



DuPont OEM/Fleet Finishes

TECHNICAL MANUAL

IMRON® 6000™ LOW VOC

POLYURETHANE ENAMEL

TYPE

A high performance, low VOC (<3.5 lbs/gal), two-component polyurethane basecoat enamel, for use with high solids polyurethane clearcoats.

DESCRIPTION

A high-hiding, high performance polyurethane basecoat enamel formulated to work with Imron® 6000 3440S™ Urethane Clear, Imron® 6000 3480S™ Low HAPS Clear or Imron® EZ-3460S™ Clearcoat. Imron® 6000™ is a high gloss, extremely durable, chemical and solvent resistant air dry system that is available in solid, metallic and pearl colors. Most basecoat colors can deliver hiding in one or two coats. It is also available in lead-free colors.

SUGGESTED USES

Imron® 6000™ is an extremely versatile product and is recommended for use on commercial trucks, fleet vehicles, and other applications where superior performance and/or superior appearance is required.

NOT RECOMMENDED FOR

- Immersion service.
- Use over lacquer finishes.

COMPATIBILITY WITH OTHER COATINGS

Compatible with all Dupont OEM/Fleet Primer systems.

DRY FILM CHARACTERISTICS*

- | | |
|-----------------------|-----------|
| ■ Chemical Resistance | EXCELLENT |
| ■ Humidity Resistance | EXCELLENT |
| ■ Weatherability | EXCELLENT |
| ■ Acid Resistance | EXCELLENT |
| ■ Alkali Resistance | EXCELLENT |
| ■ Solvent Resistance | EXCELLENT |
| ■ Abrasion Resistance | EXCELLENT |
| ■ Flexibility | EXCELLENT |

*With Imron® 3440S™, 3480S™ or EZ-3460S™ Clearcoat

MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service.

VOLUME SOLIDS – WILL VARY WITH COLOR SELECTED

- 48.0% average unactivated
- 53.5% average RTS mixed 3:1 with DuPont 193S™ or 194S™

WEIGHT SOLIDS – WILL VARY WITH COLOR SELECTED

- 61.0% average unactivated
- 64.4% average RTS mixed 3:1 with DuPont 193S™ or 194S™

WEIGHT PER GALLION

- 9.54 lbs/gal average unactivated

SUGGESTED DRY FILM THICKNESS

- Metallics & Pearls: 1.0-1.6 mils DFT
- Solid Colors: 0.7-1.3 mils DFT

THEORETICAL COVERAGE PER GALLON

- 858 sq ft/gal average @1mil DFT

GLOSS

- High

COLOR

- Available in solid, metallic, and pearl colors

FLASH POINT (CLOSED CUP)

- Below 80°F (27°C)

SHELF LIFE

- 12 months minimum

APPLICATION SOLVENTS

- Ready-to-spray below 3.5 lbs/gal VOC upon activation. Further reduction will result in greater than 3.5 lbs VOC.

CLEANUP SOLVENTS

- DuPont 3602S™ Thinner
- DuPont 8685S™ Reducer

IMRON[®] 6000[™] LOW VOC

POLYURETHANE ENAMEL

ACTIVATION (MIX RATIO)

- Add 3 parts Imron[®] 6000[™] 3.5 VOC Enamel with 1 part DuPont 193S[™] (or DuPont 194S[™] for reduced HAPS applications) and mix thoroughly. Filter material prior to spray application.
- Up to 2 oz/gal MasterTint[®] 389S[™] Accelerator should be added for improved pot life and dry time.
- 1 ounce MasterTint[®] 8989S[™] Super Fast Dry Accelerator may be added instead of MasterTint[®] 389S[™]. *Note: MasterTint[®] 8989S[™] will shorten pot life.*

INDUCTION TIME

- No induction time required.

POT LIFE

- 2 hours at 70°F (21°C)
- 2-4 hours at 70°F (21°C) with MasterTint[®] 389S[™]
- 45 minutes at 70°F (21°C) with MasterTint[®] 8989S[™]

ADDITIONAL COMMENTS

- Heating activated material above 110°F (43°C) is NOT recommended, as paint viscosity will increase rapidly.
- With plural component spray gun, unactivated paint may be heated to 135°F (57°C) to get 90°F (32°C) at the gun.
- Sanding is recommended for recoating if the basecoat is force dried or cured > 16 hours ambient.
- When striping, for improved tape time use up to 1 oz/gal of MasterTint[®] 8989S[™].

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) below the dew point. Relative humidity should be below 90%.

APPLICATION

- Pressure pot application is recommended for best color match and performance.
- For pressure pot application use 60-70 psi air pressure at the gun for all basecoat colors.
- For most colors, apply one cross-coat to achieve hiding. Some lead-free colors may require additional cross coats.
- Do not spray Imron[®] 6000[™] if the paint temperature is less than 75°F (24°C). Use warm water or paint

- heaters to heat the paint to an optimum temperature of 85-95°F (29-35°C). (In case of fish eyes, use DuPont 359S[™] Paint Additive to 1 ounce per ready-to-spray gallon of Imron[®] 6000[™] for solid colors; use 1 oz of DuPont VG-F-70050[™] for metallic colors. Do not use FEE.)
- Purge lines with DuPont 3602S[™] Thinner or DuPont 8685S[™] Reducer when changing colors or cleaning guns and equipment.

CURE TIME AT RECOMMENDED THICKNESS – 77°F (25°C) & 50% RH

| | Without Accelerator | w/MasterTint [®] 389S [™] | w/MasterTint [®] 8989S [™] |
|-------------------|---------------------|---|--|
| ■ Dry to Touch | 4-6 hours | 1-2 hours | 0.5-1 hour |
| ■ Tack Free | 10-12 hours | 2-4 hours | 1-2 hours |
| ■ Tape Free | 12-24 hours | 4-6 hours | 2-4 hours |
| ■ Dry to Assemble | 72 hours | 72 hours | 72 hours |

APPLICATION EQUIPMENT

- Air-Assisted Airless
- Gravity Feed Gun
- Pressure Pot
- Airless
- HVLP

ENVIRONMENTAL

- VOC content (lbs/gal)

| | | |
|--|-----------|-----------|
| Imron [®] 6000 [™] HL | <u>LE</u> | <u>AP</u> |
| | 3.9 | 3.9 |
| RTS mixed 3:1 w/ DuPont 193S [™] or 194S [™] | 3.5 | 3.5 |
- DuPont 194S[™] may be used for reduced HAPS applications.

FOR VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

SAFETY AND HANDLING

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling or using. These products are for industrial use by trained professional painters only.

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