

Imron® MS600™
EM Mixed Color

Brush Application

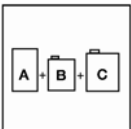
General Information for Use

Imron® MS600™ Marine Topcoats are formulated for optimum appearance with spray application. Products can be satisfactorily applied by brush. Roller application is not recommended. Always verify your method of application will lead to the results you desire.



Components

Imron® MS600™ Color
DuPont™ 18101S™ Brush & Roll Activator
DuPont™ 18701S™ Brush & Roll Reducer



Mix Ratio

Thoroughly mix Imron® MS600™ Color prior to activation. Filter activated material prior to application.

<i>Three Component System</i>	<i>Parts by Volume</i>
Imron® MS600™ Color	4
DuPont™ 18101S™ Activator	1
DuPont™ 18701S Reducer	1

Viscosity will be 22 to 25 seconds in a Zahn #2 cup.



Pot Life and Induction Time

Pot life is 3 hours at 70°F (21°C)
No induction time is required prior to application.

Guidelines for Use



Substrate and Surface Preparation

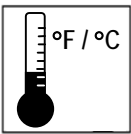
Surface preparation is critical to topcoat appearance. Primers and surfacers should be properly applied and cured according to product recommendations. Surfaced substrate should be DA sanded with 240-grit or finer for best appearance. Substrate should always be thoroughly wiped/tacked immediately prior to topcoat application.

Application

Apply Imron® topcoat in two coats, 1.5 to 2.0 mils wet film thickness, waiting 16 hours between coats. To improve appearance, sand between coats with 320 to 400 grit paper. After sanding, blow off surface, solvent wipe and tack to ensure a clean surface.

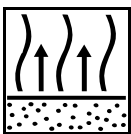
Use quality brushes, such as Corona Urethamer™.

If the second coat is not applied within 24 hours, the first coat must be scuff sanded to ensure adequate adhesion.



Environmental Conditions

Substrate and ambient temperature must be between 55°F (13°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated material above 110°F (43°C) may cause gelation.



Dry Times

Air Dry at 70°F (21°C)

Dry to Touch	4-8 hours
Dry to Tape	overnight



Cleanup Solvents

DuPont™ 3642S™ Thinner or Nason® 481-16 Thinner

Physical Properties

VOC	<i>Less Exempts (LE)</i>	<i>As Packaged (AP)</i>
Ready-to-Apply Topcoat	3.9 lbs/gal	3.8 lbs/gal

Ready-to-Apply

Theoretical Coverage	740 ft ² /gal average at 1 mil dry film thickness
Weight Solids	60 % average
Volume Solids	44 % average
Gallon Weight	9.3 lbs/gal average

Dry Film

Gloss	≥ 90 measured at 60°
Recommended Film Thickness	2.0 – 2.5 mils

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Do not allow material to enter drains or waterways.

E-R 4775/ K-17268
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