



Imron® 9300

3.5 VOC P.U. Topcoat

Description

High Solids 2-component topcoat system for use on chassis & trailers.
Composition based on polyurethane acrylic (patented “star” polymer technology).

Products

AMXXX	Centari® Master Tint
9022	Imron® 9300 Standard Activator
9310	Imron® 9300 Binder
9330	Imron® 9300 Airless/Airmix Thinner
9331	Imron® 9300 Conventional Thinner
ZK930	Imron® 9300 Additive

Properties

- High quality 2K polyurethane topcoat which provides an excellent appearance, a high gloss finish and low consumption in a very broad range of industrial applications.
- Suitable for Airless, Air-mix and conventional application.
- When fully cured, Imron® 9300 is resistant to short exposures of a lot of chemicals.

Colour

- See colour formula

Substrates

- All OEM finishes and DuPont primers.

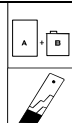

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<p>Surface preparation</p> <ul style="list-style-type: none"> •

<p>VOC value ready for use without thinner (EU Directive 1999/13/EC)</p> <p>< 420g/l (practically measured following ASTM D 3960-96)</p>
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Product preparation

	Mixing Ratio	Airless/Airmix		Conventional	
		Imron® 9300 9022 9330 9331	3 1 0.4 -	3 1 - 0.4	
	Pot life at 20°C	9022	60-90 min		
Recommended dry film thickness		50-70 μ			

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Application

	Application viscosity	Spray nozzle	Pressure	Spray distance	Number of coats
	(s)	(mm)	(bar)	(cm)	
 Gravity feed	FORD4 22-32 DIN4 22-32	1.4-1.6	3-4	20-25	1.5 to 2 following colour coverage
 Suction feed (High pressure spraying)	AFNOR4 24-34	1.4-1.8	3-4	20-25	
 HVLP (Low pressure spraying)	FORD4 22-32 DIN4 22-32 AFNOR4 24-34	1.3-1.5	0.7 bar at nozzle	10-15	1.5 to 2 following colour coverage
 Pressure pot	FORD4 22-32 DIN4 22-32 AFNOR4 24-34	1.0-1.2	4-6	20-25	1.5 to 2 following colour coverage
Membrane Pump (High pressure spraying)					
 Airless	FORD4 22-32 DIN4 22-32 AFNOR4 24-34	0.23	200-240	30	1.5 to 2 following colour coverage
Airmix (High pressure spraying)		0.23	100(product pressure) - 4 bar at gun	30	
 Electrostatic	According to the advice of the DuPont Technical Representative.				

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Drying

	Flash Time	15 min. between coats 15 min. before bake
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	Drying (* object temperature)	20°C (*) 45°C (*) 60°C (*)	16 hrs 3 hrs 30 min
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Product data



Flash point	>23°C
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	Solids Weight (%) +/- 1	Density (kg/l) +/- 0.01	Theoretical coverage		Theoretical material consumption	
			(at 50 µ) m ² /l	(at 70 µ) m ² /l	(at 50. µ) ml/m ²	g/m ²
RFU without thinner						
I9300 RFU White	67.6	1.22	10.9	7.8	91.7	112.4
Black	62	1.00	11.3	8.0	88.5	89.3

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Remarks

	<ul style="list-style-type: none"> • Centari® Master Tints have to be thoroughly mixed before weight-out and the Imron® 9100 colour has to be mixed immediately after weigh-out. • Close activator can tightly immediately after use, as it will react with humid air and water and lose its hardening effect. • Material has to be at room temperature (18-20°C) before use. • To obtain optimal performance thoroughly mixing of the activator and thinner into the paint is advised. • 9330 should not be used to clean equipment or tubes. • Viscosity can be adjusted by adding 9331. Note that the addition of thinner can result in higher VOC content than 3.5 (420 g/l). • Max. bake temperature is 80°C. • Contact your DuPont technical representative in case of specific system modifications 	
	<ul style="list-style-type: none"> • Before application a colour comparison is recommended. 	
<p>Data</p>	<p>Shelf Life (5-35°C) (months)</p>	<p>Density (kg/l) +/- 0.01</p>
<p>AM-Tints 9310 9022 9330 9331 ZK930</p>	<p>48 24 24 48 48 48</p>	<p>- 0.995 1.050 0.776 0.903 0.894</p>



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Safety

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

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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