

# IMRON<sup>®</sup> 700

## POLYURETHANE ENAMEL

### Description

2-component topcoat system designed for application on trucks, buses and light commercial vehicles.

Composition based on functional polyurethane.

### Products

AM	Centari <sup>®</sup> MasterTint <sup>®</sup>
AU170	Polyurethane Binder
AU270	Polyurethane Activator
256S	Activator Fast
AU370	Polyurethane Thinner

### Properties

- Imron<sup>®</sup> 700 offers easy application on large surfaces with perfect flow and overspray melt-in, fast set up and dry to assemble times.
- Has excellent mechanical, chemical and weather resistance.
- Can be used for spot, panel and overall repair.


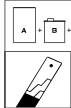








### Substrates

- all OEM finishes and DuPont primers

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### PRODUCT PREPARATION

	<b>Colour tools</b>	See colour formula.					
	<b>Mixing ratio</b>	Imron <sup>®</sup> 700 AU270 256S AU370	<b>Standard</b>		<b>Fast</b>		
			4	4			
			1	/			
			/	1			
		0.5-1	0.5-1				
	<b>VOC</b>	530-585 g/li					
	<b>Pot life at 20°C</b>	4 h					
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	16-17 s				
		<b>FORD 4</b>	16-17 s				
		<b>AFNOR 4</b>	18-20 s				
	<b>Spray equipment</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b> <b>Airless</b>	<b>Fluid tip</b>		<b>Spray distance</b>		
			1.2-1.4 mm	20-25 cm			
			1.6-1.8 mm	20-25 cm			
			1.3-1.5 mm	10-15 cm			
			1.0-1.2 mm	20-25 cm			
			0.011"/65°-85°	20-25 cm			
	<b>Spray pressure</b>	<b>Gravity feed</b>	3-4 bar				
		<b>Suction feed</b>	3-4 bar				
		<b>HVLP</b>	0.7 bar at nozzle				
		<b>Pressure feed</b>	4-6 bar				
		<b>Airless</b>	160-180 bar				
	<b>Number of coats</b>	2					
	<b>Flash time</b>	10 min. between coats. 10 min. before bake.					
	<b>DFT</b>	50-60 μ					
	<b>Drying</b>	<b>Dust-free</b> <b>Dry to handle</b> <b>Tape-free</b>	<b>AU270</b>		<b>256S</b>		
			<b>20°C</b>	<b>30 min. x 60°C</b>	<b>20°C</b>	<b>20 min. x 60°C</b>	
			30 min.	imm.	25 min.	imm.	
			4 h	imm.	4 h	imm.	
	12 h	1 h	12 h	1 h			
	<b>IR drying*</b>	Flash time	10 min. * guideline for short/medium wave IR equipment				
		Distance	80 cm				
		Half power	5 min.				
		Full power	15-20 min.				
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.							

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## POLYURETHANE ENAMEL

### RECOMMENDED USE

#### Surface preparation

1. Clean surface with water and soap.
2. Degrease with 3919S. Wipe dry with clean cloth.
3. Repair according to damage.
4. Sand:  
dry mechanical P320 - P360;  
wet P800 - P1000.
5. Degrease with 3920S.
6. Wipe dry and tack rag.

#### Topcoat application

On well prepared surface, apply 2 full coats with 10 min. flash between coats.

#### Chemical resistance

When fully cured, Imron<sup>®</sup> 700 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol
nitric acid	20 %	gasoline
citric acid	10 %	

#### Equipment cleaning

Use 3608S.

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### RECOMMENDED USE (con'd)

#### Recoatability

At any time after tape-free time:

- without sanding before 24 h;
- with sanding after 24 h.

#### Product data

Theoretical coverage: 6-7 m<sup>2</sup>/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
AM1x Centari <sup>®</sup> MasterTint <sup>®</sup>	1	2
AM94 Centari <sup>®</sup> MasterTint <sup>®</sup>	1	2
AM95 Centari <sup>®</sup> MasterTint <sup>®</sup>	1	2
AM7xx Centari <sup>®</sup> MasterTint <sup>®</sup>	1	3
AMxx Centari <sup>®</sup> MasterTint <sup>®</sup>	1 - 4	4
AU170	4 - 20	2
AU270	5	2
256S	1 - 5	2
AU370	1 - 5	2

#### Remarks

- Centari<sup>®</sup> MasterTints<sup>®</sup> have to be thoroughly mixed before weigh-out and the Imron<sup>®</sup> 700 colour has to be mixed immediately after weigh-out.
- Close can of AU270 and 256S tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- For structured and/or flat colours, see specific TDS.
- Material has to be at room temperature (18-20°C) before use.

#### Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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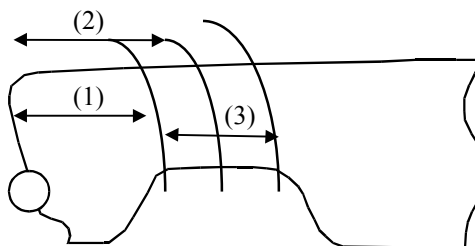
### REPAIR SYSTEMS

#### Spot repair

1. Clean surface with water and soap.
2. Degrease with 3919S and wipe dry with clean cloth.
3. Repair with recommended undercoats.
4. Sand primed spots as recommended.
5. Prepare complete blending area an ultra fine sanding pad or with 600S.
6. Degrease with 3920S.
7. Wipe dry and tack rag.
8. The following spot repair method can be used:
  - AK350 Centari<sup>®</sup> Blending Thinner method.

#### AK350 Centari<sup>®</sup> Blending Thinner method

- ① Apply 1<sup>st</sup> coat Imron<sup>®</sup> 700.  
Flash time: 10 min.
- ② Extend 2<sup>nd</sup> coat Imron<sup>®</sup> 700  
beyond the previous one.
- ③ Blend in the fade-out area with AK350.



OPTIONAL: dilute the remaining part Imron<sup>®</sup> 700 with 1 part AK350 after 2<sup>nd</sup> coat and apply 1 coat of this mixture extending in the blending area, before blending in the fade-out area with pure AK350.

If necessary, balance out the gloss level by polishing with 1500S or 3000S after complete hardening of the repair.