IMRON® MARINE
DP8130 Alu Grip Primer

Description

Thin film 2-component chromate-free epoxy Imron® Marine Alu Grip Primer.
Color: white.
Composition based on epoxy resin.

Products

DP8130	Imron® Marine Alu Grip Primer
DP8135	Imron® Marine Alu Grip Primer Activator
TH80	EP Thinner

Properties

- Very good corrosion and chemical resistance.
- Excellent adhesion on properly treated aluminum, aluminum alloys and bronze.
- Recommended as a first coat over new aluminum constructions.
- High humidity resistance and very good flexibility.
- Recommended as a primer for all Imron® Marine systems.

Substrates

Following specifications listed in the Imron® Marine Manual and in particular:
- Aluminum, aluminum alloys, lead and bronze.

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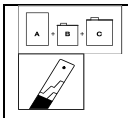
PRODUCT PREPARATION

	**Mixing ratio**		**Volume**	**Weight**
		DP8130	7	100
		DP8135	3	35
		TH80	0 to 0.4	0 to 6
	VOC	499 to 533 g/l		
	**Pot life at 20°C**	18 hr.		
	**Spray viscosity at 20°C**	**DIN 4**	40-65 s	
		FORD 4	40-65 s	
		AFNOR 4	40-65 s	
	**Spray equipment**		**Fluid tip**	**Distance**
		Gravity feed	2.2-2.8 mm	20-30 cm
		HVLP	2.0-2.2 mm	15 cm
		Pressure feed/ Airmix®	1.6 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	140-200 bar	
	**Number of coats**	1 to 2		
	**Flash time at 20°C**	Between coats till flat with maximum of 3 days.		
		Before recoating: 2K primers	Minimum 6 hr.	maximum 7 days
	DFT	25 to 35 µ		
	**Dry to sand at 20°C**	1 hr. to maximum 3 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.

* AIRMIX® is a registered trademark of KREMLIN

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RECOMMENDED USE

Surface preparation

Following specifications listed in the Imron® Marine Manual and in particular:
Bare metals (Aluminum, aluminum alloys, lead and bronze)
- Clean substrate with a suitable nitrocellulose thinner.
- Sand metal with P80 - P120 sanding paper.
- Apply primer till recommended film build.
- Flash recommended time before further priming.

Remarks

- Activated material should not be returned to original can of non-activated material.
- DP8130 can be applied by brush if no reducer is added to the activated material.
- Material has to be stirred well before use.
- Close can of DP8135 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

After minimum 6 hr. at 20°C and maximum 7 days at 20°C without sanding.

Equipment cleaning

Use TH80.

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Product data

Package viscosity:	5.500 cp
Volume solids:	41 % ± 2 %
Film build:	Wet: 60 µ
	Dry: 25 µ
Theoretical coverage:	12.0 m²/l at 35 µ DFT - ready-to-spray
	16.0 m²/l at 25 µ DFT - ready-to-spray

Products	Packages (l)	Storability at 20°C (Months)	VOC (g/l) ± 5	Density (kg/l) ± 0.01	Flash Point (°C)
DP8130	3.55	24	516	1.14	27
DP8135	1.45	24	461	0.92	33
TH80	5	60	843	0.84	23

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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