# IMRON® MARINE
## DP3330 Spray Fairing

### Description

2-component chromate-free epoxy Imron® Marine Spray Fairing.
Color: grey.
Composition based on epoxy resin.

### Products

| | |
|---|---|
| DP3330 | Spray Fairing |
| DP3335 | Spray Fairing Activator |
| TH80 | EP Thinner |

### Auxiliary products

| | |
|---|---|
| TH39 | Water Based degreaser |
| 3919S | Prepsol |

### Properties

- Excellent adhesion on properly treated metal substrates: Aluminum, steel, composites material and wood.
- Provides, when used in combination with DP3350 Fairing Lite, a complete filling and fairing solution for turning rough surfaces into perfectly smooth areas.
- Very good filling properties. Suitable for use over rough substrates.
- High humidity resistance and very good flexibility.
- Recommended as spray fairing for all Imron® Marine systems.

### Substrates

Following specifications listed in the Imron® Marine Manual and in particular:
- bare metals: steel, aluminum and galvanized steel;
- well prepared Gelcoat, well sanded fairing and cured repaired finishes.

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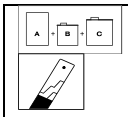
### PRODUCT PREPARATION

| | | | | |
|---|---|---|---|---|
|  | **Mixing ratio** | | **Volume** | **Weight** |
| | | DP3330 | 1 | 100 |
| | | DP3335 | 1 | 100 |
| | | TH80 | 0 to 0.1 | 10 |
| | **VOC** | 245 g/l | | |
|  | **Pot life at 20°C** | 4 hr. | | |
|  | **Spray viscosity at 20°C** | **DIN 4** | 35-80 s | |
| | | **FORD 4** | 35-80 s | |
| | | **AFNOR 4** | 40-90 s | |
|  | **Spray equipment** | | **Fluid tip** | **Distance** |
| | | **Gravity feed** | 2.2-2.8 mm | 20-30 cm |
| | | **HVLP** | 2.0-2.8 mm | 15 cm |
| | | **Pressure feed/ Airmix®** | 1.6-2.2 mm | 20-30 cm |
| | | **Airless** | 0.013”/65°-80° | 20-30 cm |
|  | **Spray pressure** | **Gravity feed** | 3.5-4.5 bar | |
| | | **Suction feed** | 3.5-4.5 bar | |
| | | HVLP | 0.7 bar at nozzle | |
| | | **Pressure feed** | 3.5-4.5 bar | |
| | | **Airless** | 180-200 bar | |
|  | **Number of coats** | 2 to 4 | | |
|  | **Flash time at 20°C** | Between coats till flat maximum 2 hr. | | |
| | **DFT** | Up to 600 µ. | | |
|  | **Dry to sand at 20°C** | 16 hr.<br>Full cure time: 7 days. | | |

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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### RECOMMENDED USE

**Surface preparation**

Following specifications listed in the Imron® Marine Manual and in particular:
Bare metals (steel, aluminum, aluminum alloys)
- Clean substrate with a suitable nitrocellulose thinner.
- Grit blast surface up to Sa 2 ½ to eliminate all traces of rust and corrosion.
- Blow surface to eliminate dust and blasting media.
- Apply etching primer and filling fairing till recommended film build.

Bare glass fiber
- Clean surface with water and soap. Rinse and dry.
- Degrease with 3919S or TH39. Wipe dry.
- Dry sand with P80 - P120.
- Clean with 3919S or TH39.
- Apply etching primer; osmosis prevention primer and/or filling fairing till recommended film build.

**Remarks**

- Activated material should not be returned to original can of non-activated material.
- Material has to be stirred well before use.
- Close can of DP3335 tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

**Recoatability**

At any time after full cure and sanding.

**Equipment cleaning**

Use TH80.

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**Product data**

| | |
|---|---|
| Package viscosity: | DP3330: 340 cp |
| | DP3335: 420 cp |
| Volume solids: | 68 % ± 5 % |
| Film build: | Wet: 600 µ |
| | Dry: 400 µ |
| Theoretical coverage: | 2.0 m²/l |

| Products | Packages (l) | Storability at 20°C (Months) | VOC (g/l) ± 5 | Density (kg/l) ± 0.01 | Flash Point (°C) |
|---|---|---|---|---|---|
| DP3330 | 5 | 24 | 245 | 1.41 | 30 |
| DP3335 | 5 | 24 | 245 | 1.41 | 30 |
| TH80 | 5 | 60 | 839 | 0.84 | 23 |
| 3919S | 5 | 60 | 813 | 0.81 | 43 |

**Safety**

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

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**Information**

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.
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