

IMRON® MARINE

Imron® Basecoat

Description

2K 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-...	Imron® Basecoat Mixed Colors
DP2120	Imron® Basecoat Activator
TH90	Imron® Basecoat Thinner Fast
TH91	Imron® Basecoat Thinner
DP162	Imron® Basecoat Binder

Auxiliary products

TH39	Water Based degreaser
3919S	Prepsol

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 Imron® MarineManual.

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PRODUCT PREPARATION

	Mixing ratio		Standard	Special Colors
		Imron® Basecoat DP2120 TH90/TH91	4 1 2.5	5 1 3
	VOC	669 to 742 g/l		
	Pot life at 20°C	8 hr.		
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	16-25 s 16-25 s 17-26 s	
	Spray equipment		Fluid tip	Distance
		Gravity feed	1.2-1.4 mm	15-20 cm
		Suction feed	1.4-1.6 mm	15-20 cm
		HVLP	1.2-1.4 mm	10-15 cm
		Pressure feed	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 Imron® Marine Manual.

Basecoat application

Following specifications listed in the Imron® Marine Manual.

Clearcoat application

Following specifications listed in the Imron® Marine Manual.

Remarks

- Imron® Basecoat Mixed Colors have to be thoroughly mixed.
- Axalta Coatings Systems is not responsible for color-matching in the end-application of customer, in particular if customer applies products from different batches. Customer shall perform an inspection related to the color of products before taking the products into use.
- 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.

Recoatability

Following specifications listed in the Imron® Marine Manual.

Equipment cleaning

Use a suitable nitrocellulose thinner.

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Product data

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

Products	Packages (l)	Storability at 20°C (year)	VOC (g/l) ± 5	Density (kg/l) ± 0.01	Flash Point (°C)
MB-... Imron® Basecoat	-	1	-	-	23
DP2120	1 - 5	2	450	1.02	25
TH90	5	2	851	0.85	23
TH91	5	2	872	0.87	35
DP162	3.5	2	737	0.93	24
TH39	5	2	195	0.98	68
3919S	5 - 20	2	815	0.78	35

REPAIR SYSTEMS

Spot repair

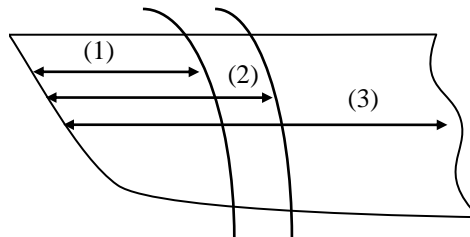
1. Clean surface following specifications listed in the Imron® Marine Manual.
2. Repair with recommended undercoats.
3. Sand primed spots as recommended.
4. Prepare complete fade-out area with a non-silicone containing rubbing compound or sand wet with P1200.
5. Rinse with water and wipe dry.
6. Degrease with 3919S or TH39.
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.

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With use of mid-coat

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

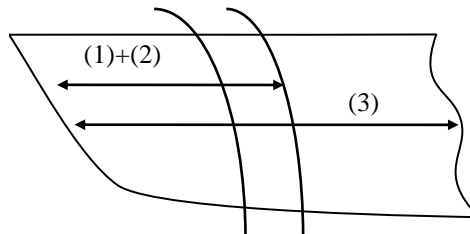
- (1) Apply mid-coat, flash till completely flat.
- (2) Apply 2 coats of basecoat, extending 2nd coat beyond the previous one.
Flash time: 3 to 5 min.
- (3) Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



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

Without use of mid-coat

- (1) + (2) Apply 2 to 3 coats Imron® Basecoat, extending each one beyond the previous one.
- (3) 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.

Safety

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



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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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