**IMRON® 2.8 FT-C™**

**FLAT CLEAR POLYURETHANE**

(*formerly Imron® 613P™*)

Imron® 2.8 FT-C™ flat clear aliphatic polyurethane enamel is a high-solids, two-package, VOC conforming product (2.8 lbs./gal.) based on patented DuPont resin technology, producing properties of both polyester and acrylic polyurethanes. The resulting highly durable finish delivers industry leading polyurethane performance.

**SUGGESTED USES**

As a high performance clear topcoat over finishes in sound condition on steel, galvanized steel, stainless steel, aluminum, concrete, concrete block, fiberglass, plastics and wood where:
- Restoring faded finishes without gloss avoids the cost of complete re-painting.
- Outstanding color protection without gloss is desired.
- Resistance to chemical and/or marine environments is required.
- Application must be made at temperatures as low as 35° F.

**NOT RECOMMENDED FOR:**

Immersion Service

**COMPATIBILITY WITH OTHER COATINGS**

Imron® 2.8 FT-C™ can be applied over other DuPont Industrial Coatings including, but not limited to, Imron® solventborne polyurethanes, Imron® waterborne polyurethane copolymer coatings, Corlar™ epoxies, Tufcote® acrylics and Tufcote® alkyd primers. See Additional Comment #2 & 3.

Imron® 2.8 FT-C™ 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 Coating representative for specific recommendations.

**MAXIMUM SERVICE TEMPERATURE**

250°F (93°C) in continuous service.
300°F (148°C) in intermittent heat.

Some yellowing of light colors may occur at elevated temperatures.

**PERFORMANCE PROPERTIES***

<table>
<thead>
<tr>
<th>Property</th>
<th>Performance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Abrasion &amp; Mechanical Abuse</td>
<td>Excellent</td>
</tr>
<tr>
<td>Acids</td>
<td>Excellent</td>
</tr>
<tr>
<td>Color &amp; Gloss Retention</td>
<td>Excellent</td>
</tr>
<tr>
<td>Humidity</td>
<td>Very Good</td>
</tr>
<tr>
<td>Solvents</td>
<td>Very Good</td>
</tr>
<tr>
<td>Adhesion</td>
<td>Excellent</td>
</tr>
<tr>
<td>Alkalis</td>
<td>Excellent</td>
</tr>
<tr>
<td>Cutting Oil</td>
<td>Excellent</td>
</tr>
<tr>
<td>Salts</td>
<td>Excellent</td>
</tr>
<tr>
<td>Weather</td>
<td>Excellent</td>
</tr>
</tbody>
</table>

* For more information please see ASTM Information section.

**VOC (THEORETICAL)**

<table>
<thead>
<tr>
<th>Description</th>
<th>VOC (Theoretical)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mixed VOC, no reduction</td>
<td>2.8 lbs./gal. (336 g/l)</td>
</tr>
<tr>
<td>Mixed VOC, 3% reduction w/DuPont 68083™ or 2 oz. MasterTint® 389S™ Accelerator</td>
<td>3.0 lbs./gal. (360 g/l)</td>
</tr>
</tbody>
</table>

**COLOR**

Clear

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GLOSS (ASTM D523):

Gloss Adjustment Ratios
To achieve variable gloss ranges, the following chart can be used as a guide:

\[
\text{Imron}^\circledR 613P^\text{TM} + \text{Imron}^\circledR 611P^\text{TM} = \text{Approximate Gloss Range (@60°)}
\]

<table>
<thead>
<tr>
<th>Parts</th>
<th>1 part</th>
<th>2 parts</th>
<th>1.5 parts</th>
<th>1 part</th>
</tr>
</thead>
<tbody>
<tr>
<td>Parts</td>
<td>1 parts</td>
<td>1 parts</td>
<td>1.5 parts</td>
<td>2 parts</td>
</tr>
<tr>
<td></td>
<td>&lt;10</td>
<td>15-25</td>
<td>40-50</td>
<td>75-85</td>
</tr>
</tbody>
</table>

CURE TIME – HOURS @ 77°F (25°C), 50% R.H. @ 2.0-2.5 MILS SUGGESTED DFT

<table>
<thead>
<tr>
<th>Without Accelerator</th>
<th>MasterTint® 389S™</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry to Touch</td>
<td>4 – 6</td>
</tr>
<tr>
<td>Dry to Recat</td>
<td>10 – 12</td>
</tr>
<tr>
<td>Dry to Handle</td>
<td>10 – 12</td>
</tr>
<tr>
<td>Pack/Ship</td>
<td>24</td>
</tr>
<tr>
<td>Full Cure</td>
<td>7 days</td>
</tr>
<tr>
<td>Pot Life</td>
<td>1.5 – 2</td>
</tr>
</tbody>
</table>

THEORETICAL COVERAGE PER GALLON*

834 ft² (20.5 m²/L) @ 1 mil
417 ft² (10.2 m²/L) @ suggested DFT of 2 mils

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

SUGGESTED FILM BUILD

3 – 4 mils (75 – 100 µm) wet (WFT)
1.5 – 2 mils (37 – 50 µm) dry (DFT)

VOLUME SOLIDS (MIXED):

52% ± 2%

WEIGHT SOLIDS (MIXED):

62% ± 2%

WEIGHT PER GALLON (MIXED):

8.85 lbs. (4.014 kg) ± .2

FLASH POINT (TAG CLOSED CUP)

Between 20 to 73°F (-7 to 23°C) Mixed

PACKAGING

Enamel: 1’s (75% full)  Activator: Quarts (full)

SHIPPING WEIGHT (LBS) APPROXIMATE/AVG.

Enamel: 1 gallon container – 8  Activator: 1 quart container – 3

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 minimum
- Rotate stock and invert cans every 30 days to prevent hard settling. If settling occurs, reincorporate by manually breaking up the solids and shaking or power mixing for 30 minutes.

SAFETY INSTRUCTIONS

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

SURFACE PREPARATION
Newly primed surfaces should be clean and dry. If contaminated, detergent/water wash, then blow dry. Previously painted surfaces should have all loose paint removed and the edges feathered. Prime bare spots with appropriate primer. See Additional Comments #3.

ACTIVATION
Thoroughly mix 3 parts Imron® 2.8 FT-C™ (613P™) Enamel, then add 1 part Imron® VGY-611™ Activator while stirring. No induction period is necessary. Note: Enamel is short-filled to allow for addition of activator. Do not shake. If air bubbles are excessive as a result of stirring, agitating or boxing the base material, allow the bubbles to dissipate prior to activation.

POT LIFE
1.5 – 2 hours @ 77°F and 50% RH. Higher temperatures and humidity will severely shorten pot life.

REDUCTION
Normally 0-3% (1-4 oz.) reduction is adequate for spray application depending upon conditions and equipment. Maximum reduction should not exceed 3%. Use DuPont 68083™ Thinner. If faster recoat and handling is required, add up to 2 oz./gal MasterTint® 389S™ Accelerator.

APPLICATION THINNERS & ADDITIVES
Spray: DuPont 68083™
Acceleration: MasterTint® 389S™
Brush & Roll: Not recommended due to uneven appearance.

CLEANUP THINNERS
DuPont 68083™ or MEK

APPLICATION CONDITIONS
This product is best applied by spray. Do not apply if the application surface temperature is below 45°F (7°C) or above 110°F (43°C), or if the atmospheric temperature is within 5°F of the dew point. For best results, application temperature should be between 65°F and 85°F. Relative Humidity should be below 90%. For application temperatures below 45°F, the use of MasterTint® 389S™ Accelerator is required. Mix only amounts that can be applied within a 1.5 – 2 hour period. For airless spray application, tip size must not exceed .011”.

APPLICATION EQUIPMENT
♦ Apply by spray only.
♦ Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

AIR SPRAY
Manufacturer DeVilbiss
Spray Gun JGA
Fluid Tip 1.4 mm
Fluid Needle 402-FF
Air Cap 777

AIRLESS SPRAY
Manufacturer Graco
Pump Xtreme 33:1
Filter 60 Mesh
Fluid Hose 3/8” X 100’ Max.
Spray Gun 238591
Tip Size .411-.611
### AIR ASSISTED AIRLESS

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Graco</th>
</tr>
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<tbody>
<tr>
<td>Pump</td>
<td>Senator 12:1</td>
</tr>
<tr>
<td>Spray Gun</td>
<td>217292</td>
</tr>
<tr>
<td>Tip Size</td>
<td>.023 - .029</td>
</tr>
<tr>
<td>Fluid Hose</td>
<td>3/8” X 50’ Max.</td>
</tr>
</tbody>
</table>

### HVLP

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>DeVilbiss</th>
</tr>
</thead>
<tbody>
<tr>
<td>Spray Gun</td>
<td>GTI</td>
</tr>
<tr>
<td>Tip Size</td>
<td>1.4 mm</td>
</tr>
<tr>
<td>Air Pressure</td>
<td>10 psi @ air cap</td>
</tr>
<tr>
<td>Fluid Hose</td>
<td>3/8” X 60’ Max.</td>
</tr>
<tr>
<td>Fluid Delivery</td>
<td>10 – 12 oz</td>
</tr>
</tbody>
</table>

### ADDITIONAL COMMENTS

1. May be recoated by spray when tack-free.
2. For best results when applying Imron® 2.8 FT-C™ over itself or over other Imron® product, the clear should be applied within 72 hours @ 77°F. If more than 72 hours has elapsed, the surface should be scuffed with very fine (400-600 grit) sand paper before applying the Imron® 2.8 FT-C™.
3. If accelerators have been used, recoating must be done within 48 hours. If more time has elapsed, scuff sand to ensure adhesion.