

# DuPont Marine Finishes Product Chart

Product	Components	Mix Ratio	VOC	Additives/Notes	Gun Setup & Fluid Delivery	Flash / Dry Times
Epoxy Fairing Compounds	DuPont™ 18545S™ Trowelable Fairing Compound DuPont™ 18145S™ Fairing Activator DuPont™ 18146S™ Fairing Activator - Cold Weather	1 Part Trowelable Fairing 1 Part Activator	0.9 1.4	Apply over cured and sanded DuPont™ 18545S™	Thorough mix evident only when positive color change appears. Do not apply beyond recommended pot life.	Pot life: 40-45 min. To Sand: 12-24 hrs. (thickness dependent) Full Cure: 3-5 days @ 95°F (35°C), 5-7 days @ 77°F (25°C), 10-12 days @ 55°F (13°C)
	DuPont™ 18550S™ Spray Fairing Compound DuPont™ 18150S™ Spray Fairing Activator DuPont™ 18750S™ Spray Fairing Reducer	1 Part Spray Fairing 1 Part Activator 5-10% Reducer	1.9	Do not apply directly to topcoats	Pressure: 2.2 to 2.8mm Siphon: 2.2 to 2.8mm Gravity: 2.2 to 2.88mm	Pot life: 2 hrs. @ 77°F (25°C) 5-10 mils per pass; 30 to 35 mils max. recommendation 5-6 hrs flash; dry to sand 6-8 hrs. Full cure: 3 days
Primers	DuPont™ Corlar® 18510S or 185413S™ Epoxy Primer DuPont™ Corlar® 18110S™ Epoxy Activator DuPont™ Corlar® 18710S™ VOC-Exempt Reducer	4 Parts Primer 1 Part Activator 1 Part Reducer or 4-1 as HB	2.8	Cold Weather Mix Ratio 4 Parts Primer 1 Part Activator 1/2 Part Reducer 1/2 Part 18810S™ Cold Weather Accelerator	Pressure: 1.2 to 1.6 mm Siphon: 1.4 to 1.8 mm Gravity: 1.4 to 1.8 mm 12-16 oz/min. Conventional: 50-60 psi HVLP: 25-30 psi	30 min induction; 4 hr. pot life 2 coats with 20 min. flash Dry to touch: 2-4 hrs. Dry to sand: 8-12 hrs. 2.5 - 4.0 DFT; max DFT 6.0 mils
	DuPont™ Corlar® 18515S™ High Build Epoxy Primer DuPont™ Corlar® 18115S™ Epoxy Activator DuPont™ Corlar® 18710S™ VOC-Exempt Reducer	2 Parts Primer 1 Part Activator ~10% Reducer	2.0	Material will not apply properly with a suction / siphon / gravity gun	Pressure: .110"/2.8mm 8-10 oz/min. Conventional: 50-60 psi	15 min. induction; 8 hr. pot life Apply full wet coat to achieve 5-7 mils WFT to a max 4 coats and 12-15 WFT Allow 15-30 min. flash between coats
	DuPont™ 18530S or 18532S™ Urethane Primer DuPont™ 18100S™ Activator	4 Parts Primer 1 Part Activator	2.8	2 oz DuPont™ 18820S™ per RTS gal.	Pressure: 1.0 to 1.4 mm Siphon: 1.0 to 1.4 mm Gravity: 1.2 to 1.5 mm 8-10 oz/min. HVLP: 25-30 psi	No induction; 2 hr pot life with 18820S™ Dry to touch: 30-45 min. with 18820S™ Dry to tape: 2-3 hrs. with 18820S™ 1 Cross Coat
	DuPont™ 18560S™ Alumistick Epoxy Primer DuPont™ 18160S™ Alumistick Activator	2 Parts Primer 1 Part Activator	0.1	DuPont™ 13813S™ up to 1 oz per RTS gal. Primer #3 13-15 seconds Surfacer #3 14-16 seconds	Pressure: 0.8 to 1.0mm Siphon: 1.9 to 2.1mm Gravity: 1.4 to 1.5mm 10-12 oz/min 8-10 psi at the cap	15 min. induction; 2 hr. pot life Air dry to rib sand: 30-60 min. Air dry to over-coat: 30-40 min. (1 coat) Air dry to over-coat: 50-60 min. (2 coats)
	DuPont™ Corlar® 18570S™ DTM Epoxy Primer DuPont™ Corlar® VFP34797™ Activator	1 Part Primer 1 Part Activator	2.1	DuPont™ 18750S™	Pressure: 1.2mm to 2.0mm	No induction: 8 hr. pot life when reduced with 18750S™ Dry to touch: 1-2 hr. @90°F (32°C) Dry to handle: 2 hr. @90°F (32°C) Full cure: 4 days @ 90°F (32°C)
Single-Stage Topcoat	DuPont™ Imron® MS600™ Topcoat DuPont™ 18100S™ Activator DuPont™ 187x5S™ Reducer	2 Parts Color 1 Part Activator 1 Part Reducer	3.5	2 oz DuPont™ 18820S™ per RTS gal. 1 oz 18801S™ or 18802S™ anti crater per RTS gal.	Pressure: 1.0 to 1.4 mm Siphon: 1.0 to 1.4 mm Gravity: 1.2 to 1.6 mm 10-12 oz/min. HVLP: 25-30 psi	No induction/4 hr Pot Life Apply med 1st coat 5-20 min flash 2nd wet cross-coat Dry to Touch 4-6 hr. To Tape overnight 72 hrs. cure before placed into limited service
	DuPont™ Imron® MS600™ EMBR Brush and Roll Topcoat DuPont™ 18101S™ Activator DuPont™ 18701S™ Reducer	4 Parts Color 1 Part Activator 1 Part Reducer	3.4	1 oz DuPont™ 18807S™ Accelerator per RTS gal. 2 oz DuPont™ 18820S™ per RTS gal. Can be used to improve dry time and lessen appearance/smoothness of finish	Apply 2 coats 1.5-2.0 mils WFT Allow to flash 16 hrs. between coats Recommended equipment: Corona urethane brushes Corona Glasskoter roller 1/8" nap	No Induction; 3 hr. pot life Dry to touch: 2-4 hrs. Dry to sand: Overnight Dry to tape: 24-36 hrs.
	DuPont™ Imron® MS100™ Basecoat DuPont™ 18105S™ Activator DuPont™ 18070S™ Reducer Check Viscosity 9-17 sec. Zahn #3 prior to adding Reducer	3 Part Color 1 Part Activator 1 Reducer (optional)	3.5	2 oz DuPont™ 18820S™ per RTS gal. (will reduce pot life by 50% improve dry times) 1 oz DuPont™ 8989S™ per RTS gal. (repairs only) 1 oz DuPont™ 18801S™ anti crater per RTS gal.	Pressure: 1.0 to 1.4 mm Siphon: 1.0 to 1.4 mm Gravity: 1.2 to 1.6 mm HVLP: 10-12 oz/min. 30-35 psi Conventional: 10-12 oz/min 50-60 psi	No induction; 2 hr. pot life 1 cross coat Allow to flash 30 min. before applying DuPont™ MS1™ clearcoat Dry to touch: 4 hr. Dry to tape: 8-12 hr.
Clearcoats	DuPont™ Imron® MS1™ Polyurethane Clearcoat DuPont™ 18100S™ Activator DuPont™ 187x5S™ Reducer	2 Parts Clearcoat 1 Part Activator 1 Part Reducer (optional)	3.4	2 oz 189S™ per RTS gal. to improve pot life / dry time 2 oz DuPont™ 18820S™ per RTS gal. to improve dry time 1 oz of DuPont™ 18802S™ anti crater per RTS gal. 1 oz of DuPont™ 13814S™ anti crater per RTS gal.	Pressure: 1.0 to 1.4 mm Siphon: 1.0 to 1.4 mm Gravity: 1.2 to 1.6 mm HVLP: 8-10 oz/min 25-30 psi Conventional: 8-10 oz/min 50-60 psi	No induction; 2 hr pot life no reducer Pot life: 2 hr. no reducer; 4 hr. with reducer For MS600™: flash 2 hrs then apply 2 coats w/ 30 min. flash between coats For MS1™: flash 5-30 min. then apply 2 coats w/ 30 min flash between coats Dry to touch: 4 hrs Dry to sand: 8 hrs
Cabin Finishes	DuPont™ 18320S™ Clear Polyurethane Filler-Sealer DuPont™ 18120S™ Activator DuPont™ 18122S™ Slow Urethane Activator (optional)	4 Parts Clear Sealer 1 Part Activator	4.8	None Recommended	Pressure: 1.2 to 1.6 mm Siphon: 1.2 to 1.6 mm Gravity: 1.2 to 1.6 mm Conventional: 10-12 oz/min. 50-60 psi HVLP: 10-12 oz/min. 25-30 psi	No Induction: 30 min. Pot Life: can be extended with 18775S™ medium reducer Recommend 3 coat process: 1 med coat, 3- 5 min flash, repeat for 2nd and 3rd coats
	DuPont™ 18321S™ Polyurethane Clearcoat DuPont™ 18120S™ Urethane Activator DuPont™ 18122S™ Activator - Slow (optional)	4 Parts Clearcoat 1 Part Activator	4.2	None Recommended	Pressure: 1.2 to 1.6 mm Siphon: 1.2 to 1.6 mm Gravity: 1.2 to 1.6 mm HVLP: 10-12 oz/min 25-30 psi Conventional: 10-12 oz/min 50-60 psi	No induction; 2 hr pot life Pot Life: can be extended with 18775S™ medium reducer Recommend 3 coat process: 1 med coat, 3- 5 min flash, repeat for 2nd and 3rd coats

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