



# IMRON<sup>®</sup> 2.8 FT-C<sup>™</sup>

## FLAT CLEAR POLYURETHANE

(formerly Imron<sup>®</sup> 613P<sup>™</sup>)

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

Imron<sup>®</sup> 2.8 FT-C<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 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\*

Abrasion & Mechanical Abuse	Excellent	Adhesion	Excellent
Acids	Excellent	Alkalis	Excellent
Color & Gloss Retention	Excellent	Cutting Oil	Excellent
Humidity	Very Good	Salts	Excellent
Solvents	Very Good	Weather	Excellent

\* For more information please see ASTM Information section.

### VOC (THEORETICAL)

Mixed VOC, no reduction	2.8 lbs./gal. (336 g/l)
Mixed VOC, 3% reduction w/DuPont 68083 <sup>™</sup> or 2 oz. VG-805 <sup>™</sup> Accelerator	3.0 lbs./gal. (360 g/l)

### COLOR

Clear

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## **IMRON® 2.8 FT-C™** Flat Clear Polyurethane (formerly Imron® 613P™)

### **GLOSS (ASTM D523):**

Gloss Adjustment Ratios

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

Imron® 613P™ + Imron® 611P™ = Approximate Gloss Range (@60°)		
1 part	--	<10
2 parts	1 parts	15-25
1.5 parts	1.5 parts	40-50
1 part	2 parts	75-85

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

	Without Accelerator	Hours with 2 oz VG-805™ Accelerator
Dry to Touch	4 – 6	1
Dry to Recoat	10 – 12	1.5
Dry To Handle	10 – 12	2.5
Pack/Ship	24	5 – 6
Full Cure	7 days	5 days
Pot Life	1.5 – 2	3

### **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.



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### 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 VG-805™ Accelerator.

#### APPLICATION THINNERS & ADDITIVES

Spray: DuPont 68083™  
Acceleration: VG-805™ Accelerator  
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 VG-805™ 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.

#### CONVENTIONAL SPRAY

Manufacturer Model	Sata K3 or K3 RP	DeVilbiss JGA or MBC	Graco DeltaSpray XT	Iwata W-77, W-71, or W-200	Binks 2001 or 95	Kremlin M22HPAP
Tip Size	1.0 – 1.3 mm	1.1–1.4mm	1.0-1.5 mm	1.2-1.8 mm	1.2-1.8 mm	1.2-1.8 mm

#### HVLP SPRAY

Manufacturer Model	Sata 3000RP HVLP	DeVilbiss JGHV, EXL, or FLG	Graco DeltaSpray XT - HVLP	Iwata LPH 200 LVLP	Binks MACH 1 & 1SL	Kremlin E3K HVLP
Tip Size	1.2 – 1.6 mm	1.3–1.8mm	1.3-2.2 mm	0.8-1.2 mm	1.0-1.7 mm	1.5-1.8 mm



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### **AIRLESS SPRAY**

<b>Manufacturer</b>	<b>Graco</b>	<b>Iwata</b>	<b>Binks</b>	<b>Sata</b>
<b>Model</b>	Silver or Plus	ALG or Airlessso	Airless 1	Airless 250 II
<b>Tip Size</b>	.011 - .015	.011 - .015	.011 - .017	.013 - .017
<b>Pump</b>	30:1 min	ALG 30:1 min	30:1 min	Orca 32:1 pump

### **AIR ASSISTED AIRLESS SPRAY**

<b>Manufacturer</b>	<b>Graco</b>		<b>Sata</b>	<b>Iwata</b>	<b>Kremlin</b>	<b>Binks</b>
<b>Model</b>	AA4000 HVLP, AA10HP Cap	Alpha or Alpha Plus	Shark 32:1 or Dolphin 14:1, K3 spray mix	MSG 2000 Gun MSU11 13:1 or MSU32 17:1	Airmix MVX	AA 1500
<b>Tip Size</b>	.021 - .027	.015 - .021	.011-.018	.011 - .018	.011 - .020	.013 - .019

### **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.