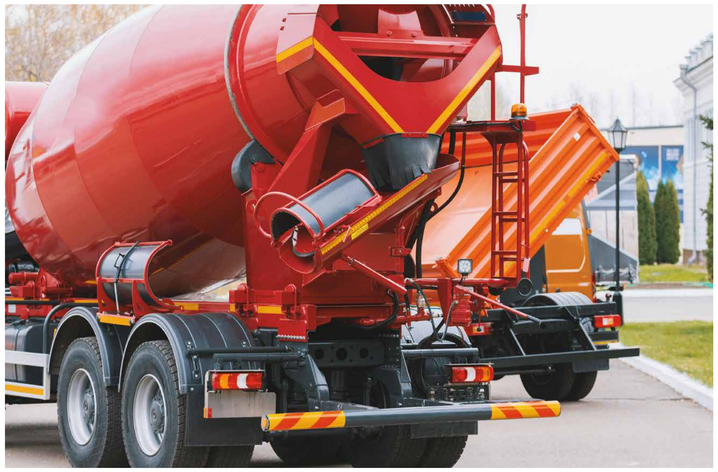
Duraspar® IP

MIXING AND APPLICATION GUIDE



OUTSTANDING FIRST-PASS YIELD

Designed for demanding markets, **Duraspar Industrial Performance** (IP) is a 2K polyurethane intermix system. Known for its outstanding first-pass hide and sag resistance, Duraspar IP combines the aesthetics of automotive paint with the rugged performance of an industrial coating.

DURASPAR IP PRODUCTS & COMPONENTS

PRODUCT CODE	DESCRIPTION
Duraspar IP Color Coat	
V66VCV079EU	DIP ACTIVATOR
R07KCV031EU	DIP MEDIUM REDUCER
60660	REDUCER SLOW
V70VCV094EU	DIP THIXOTROPE

DURASPAR IP MIXING RULES

- Mix three (3) parts DURASPAR IP to one (1) part DIP Activator and one (1) part reducer (3:1:1).
- Reducer selection and amount should be based on the size of the area to be painted, air movement and temperature.

3 Parts DURASPAR IP + 1 Part DIP Activator + 1 Part Reducer

OPTIONAL ADDITIVES

- V06V00770EU Cure Accelerator (2 - 8 g/L)
- V70VCV011EU, Fish Eye Eliminator
- V70VCV094EU DIP Thixotrope

SURFACE PREPARATION

- Finish sand with 180-360 grit sandpaper or equivalent
  - Mask all adjacent areas to prevent overspray problems
- Apply the Duraspar IP over Sherwin-Williams approved primers
  - See Sherwin-Williams Rep for full list of approved primers
- Coatings should not be applied at air or surface temperature below 10°C
- Substrate must be at least (3°C) above the dew point
- Do NOT apply Duraspar IP directly to metal

GUN SET UP

LOW PRESSURE CONVENTIONAL SPRAYING	
Tip Size	0,8 - 1,2 mm
Flow Rates	300 - 350 mL/min
Atomizing Air	3 - 4 bar
Viscosity DIN 4 mm (20°C)	20 - 25 s

AIR-ASSISTED AIRLESS SPRAYING	
Tip Size	0,007 - 0,011" / 40° (0,18 - 0,28 mm)
Material pressure	2,5 - 3 bar
Air pressure	2,0 - 2,5 bar
Viscosity DIN 4 mm (20°C)	20 - 30 s

Note: The specifications apply to ambient temperatures of approx. 20°C and are to be understood as a recommendation or guide. Due to requirements, specifications or conditions on site, it may be necessary to deviate from this.

*Metallics require 0.8-1.0 tip size and 4 bar atomizing air.

APPLICATION GUIDELINES

DURASPAR IP APPLICATION

- Cut in all recessed areas first and paint top to bottom.
- Apply using two-coat, cross-coat technique.
- Apply one medium coat horizontally, and then apply one medium coat vertically.
- Flash times will be dependent on temperature, air flow, thinner selection and if accelerator is used.

DURASPAR IP AIR DRY AND CURE TIMES

AIR DRY @ 25°C (77°F)	
Standard System	
Flash between primer and color coat	45 minutes minimum
Flash between color and clear	60 minutes minimum
Time to tape	4 hours as is 1 hour with GA1098 Accelerator
Time to sand	8 hours as is 4 hours with GA1098 Accelerator
Time to outdoor exposure	16 hours at temps. > than 15°C 4 hours with accelerator and temps. > 25°C
Recoat Windows:	**Scuff sanding of first coat is required when applying clear coat outside these windows**

RECOAT WINDOWS

SCUFF SANDING OF FIRST COAT IS REQUIRED WHEN APPLYING SECOND COATS OUTSIDE THESE WINDOWS.

- Color coat over color coat: 12 hours max at temperatures up to 32°C
- Color coat over color coat (with accelerator): 8 hours max at temperatures up to 32°C
- Clear coat over color coat: 8 hours max at temperatures up to 32°C

BAKE SCHEDULE

Flash after topcoat application	30 minutes minimum
Cure time and temperature	60 minutes at 40°C (Part Metal Temp.)
Time to outdoor exposure	24 hours minimum

Duraspar IP PotLife

- @25°C = 90 minutes as is
- @32°C = 60 minutes as is

Duraspar IP Clean Up

- Thinner codes 33170,R04CUI001 or NT019 or V0002
- Check local regulations

DURASPAR IP PHYSICAL DATA

VOC content (reduced 3:1:1)	420 g/L
Volume Solids (as supplied)	51% - 55%
Theoretical Coverage	18,5 m^2/L @ 40 µm DFT
Target wet film thickness	75 - 125 µm
Recommended DFT	40 - 65 µm
60° Gloss	90 GU

At Sherwin-Williams, we think about coatings differently, continuously seeking the perfect solution to help your products win over your customers. Whether you need the most rugged and protective coating, a technical expert to provide answers and hands-on support, consistently perfect color at just the right gloss, or a custom solution created just for you — we are here to help. We are Sherwin-Williams General Industrial Coatings, and we are obsessed with giving you the competitive edge.

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