Technical Data Sheet

IMRON® MARINE
DP8140 Universal Primer

Description

2-component chromate-free epoxy Imron® Marine Universal Primer.
Ideal primer for the use on above and below the water area of yacht and pleasure crafts.
Colour: grey.
Composition based on epoxy resin.

Products

DP8140	Universal Primer
DP8145	Universal Primer Activator
TH80	EP Thinner

Auxiliary products

TH39	Water Based degreaser
3919S	Prepsol

Properties

- Very good corrosion and chemical resistance.
- Excellent adhesion on properly treated metal substrates.
- Excellent prevention primer against Gelcoat osmosis and blistering.
- Excellent adhesion on properly treated aluminum, aluminum alloys and bronze.
- Recommended as a first coat over new steel and aluminium constructions.
- Very good filling properties. Suitable for use over rough substrates e.g. grit blasted metals.
- 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:
- bare metals: steel, aluminium, aluminum alloys, lead and bronze and galvanised steel.
- well prepared Gelcoat, cured and sanded fairing and cured repaired finishes.

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DP8140 Universal Primer

PRODUCT PREPARATION

	Mixing ratio		**Volume**	**Weight**
		DP8140	2	100
		DP8145	1	37
		TH80	0 to 5%	0 to 6
	VOC	476 to 540 g/l		
	Pot life at 20°C	12 hr		
	Spray viscosity at 20°C	**DIN 4**	> 150 s	
		FORD 4	> 150 s	
		AFNOR 4	> 150 s	
	Spray equipment		**Fluid tip**	**Distance**
		Gravity feed	2.2-3.0 mm	20-30 cm
		HVLP	2.0-2.6 mm	15 cm
		Pressure feed/Airmix®	1.6 mm	20-30 cm
		Airless	0.017"/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	2 to 4		
	Flash time at 20°C	Between coats till flat with maximum of 3 days.		
		Before recoating: 2K primers	minimum 2 hr.	maximum 28 days
	DFT	80 to 225 µ		
	Dry to sand at 20°C	16 hr.		

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 and galvanised steel)
- 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 primer till recommended film build.

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.

Bare glass fibre
- 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.
- Wipe dry before priming.

Remarks

- As osmosis prevention primer, apply 3 to 4 coats to achieve film build of 200 to 240 µ.
- Activated material should not be returned to original can of non-activated material.
- DP8140 can be applied by brush if no reducer is added to the activated material.
- Material must be stirred well before use.
- Close can of DP8145 tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material must be at room temperature (18-25°C) before use.

Recoatability

Sanding: after full cure.
Without Sanding: after minimum 6 hr. at 20°C and maximum 3 days at 20°C.

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Equipment cleaning

Use TH80.

Product data

Package viscosity:	10.500 cp
Volume solids:	44 % ± 2 %
Film builds:	Wet: 180 µ
	Dry: 80 µ
Theoretical coverage:	5.6 m²/l at 80 µ DFT - ready-to-spray
	2.0 m²/l at 225 µ DFT - ready-to-spray

Products	Packages	Storability at 20°C	VOC	Density	Flash Point
	(l)	(Months)	(g/l) ± 5	(kg/l) ± 0.01	(°C)
DP8140	3.4	24	493	1.23	32
DP8145	1.6	24	438	0.98	32
TH80	1	60	843	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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