Description:

DuPont Imron® Industrial Strength is the next generation of Imron® technology. Based upon unique DuPont formulations and resin technology, Imron® Industrial Strength is the fastest Imron® yet, providing the “Wet Look that Lasts” with the lowest environmental impact. Imron® Industrial Strength qualities Semi Gloss (GO), Satin Gloss (GP) and Flat (GQ) are reduced gloss, 0.3 lbs/gal VOC conforming, low HAPS, polyurethane topcoats. The resulting finish product provides a brush, roll or sprayable topcoat suitable for use in any environment where long term color and variable gloss are desired.

* See section on VOC (page 2).

Suggested Uses:

As a high performance, tough, industrial strength semi gloss polyurethane topcoat over properly prepared and primed aluminum, carbon steel, galvanized, concrete or dry wall where:

- Outstanding color protection with reduced gloss is required
- Very good skydrol resistance is needed
- Low environmental footprint is desired
- Outstanding flexibility is needed
- Application by brush, roll or spray is desired
- Faster dry times are desired
- Excellent chemical resistance
- In-field color shading is needed
- Excellent chemical resistance

Not recommended for: Immersion service

COMPATIBILITY WITH OTHER COATINGS

- Aged Imron® Industrial Strength may be re-coated with itself following washing with clean, fresh water – no mechanical surface preparation is required.
- Imron® Industrial Strength can be applied over other DuPont Industrial Coatings including, but not limited to Imron® Industrial Strength Primers, Imron® Waterborne Polyurethane Copolymer coatings, Corlar® epoxies, Tufcote® acrylics, and Tufcote® alkyd primers.
- Imron® Industrial Strength 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.

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>Abrasion &amp; Mechanical</th>
<th>Excellent</th>
<th>Color &amp; Gloss Retention</th>
<th>Excellent</th>
</tr>
</thead>
<tbody>
<tr>
<td>Alkalis</td>
<td>Excellent</td>
<td>Acids</td>
<td>Excellent</td>
</tr>
<tr>
<td>Humidity</td>
<td>Excellent</td>
<td>Salts</td>
<td>Excellent</td>
</tr>
<tr>
<td>Solvents</td>
<td>Very Good</td>
<td>Weather</td>
<td>Excellent</td>
</tr>
</tbody>
</table>
VOC (Theoretical less water and exempt compounds).

This product contains TBAc.

<table>
<thead>
<tr>
<th>Without 2 oz VG-805™</th>
<th>8 to 1 25% Reduction</th>
<th>With 2 oz VG-805™</th>
<th>8 to 1 25% Reduction</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>TBAc Exempt</strong></td>
<td><strong>TBAc Non-Exempt</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>No Reduction</td>
<td>No Reduction</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>9M01™</strong></td>
<td>0.3</td>
<td><strong>9M02™</strong></td>
<td>2.3</td>
</tr>
<tr>
<td>0.4</td>
<td>2.4</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.0</td>
<td>2.9</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Where TBAc is considered an exempt solvent for contains requirements.

**HAPS Information – Theoretical**

Imron® Industrial Strength – Mixed 8 to 1 no reduction – 0.01 lbs/gal solids

Imron® Industrial Strength – Mixed 8 to 1 with 25% Imron® 9M01™ or 9M02™ Thinner and 2 oz. VG-805™

Accelerator – 0.01 lbs/gal solids

**COLOR**

Imron® Industrial Strength is mainly a mix system, utilizing balanced factory packaged colors, 9TXX colors and 9T20™ Flattener. These colors can then be used by themselves as topcoats or in combination with other colors to make thousands of mixed colors. To make Industrial Strength, GO, GP, GQ mix quality, obtain a mix quality formula from DuPont ColorNet®. Note: Reduced gloss color mix formulas shall be full gallons only, then activated 8 to 1 with 9T00-A™ Activator.

**Color Availability:**

- 9T01™ – White
- 9T02™ – Black (match to 1640)
- 9T03™ – Yellow
- 9T04™ – Violet
- 9T05™ – Yellow Orange Shade
- 9T06™ – Red Orange Shade
- 9T07™ – Blue Green Shade
- 9T08™ – Yellow Oxide
- 9T09™ – Green
- 9T10™ – Red
- 9T11™ – White (match to 1632)
- 9T12™ – Red Oxide
- 9T13™ – Orange
- 9T14™ – Transparent Red
- 9T15™ – Magenta
- 9T16™ – Violet-Blue Shade
- 9T17™ – Blue-Red Shade
- 9T20™ Flattener

**Gloss**

@ 60º angles  –   Semi = 50-65º  Satin = 25-45º  Flat = 0 - 10º

**Weight Solids – Average varies with color**

68% +/- 2%

**Weight per gallon – Average varies with color**

8.9 – 10.5 lbs

**Volume Solids -- Average varies with color**

62% +/- 2%

**Flash Point**

Between 73º to 100ºF (23º to 38ºC)

**Packaging for reduced gloss colors**

- 17 Factory packaged colors – 9TXX – 1 gallon container 80% Full (102.4 oz.)
- 9T20™ Flattener – 1 gallon container 100% Full (128 oz.)
- Activator – 9T00-A™ – pint container 100% Full (16 oz.)

**Shipping Weight – lbs – approximate**

1 Gallon container: 10-12 lbs depending upon color

Pint Activator: 1-2 lbs

**SHELF LIFE & STORAGE CONDITIONS**

Store in a dry, well-ventilated area. Storage conditions should be between 35ºF (2ºC) and 120ºF (48ºC)

- Shelf Life: 1 year minimum.
SAFETY
Consult the Material Safety Data Sheet for this product prior to use. Imron® Industrial Strength products are intended for professional use only.

Cure Times – hours @ 2.0 to 3.0 mils suggested DFT

<table>
<thead>
<tr>
<th></th>
<th>@ 77°F, 50% RH</th>
<th>@ 90°F (32°C) &lt; 25% RH</th>
</tr>
</thead>
<tbody>
<tr>
<td>20%-9M01 Reducer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>With VG-805™</td>
<td>3</td>
<td>1</td>
</tr>
<tr>
<td>With 2 ozs VG-805™</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>20%-9M01 Reducer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>With 2 ozs VG-805™</td>
<td>2</td>
<td>1</td>
</tr>
<tr>
<td>20%-9M02 Reducer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Without VG-805™</td>
<td>4</td>
<td>3</td>
</tr>
<tr>
<td>With VG-805™</td>
<td>12</td>
<td>16</td>
</tr>
<tr>
<td>20%-9M02 Reducer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Without VG-805™</td>
<td>4</td>
<td>3</td>
</tr>
<tr>
<td>With VG-805™</td>
<td>12</td>
<td>16</td>
</tr>
<tr>
<td>To Touch</td>
<td>18</td>
<td>10</td>
</tr>
<tr>
<td>Tack Free</td>
<td>18</td>
<td>10</td>
</tr>
<tr>
<td>To Handle</td>
<td>18</td>
<td>10</td>
</tr>
<tr>
<td>To Recoat</td>
<td>18</td>
<td>10</td>
</tr>
<tr>
<td>Hard Dry</td>
<td>18</td>
<td>10</td>
</tr>
<tr>
<td>Pot Life</td>
<td>18</td>
<td>10</td>
</tr>
<tr>
<td>Full Cure</td>
<td>7 days</td>
<td>7 days</td>
</tr>
<tr>
<td></td>
<td>6 days</td>
<td>6 days</td>
</tr>
</tbody>
</table>

Theoretical Coverage Per Gallon
994 ft² (24.3 m²/l) @ 1 mil dft
497 ft² (12.1 m²/l) @ 2 mil dft
Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Suggested Film Builds
3-5 mils (75-125 µm) wet
2-3 mils (50 – 75 µm) dry
Application by brush and roller may require additional coats to achieve recommended films thickness.

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.

Activation
Thoroughly mix all colored portions until uniform. To 8 parts 9TXX base, add one part DuPont Imron® 9T00-A™ Activator. If using a mix formula, follow specific color formula for color desired. Measure out appropriate amounts, add activator and mix thoroughly. For most applications, add 5 – 15% Imron® 9M01™ or 9M02™ Thinner reducer depending upon application conditions and methods. Mix until uniform. (See reduction section below.) Mix thoroughly using a mechanically powered sheer “Jiffy” mixer with variable RPM settings; use medium speed RPM. Move mixer up and down through paint for uniform mixing. DO NOT SHAKE. Note: Reduced gloss color mix formulas shall be full gallons only, then activated 8 to 1 with 9T00-A™ Activator.

Reduction
Normally 5-15% reduction with Imron® 9M01™ or 9M02™ Reducer is adequate for spray application, pressure pot and airless, depending upon conditions and equipment. To help maximize pot life, up to 25% may be added. For maximum appearance, up to 25% Imron® 9M01™ or 9M02™ may be added. For brush applications, add 5-10% 9M01™ or 9M02™ Thinner. For rolling applications, add 1 oz of Imron® 9M05™ Rolling Additive per activated gallon and 5-10% 9M01™ or 9M02™ Reducer. After addition of 9M05™ Rolling Additive, allow 5 minutes induction before application. If faster recoat and handling are required, add up to 2 oz. VG-805™ Accelerator. If accelerators have been used, recoating must be done within 48 hours. If more time has elapsed,
scuff sand to ensure adhesion. Use of 9M02™ Pot Life Extender / Reducer will affect VOC. Please see VOC section. Use only recommended reduction solvents.

**Application Thinners**

- Spray, Brush and Roll – Below 80°F: Imron® 9M01™
- Spray, Brush and Roll – Above 80°F: Imron® 9M02™

**Clean Up Thinners**

- Imron® 9M01™, T-1021

**Application Conditions**

Do not apply if the application surface temperature is below 45°F (7ºC) or above 110°F (43ºC), or if the atmospheric temperature is within 5ºF of the dew point. For application temperatures below 45°F, the use of 2 oz. Imron® VHY-691™ is recommended. Relative humidity should be below 90%.

**Application Equipment**

- Apply by spray, brush or roll
- Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

**Roll**

- Manufacturer: Wooster® Pro/Doo-Z™ ¼” – ½” nap
- Additions:
  - Add 1 oz./gallon Imron® 9M05™ Rolling Additive to eliminate bubbles. Craters may develop if you exceed 2 oz./gallon.
  - Add 5-10% Imron® 9M01™ or 9M02™ reducer to maintain wet edge.
  - May be cross-rolled.
  - For best results, allow 5 minutes mix time after adding Imron® 9M05™.

**Brush**

- Manufacturer: Wooster® China Bristle
- Additions:
  - Add 5-10% Imron® 9M01™ or 9M02 reducer to maintain wet edge. Do not cross brush to reduce lap marks.

**Spray**

- Additions:
  - May be recoated by spray when tack-free.
  - Imron® 9M05™ is not recommended for spray application.

**Conventional**

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Sata</th>
<th>DeVilbiss</th>
<th>Graco</th>
<th>Iwata</th>
<th>Binks</th>
<th>Kremlin</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model</td>
<td>K3 or K3 RP</td>
<td>JGA or MBC</td>
<td>DeltaSpray XT</td>
<td>W-77, W-71, or W-200</td>
<td>2001 or 95</td>
<td>M22HPAP</td>
</tr>
<tr>
<td>Tip Size</td>
<td>1.0 – 1.3 mm</td>
<td>1.1 - 1.4 mm</td>
<td>1.0 - 1.5 mm</td>
<td>1.2 – 1.8 mm</td>
<td>1.2 – 1.8 mm</td>
<td>1.2 – 1.8 mm</td>
</tr>
</tbody>
</table>

*Fluid lines 3/8” ID or larger are required for proper fluid delivery.

**HVLP Spray**

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Sata</th>
<th>DeVilbiss</th>
<th>Graco</th>
<th>Iwata</th>
<th>Binks</th>
<th>Kremlin</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model</td>
<td>3000RP</td>
<td>JGHV, EXL, or FLG</td>
<td>DeltaSpray XT</td>
<td>LPH 200 LVLP</td>
<td>MACH 1 &amp; 1SL</td>
<td>E3K HVLP</td>
</tr>
<tr>
<td>Tip Size</td>
<td>1.2 – 1.6 mm</td>
<td>1.3 - 1.8 mm</td>
<td>1.3 – 2.2 mm</td>
<td>0.8 – 1.2 mm</td>
<td>1.0 – 1.7 mm</td>
<td>1.5 – 1.8 mm</td>
</tr>
</tbody>
</table>

**Airless Spray**

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Graco</th>
<th>Iwata</th>
<th>Binks</th>
<th>Kremlin</th>
</tr>
</thead>
<tbody>
<tr>
<td>Model</td>
<td>Silver or Plus</td>
<td>ALG or Airlesso</td>
<td>Airless 1</td>
<td>Airless 250 II</td>
</tr>
<tr>
<td>Tip Size</td>
<td>.011 - .015</td>
<td>.011 - .015</td>
<td>.011 - .017</td>
<td>.013 - .017</td>
</tr>
<tr>
<td>Pump</td>
<td>30:1 min</td>
<td>ALG 30:1 min</td>
<td>30:1 min</td>
<td>Orca 32:1</td>
</tr>
</tbody>
</table>

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