Imron® MS600™ Polyurethane Topcoat

GENERAL

DESCRIPTION
A high-performance single stage acrylic/polyester-based polyurethane topcoat designed to deliver excellent appearance and durability with ease of application. This high-solids topcoat has a ready-to-spray VOC of less than 3.5 lbs/gal and is available in factory packaged whites and mixed colors.

RECOMMENDED USES
Imron MS600 is an air dry product recommended for above the water line marine applications where excellent appearance, durability, sag resistance, and ease of use are required. Imron MS600 is recommended for use with Corlar® 18510S™ Epoxy Primer for maximum topcoat appearance. It may be used over most aged and hard cured coatings in good condition.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS
Imron MS600 Color
18100S™ Urethane Activator
Imron 18765S™ Low Temperature Reducer (< 70° F)
Imron 18775S™ Medium Temperature Reducer (70 – 85° F)
Imron 18785S™ High Temperature Reducer (>85° F)
Imron Reducers are available for a range of application conditions. Suggested usage ranges are dependent on air flow and relative humidity.

See Imron MS100™ product data sheet for basecoat information.

MIX RATIO
Thoroughly mix Imron MS600 color prior to activation. Filter activated material prior to spray application.

Three Component System	**Parts by Volume**
Imron MS600 color	2
18100S Urethane Activator	1
Imron Reducer 187X5S (Temperature dependent)	1

VISCOSITY
Viscosity will be 16-19 seconds in a Zahn #2 cup.

INDUCTION TIME
No induction time is required prior to application.

POT LIFE
Pot life is 4hours at 70°F (21°C), approximately 2 hours at 90°F (33°C).

ADDITIVES

Accelerators

- Add up to 2 oz. 13801S, 13803S, or 13808S urethane accelerator per RTS gallon
- For temperatures below 70°F (21°C), 13803S Urethane Accelerator can be used up to 2 oz per RTS gallon of Imron MS600 Topcoat to speed dry time and extend pot life

Flattener

- PowerTint™ PT196™ Flattener can be added to lower gloss of MS600. Refer to flattener data sheet for starting point recommendations.

Anti-Crater

- Add up to 1 oz 13813S™ per RTS gallon
  There are many causes for craters, anti-crater additives may not be able to overcome all causes.

These additives will not compensate for severe surface contamination or improper preparation.

APPLICATION

SUBSTRATES AND SURFACE PREPARATION

Surface preparation is critical to topcoat appearance and system performance. Primers should be properly applied and cured according to product data sheets. Surface immediately below topcoat should be cleaned, then DA sanded with 320 to 400 grit for optimum performance. Substrate should always be thoroughly wiped/tacked immediately prior to topcoat application.

ENVIRONMENTAL CONDITIONS

Substrate and ambient temperature must be between 55°F (13°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated material above 110°F (43°C) may cause gelation.

GUN SETUP

Imron MS600 topcoat can be applied with conventional, HVLP, air-assisted airless, and electrostatic spray equipment using pressure or gravity fluid delivery.

Conventional	**Fluid Tip**
Pressure Pot	1.0 mm – 1.4 mm (.039” - .055”)
Gravity Feed	1.2 mm – 1.6 mm (.047” - .063”)
HVLP	
Pressure Pot	1.0 mm – 1.4 mm (.039” - .055”)
Gravity Feed	1.2 mm – 1.6 mm (.047” - .063”)

FLUID DELIVERY

Conventional	10-12 oz./minute
HVLP	10-12 oz./minute

AIR PRESSURE

Conventional	50-60 psi atomizing air
HVLP	25-30 psi atomizing air

APPLICATION

Spray a medium-wet first coat. Allow first coat to flash for 5 – 20 minutes prior to second coat. Apply second coat as a wet cross-coat to achieve 2.0 – 2.5 mils dry film build. Material should be cured a minimum of 72 hrs before placed into limited service.

CLEANUP SOLVENTS
Axalta 107™ Low VOC Gun & Equipment Cleaner
Axalta 105™ Gun & Equipment Cleaner

DRY TIMES

AIR DRY
At 70°F (21°C)

Dry to Touch	4 - 6 hours
Dry to Tape	overnight

RECOAT
When recoating Imron MS600 topcoat with itself, scuff sanding (400 grit with DA) is required if the topcoat has air dried for more than 48 hours or if the topcoat has been force dried.

PHYSICAL PROPERTIES

VOC	Less Exempts (LE)	As Packaged (AP)
Ready-to-Spray Topcoat	3.5 lbs/gal	2.9 lbs/gal

FACTORY-PACKAGED AND MIXED COLORS

Color	Various mixed colors available
Closed Cup Flash Point	20°F - 73°F
Shelf Life	2 years (Unopened at 50°-110°F)

READY-TO-SPRAY

Theoretical Coverage	680 ft²/gal average at 1 mil DFT (670 - 688 ft²/gal)
Weight Solids	52% average (48 – 56%)
Volume Solids	42% average (41 - 43%)
Gallon Weight	9.3 lbs/gal average (8.5 – 10.1 lbs/gal)

DRY FILM

Gloss	≥90 measured at 60°
Recommended Film Thickness	2.0 – 2.5 mils

COATING PERFORMANCE

Chemical and Solvent Resistance	Very Good
Weatherability	Excellent
Humidity Resistance	Excellent
Acid and Alkali Resistance	Excellent
Abrasion Resistance	Excellent
Flexibility	Excellent

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

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. Do not allow material or overspray to enter drains or waterways.

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