

## IMRON® MARINE

### Imron® 2K Topgloss SF

#### Description

2-component topcoat system for solid colours for use on yachts and pleasure crafts. Composition based on a unique, patented acrylic polymer technology.

#### Products

MSF-...	Imron® 2K Topgloss SF Mixed Colours
DP2100	HS Activator Standard
DP2110	HS Activator Slow
TH61	Thinner Large Surfaces
TH101	Standard Thinner
TH102	Slow Thinner

#### Auxiliary products

TH50	Blending Thinner
TH39	Water Based degreaser
3919S	Prepsol

#### Properties

Imron® 2K Topgloss SF gives excellent appearance, a high gloss finish, very good hiding and low consumption.









#### Substrates

Following specifications listed in the Imron® Marine Manual.

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### PRODUCT PREPARATION

	<b>Mixing ratio</b>	Imron® 2K Topgloss SF DP2100 DP2110 TH61/TH101/TH102	<b>Standard</b>	<b>Large Surfaces</b>
			3 1 - 0.5 to 1.5	3 - 1 0.5 to 2
	<b>VOC</b>	520 to 570 g/l		
	<b>Pot life at 20°C</b>	DP2100	45 min	
		DP2110	2 hr.	
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	16-23 s 16-23 s 18-25 s	
	<b>Spray equipment</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	<b>Fluid tip</b>	<b>Distance</b>
			1.2-1.6 mm	20-25 cm
			1.4-1.8 mm	20-25 cm
			1.2-1.5 mm	10-15 cm
			1.0-1.2 mm	20-25 cm
	<b>Spray pressure</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	3-4 bar 3-4 bar 0.7 bar at nozzle 4-6 bar	
	<b>Number of coats</b>	2 to 3		
	<b>Flash time</b>	30 to 60 min between coats.		
	<b>DFT</b>	50 to 70 µ		
	<b>Drying at 20°C</b>	<b>Dust-free</b> <b>Tape-free and dry to handle</b> <b>Complete hardening</b>	<b>Standard</b>	<b>Large Surfaces</b>
			20 min	3 hr.
			4 hr.	16 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.				

## IMRON® MARINE Imron® 2K Topgloss SF

### RECOMMENDED USE

#### Surface preparation

Following specifications listed in the Imron® Marine Manual.

#### Topcoat application

Following specifications listed in the Imron® Marine Manual.

#### Chemical resistance

When fully cured, Imron® 2K Topgloss SF 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

- Imron® 2K Topgloss SF colours have to be thoroughly mixed.
- Axalta Coating 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.
- Adequate ventilation will be maintained during the first 6 hours of drying to avoid humidity blushing.
- When force dry, ensure minimum 15% fresh air is added.
- 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.
- For structured and/or flat colours, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

## IMRON® MARINE Imron® 2K Topgloss SF

### Recoatability

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

### Equipment cleaning

Use a suitable nitrocellulose thinner.

### Product data

Theoretical coverage: 6.0-7.0 m<sup>2</sup>/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)
Mixed colors MSF-.... Imron® 2K Topgloss SF	/	12	/	/	27
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
3919S	5	60	813	0.81	43

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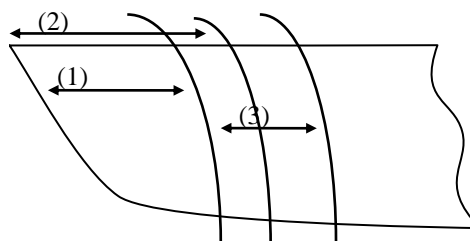
### REPAIR SYSTEMS

#### Spot repair

1. Clean surface with water and soap.
2. Degrease with 3919S or TH39 and wipe dry with clean cloth.
3. Repair with recommended undercoats.
4. Sand primed spots as recommended.
5. Prepare complete fade-out area with a non-silicone containing rubbing compound or sand wet with P1200.
6. Degrease with 3919S or TH39.
7. Wipe dry and tack rag.
8. The following spot repair methods can be used:
  - TH50 Blending Thinner method.

#### TH50 Blending Thinner method

- (1) Apply 1<sup>st</sup> coat Imron® 2K Topgloss SF.  
Flash 10 to 15 min between coats.
- (2) Extend 2<sup>nd</sup> coat Imron® 2K Topgloss SF beyond the previous one.
- (3) Blend in the fade-out area with TH50.



OPTIONAL: dilute 1 part ready-to-spray Imron® 2K Topgloss SF with 1 part TH50 in the 2<sup>nd</sup> or 3<sup>rd</sup> coat.

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.



## IMRON® MARINE Imron® 2K Topgloss SF

### 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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