

DuPont™ Imron® 500S™ Clear Coat

Type

Two-component, 5.0 VOC, polyurethane clear coat.

Description

A high-performance clear coat that delivers a very durable finish.

Suggested Uses

Designed for overall repairs.

Recommended For Use Over

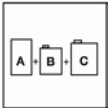
DuPont™ Imron® 5.0 topcoat

Not Recommended For

Immersion service or over alkyd enamels, acrylic enamels or lacquer finishes.

Dry Film Characteristics

Chemical Resistance	EXCELLENT
Humidity Resistance	EXCELLENT
Weatherability	EXCELLENT
Acid Resistance	EXCELLENT
Alkali Resistance	EXCELLENT
Solvent Resistance	VERY GOOD
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT



Mix Ratio

Stir DuPont™ Imron® 500S™ thoroughly prior to activation. Combine components and mix thoroughly. Filter material prior to spray application.

Two Component System	Parts by Volume
DuPont™ Imron® 500S™ Clear Coat	3
DuPont™ V-192S™ Activator	1

Add up to 4 oz. of DuPont™ 189S™ Accelerator to activated gallon to improve dry time.
Initial application viscosity: 18 – 22 seconds with #2 Zahn Cup.

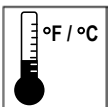


Pot Life and Induction Time

No induction time is required. Pot life is 8 hrs at 70°F (21°C); 4 hrs at 70°F (21°C) with 4 oz. DuPont™ 189S™ Accelerator.

Additional Comments

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel. Non-photochemically reactive.

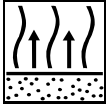


Application Conditions

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) above the dew point. Relative humidity should be below 90%.

Application

- DuPont™ Imron® 500S™ can be applied wet-on-wet on solid colors, and on metallic colors after drying overnight.
- Spray one medium-wet coat and allow to tack. Follow with a full second coat.
- Avoid heavy film build with DuPont™ Imron® 500S™ as the finish may crack or lose adhesion upon exposure to outdoor elements.
- In hot conditions, add up to 10% by volume DuPont™ 8100S™ Retarder.
- In case of fish eyes, add up to 1 oz. / gal. DuPont™ Imron® 259S™ Additive. Do not use FEE.



Dry Time

77°F (25°C) & 50% Rh at recommended film thickness

Without DuPont™ 189S™		With DuPont™ 189S™	
Dry to touch	2 hrs	Dust Free	0.5-1 hr
Tack free	2-3 hrs	Tack Free	1-2 hrs
Tape free	6-10 hrs	Tape Free	2-4 hrs
Dry to assemble	72 hours	Dry to Assemble	72 hours

Product may be force dried 30 min at 140-160°F (60-71°C).



Application Equipment

Pressure Pot
Air Assisted Airless
Gravity Feed Gun
Suction Spray
HVLP

Maximum Service Temperature

200°F (92°C) in continuous service

300°F (148°C) in intermittent heat

Volume Solids

27.2% unactivated

27.2% RTS mixed 3:1 with DuPont™ V-192S™ Activator

Weight Solids

31.6% unactivated

32.2% RTS mixed 3:1 with DuPont™ V-192S™ Activator

Weight Per Gallon

8.25 lbs/gal average unactivated

Suggested Dry Film Thickness

1.5 – 2.0 mils

Theoretical Coverage Per Gallon

436 sq. ft./gal average @ 1 mil DFT mixed 3:1 w/ DuPont™ V-192S™ Activator

Gloss

High

Color

Clear

Flash Point (Closed Cup)

Below 80°F (27°C)

Shelf Life

12 months minimum

Application Solvents

DuPont™ 8485S™ Reducer

DuPont™ 8100S™ Retarder

**Cleanup Solvents**

DuPont™ 3602S™ Thinner

DuPont™ Imron® 8685S™ Thinner

Environmental

VOC content (lbs/gal)

LE AP

DuPont™ Imron® 500S Clear Coat

4.9 3.5

Mixed 3:1 with DuPont™ V-192S™ Activator

5.0 4.0

For VOC Regulated Areas

These directions refer to the use of products that 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 and using. These products are for industrial use by trained professional painters only.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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