



# IMRON<sup>®</sup> 2.8 PR<sup>®</sup> POLYURETHANE PRIMER

Imron<sup>®</sup> 2.8 PR<sup>™</sup> is a two-package, VOC conforming (2.8 lbs/gal) Low HAPS primer based on DuPont polyurethane technology. The resulting flexible primer delivers a smooth surface for maximum topcoat appearance.

### SUGGESTED USES

As a high performance primer or direct-to-metal (DTM) coating on properly prepared Carbon Steel, Galvanized Steel, or Aluminum, where:

- A sandable primer will produce a smooth surface for maximum topcoat appearance.
- Low VOC and low HAPS will reduce the environmental footprint.
- Outstanding flexibility is required.
- Application by brush and roller, in addition to spraying, may be necessary.
- Fast dry to recoat and handling times will improve productivity.

### NOT RECOMMENDED FOR:

- Immersion Service
- Highly Corrosive environments
- Marginally prepared surfaces

### COMPATIBILITY WITH OTHER COATINGS

Imron<sup>®</sup> 2.8 PR<sup>™</sup> can be topcoated with other DuPont Industrial Coatings including, but not limited to, Imron<sup>®</sup> 2.8 HG<sup>™</sup> polyurethane enamel, Imron<sup>®</sup> 1.2 HG<sup>™</sup>, Imron<sup>®</sup> 1.5 ST-D<sup>™</sup>, and Imron<sup>®</sup> 3.5 HG<sup>™</sup> high gloss and variable gloss polyurethane enamels. Imron<sup>®</sup> 2.8 PR<sup>™</sup> may be used over most aged and hard cured coatings in good condition. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact your DuPont Performance Coatings representative for specific recommendations. See Additional Comment #3.

### MAXIMUM SERVICE TEMPERATURE

250°F (121°C)

### PERFORMANCE PROPERTIES – WITH APPROPRIATE TOPCOAT

Adhesion	Excellent	Color & Gloss Retention	Excellent,
Solvent Resistance	Very Good		under appropriate topcoat
Chemical Resistance (Watch Glass)	Very Good	Salt Fog & Humidity	Excellent,
			under appropriate topcoat

### VOC (THEORETICAL)

VOC Less Exempt when activated 4:1 with FG-062 <sup>™</sup>	2.8 lbs./gal. average
HAPS (theoretical average) when activated 4:1 with FG-062 <sup>™</sup>	0.41 lbs./gal. of paint
	0.81 lbs./gal. solids
VOC Less Exempt when activated 4:1 with FG-062 <sup>™</sup> and with 2 oz MasterTint <sup>®</sup> 389S <sup>™</sup>	2.9 lbs./gal. average

### COLOR

62-1632 <sup>™</sup> White	62-1060 <sup>™</sup> ANSI 70 Gray	62-711 <sup>™</sup> Red Oxide
62- 705 <sup>™</sup> Buff	62-1072 <sup>™</sup> ANSI 61 Gray	62-1640 <sup>™</sup> Black

### GLOSS (ASTM D523):

Satin

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**IMRON<sup>0</sup> 2.8 PR<sup>0</sup>**  
Polyurethane Primer

**CURE TIME – HOURS @ 77°F (25°C), 50% RH @ SUGGESTED DFT\***

	w/2 oz MasterTint <sup>®</sup> 389S <sup>™</sup> Accelerator	without MasterTint <sup>®</sup> 389S <sup>™</sup> Accelerator
Dry to Touch	30 – 45 minutes	2 hours
Tack free	1 – 2 hours	5 – 6 hours
Thumb Print	2 – 3 hours	8 – 12 hours

Can be topcoated wet-on-wet with Imron<sup>®</sup> topcoats after a 15 – 20 minute flash.

\* See Additional Comment 1, 2

**THEORETICAL COVERAGE PER GALLON\***

818 ft<sup>2</sup> (20.0 m<sup>2</sup>/L) @ 1 mil DFT                      410 ft<sup>2</sup> (10.0 m<sup>2</sup>/L) @ 2 mils DFT

\*Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

**SUGGESTED FILM BUILD (PER COAT)**

3 – 4 mils (75 – 100 µm) dry (DFT)                      6 – 8 mils (150 – 200 µm) wet (WFT)

**VOLUME SOLIDS (MIXED):**

51% ± 2%, varies with color

**WEIGHT SOLIDS (MIXED):**

67% ± 2%, varies with color

**WEIGHT PER GALLON:**

10.6 lbs./gal ± 0.1, varies with color

**FLASH POINT (TAG CLOSED CUP)**

20 – 70°F (-7 to 23°C)

**PACKAGING**

Imron <sup>®</sup> 2.8 PR <sup>™</sup>		1 gallon (80% full)	5 gallons (4-gallon fill)
FG-062 <sup>™</sup> Activator	1 quart (80% full)	1 gallon (full)	

**SHIPPING WEIGHT (LBS) APPROXIMATE/AVG.**

62XXXX- 1 gallon container – 10                      5 gallon container – 48

**SHELF LIFE & STORAGE CONDITIONS**

- Store in a dry, well-ventilated area. Storage Temperatures should be between -30°F (-34°C) and 120°F (48°C).
- Shelf life – 1 year

**SAFETY INSTRUCTIONS**

Consult the Material Safety Data Sheet for this product prior to use.



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**APPLICATION INFORMATION**

**SURFACE PREPARATION**

For best results, all surfaces must be clean, dry and free of loose rust, oil, grease, and all other contamination. SSPC-SP-1 Solvent Cleaning should be done at a minimum. For best results, prepare surface to an SSPC-SP-6 Commercial Blast. Or sand with 220 grit sandpaper to roughen surface.

**ACTIVATION**

4 parts Imron<sup>®</sup> 2.8 PR<sup>™</sup> (62-XXXX<sup>™</sup>) to 1 part FG-062<sup>™</sup>

**POT LIFE @ 77°F (25°C)**

- 2 hours with 2 oz. MasterTint<sup>®</sup> 389S<sup>™</sup>.
- 1 hour without accelerator

**MIXING & REDUCTION**

1. Thoroughly mix 4 parts Imron<sup>®</sup> 2.8 PR<sup>™</sup> (62-XXXX<sup>™</sup>) primer base. To it add 1 part Imron<sup>®</sup> FG-062<sup>™</sup> Activator. Mix until all ingredients are uniform. No further reduction is required.
2. Can be accelerated with MasterTint<sup>®</sup> 389S<sup>™</sup>, 2 oz per RTS gallon.
3. No induction time is required.
4. When rolling, add 1 oz/mixed gallon of RT002P<sup>™</sup>

**APPLICATION THINNERS & ADDITIVES**

None required. Please see Mixing and Thinning Instructions .

**CLEANUP THINNERS**

Use DuPont Y32035<sup>™</sup>. Dispose of waste following local guidelines

**APPLICATION CONDITIONS**

Do not apply if the application surface or ambient temperature is below 50°F (10°C) or above 95°F (35°C), or if the atmospheric temperature is within 5°F of the dew point. Relative Humidity should be below 90%.

**APPLICATION EQUIPMENT**

- ◆ Apply by spray for best results. Imron<sup>®</sup> 2.8 PR<sup>™</sup> may also be applied by brush or roller with some sacrifice in appearance.
- ◆ Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

**ROLLER**

Wooster<sup>®</sup> Pro/Doo-Z<sup>®</sup>, ¼" – ½" nap

**BRUSH**

Wooster<sup>®</sup> China Bristle

**AIR SPRAY**

Manufacturer	DeVilbiss	Sata
Spray Gun	JGA	K3 RP
Fluid Tip	1.4 FF	1.1
Air Cap	777	
Pressure Pot		12 - 15 psi
Atomizing Air		36 psi

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### AIRLESS SPRAY

Manufacturer	Graco
Pump	Xtreme 33:1
Fluid Hose	3/8" X 100' Max.
Spray Gun	238591
Tip Size	.411-.611
PSI:	2400 psi min

### ADDITIONAL COMMENTS

1. To ensure optimum adhesion, Imron<sup>®</sup> 2.8 PR<sup>™</sup> should be topcoated within 72 hours. When allowed to sit for longer than 72 hours, Imron<sup>®</sup> 2.8 PR<sup>™</sup> must be sanded. If recoating Imron<sup>®</sup> 2.8 PR<sup>™</sup> with itself, sanding is also required if primer has been force dried or has been allowed to air dry more than 16 hours.
2. Product can be force dried 30 min at 130 -180°F.
3. Imron<sup>®</sup> 2.8 PR<sup>™</sup> **should not be topcoated** with epoxies. However, Imron<sup>®</sup> 2.8 PR<sup>™</sup> can be applied over epoxies such as Corlar<sup>®</sup> 3.2 PR<sup>™</sup>, Corlar<sup>®</sup> 2.1 ST<sup>™</sup>, Corlar<sup>®</sup> LV SG<sup>™</sup>, when additional corrosion protection is desired.
4. For optimum appearance, Imron<sup>®</sup> 2.8 PR<sup>™</sup> can be sanded using 320 grit sandpaper or finer.