imm.	
		Dry to handle	4 hr	imm.	4 hr	imm.	
	Tape-free	12 hr	1 hr	12 hr	1 hr		
	IR drying*	Flash time	10 min	* Guideline for short/medium wave IR equipment.			
	Distance	80 cm					
	Half power	5 min					
	Full power	15-20 min					

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

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Sand surface:
 - a. mechanical P320 - P360;
 - b. wet P800 - P1000.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
7. Tack rag.

Topcoat application

On well prepared surface, apply 2 full coats with 10 min flash between coats.

Chemical resistance

When fully cured, Imron® 700 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol
nitric acid	20 %	gasoline
citric acid	10 %	

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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RECOMMENDED USE (con'd)

Recoatability

At any time after tape-free time. After 24 hr, scuff sanding is required.

Remarks

- Centari® MasterTints® have to be thoroughly mixed before weigh-out and the Imron® 700 colour has to be mixed immediately after weigh-out.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For structured and/or flat colours, see specific TDS.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

Product data

Theoretical coverage: 6-7 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)
AM Centari® MasterTint® (solids)	1 - 4	4
AU170	4 - 20	2
AU270	5	3
256S	1 - 5	3
AU370	1 - 5	4

Safety

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



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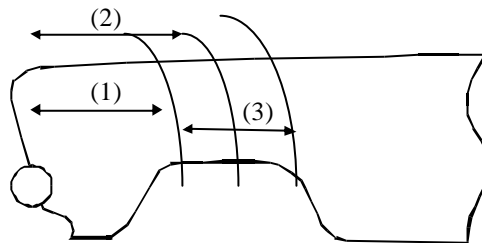
REPAIR SYSTEMS

Spot repair

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended.
5. Prepare complete fade-out area with a non silicone containing rubbing compound or sand wet with P1200.
6. Rinse with water and dry.
7. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
8. Tack rag.
9. The following spot repair method can be used:
 - AK350 Fade-out Thinner method.

AK350 Fade-out Thinner method

- † Apply 1st coat Imron® 700.
Flash time: 10 min.
- † Extend 2nd coat Imron® 700
beyond the previous one.
- † Smoothen out the fade-out area with
AK350.



OPTIONAL: dilute the remaining part Imron® 700 with 1 part AK350 after 2nd coat and apply 1 coat of this mixture extending in the blending area, before blending in the fade-out area with pure AK350.

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.