

IMRON[®] 7035

3.5 VOC P.U. TOPCOAT

Description

Ultra high solids 2-component topcoat system for solid colours for use on buses and trucks. Composition based on a unique, patented "star" polymer technology.

Products

AM	Centari [®] MasterTint [®]
ZU138	Imron [®] 7035 P.U. Binder
ZU207	Imron [®] 7035 Low VOC Activator
ZU338	Imron [®] 7035 Low Emission Additive
XK205	Low Emission Activator

Properties

- Imron[®] 7035 gives excellent appearance, a high gloss finish, very good hiding and low consumption.
- Can be used for spot, panel and overall repair.


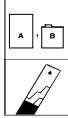







Substrates

- all OEM finishes and DuPont primers

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PRODUCT PREPARATION

	Colour tools	See colour formula. Amount of ZU338 is mentioned on the colour tools.		
	Mixing ratio	Imron [®] 7035 XK205 (spot/panel) ZU207	Fast	Standard
			3 1 /	3 / 1
	VOC	maximum 420 g/li (*)		
	Pot life at 20°C	XK205 ZU207	45 min. 1 h 30 min.	
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	19-26 s 19-26 s 21-28 s	
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip	Spray distance
			1.4-1.6 mm	20-25 cm
			1.4-1.8 mm	20-25 cm
			1.3-1.5 mm	10-15 cm
		1.0-1.2 mm	20-25 cm	
	Spray pressure	Gravity feed Suction feed HVLP Pressure feed	3-4 bar 3-4 bar 0.7 bar at nozzle 4-6 bar	
	Number of coats	1.5-2		
	Flash time	1-3 min. between coats when applying 1.5 coats. Minimum 10 min. between coats when applying 2 coats. 10 min. before bake.		
	DFT	50-70 μ		
	Drying	Dust-free Dry to handle Tape-free	30 min. x 60°C	
			imm.	
			1 h	
			2 h	

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.

(*) VOC practically measured following ASTM D 3960-96.

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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 P360 - P500;
wet P800 - P1000.
5. Degrease with 3920S.
6. Wipe dry and tack rag.

Topcoat application

Apply a light coat, immediately followed by a full coat with 1-3 min. flash between coats or apply 2 full coats, with minimum 10 min. flash between coats.

Chemical resistance

When fully cured, Imron[®] 7035 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

Equipment cleaning

Use 3608S.

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RECOMMENDED USE (con'd)

Recoatability

At any time after tape-free time.

Product data

Theoretical coverage: 7-9 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
AM1x Centari [®] MasterTint [®]	1	2
AM94 Centari [®] MasterTint [®]	1	2
AM95 Centari [®] MasterTint [®]	1	2
AM7xx Centari [®] MasterTint [®]	1	3
AMxx Centari [®] MasterTint [®]	1 - 4	4
ZU138	4	2
ZU207	5	2
ZU338	1	2
XK205	1 - 5	2

Remarks

- Centari[®] MasterTints[®] have to be thoroughly mixed before weigh-out and the Imron[®] 7035 colour has to be mixed immediately after weigh-out.
- Close can of ZU207 and XK205 tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- Viscosity can be adjusted by adding XB383. Note that the addition of thinner can result in higher VOC content than 3.5.
- Maximum baking temperature is 80°C.
- The use of XK205 is recommended for spot and panel repairs only.
- For longer pot life XK206 can be used. Note that longer drying will be needed (40 min. at 60°C).
- 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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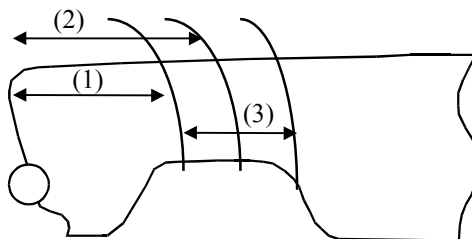
REPAIR SYSTEMS

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 with 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[®] Blending Thinner method.

AK350 Centari[®] Blending Thinner method

- ① Apply 1st coat Imron[®] 7035.
Flash: 3-5 min.
- ② Extend 2nd coat Imron[®] 7035
beyond the previous one.
- ③ Blend in the fade-out area with AK350.



OPTIONAL: dilute remaining part Imron[®] 7035 with 1 part AK350 after 2nd 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.