

DuPont™ 18550S™ Spray Fairing

Type

DuPont™ 18550S™ is a sprayable fairing compound.

Description

DuPont™ 18550S™ is a convenient, easy-to-use, sprayable fairing compound developed to be used in conjunction with DuPont™ 18545S™ for fairing large areas of aluminum, steel, fiberglass or wooden marine vessels. DuPont™ 18550S™ is designed to be the final surface fairing over DuPont™ 18545S™ Fairing Compound.

Recommended Uses

DuPont™ 18550S™ may be used above or below the water and can be easily applied up to 30 mils without sagging or shrinking during the curing process. When cured, this system features excellent sanding characteristics and accepts all DuPont Marine System primers and surfacers for above the water line. It is recommended for use with:

Fairing Compound	DuPont™ 18545S™
Primers	Corlar® 18510S™ Epoxy Primer Corlar® 18515S™ High Build Epoxy Primer

General Information for Use

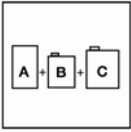
Components

DuPont™ 18550S™ Spray Fairing

DuPont™ 18150S™ Spray Fairing Activator

DuPont™ 18750S™ Spray Fairing Reducer





Mix Ratio

The activator is tinted blue.

Thoroughly mix resin and activator until a uniform color is achieved.

Three component system parts by volume

DuPont™ 18550S™ Spray Fairing	1
DuPont™ 18150S™ Spray Fairing Activator	1
DuPont™ 18750S™ Spray Fairing Reducer	5 – 10%

Do not reduce DuPont™ 18550S™ with more than 10% DuPont™ 18750S™ Spray Fairing Reducer

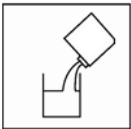


Pot Life and Induction Time

Pot life 2 hours at 77° F (25° C)

There is no induction time

DuPont™ 18550S™ must not be applied beyond the recommended pot life.



Additives

None Recommended

Guidelines for Use

Substrate and Surface Preparation

Underlying DuPont Fairing or Primer coverage must be to product specifications and it is critical the underlying paint layer be cured, sanded, and free of dirt and contamination prior to application of DuPont™ 18550S™ Spray Fairing. Sand Fairing with 36 – 80 grit, primer with 80 grit.

Environmental Conditions

Substrate and ambient temperature must be between 55° F (13° C) and 95° F (35° C). The substrate must be at least 5° F (3° C) above the dew point. Relative humidity should be below 90%.

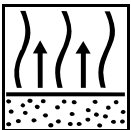


Application

Thoroughly stir resin and hardener components until homogeneous. Combine components until a consistent color is obtained throughout. Add reducer as desired. Apply with a conventional pressure pot spray gun such as Binks or equivalent. Use a #68 (2.8mm/.110") nozzle with 60-75 psi air pressure. Spray 5-10 mils per coat, allowing 5-6 hours between coats. Recommended film build is 30 to 35 mils maximum. Sand final coat and seal with 2 coats DuPont™ 18510S™ Epoxy Primer. Do not apply DuPont™ 18550S™ beyond the recommended pot life. It is recommended that spray equipment be flushed with DuPont™ 18750S™ Spray Fairing Reducer.

DuPont™ 18550S™ should never be applied directly to topcoats.

Over reducing the 18550S™ and trapping solvent between the spray fairing and primer are the major causes of failure.



Dry Times

To Sand: Approximately 6-8 hours depending upon thickness and environmental conditions.

To full cure: 3 days depending upon environmental conditions.



Recoat

Allow 5 hours between coats of 18550S™. Allow 18550S™ to cure a minimum of 24 hrs at temperatures above 77 ° F before priming. At application temperatures below 77° F, allow 2-3 days before priming.



Cleanup

Use DuPont™ 3642S™ Thinner or Nason® 481-16™ Thinner for cleaning equipment.

Physical Properties

VOC:	1.9 #/gal
Color:	DuPont™ 18550S™ White DuPont™ 18150S™ Blue
Shelf Life:	2 years in original unopened containers. Store between 50° F and 80° F
Weight Solids:	86%
Gallon Weight:	13.5 lbs/gal
Theoretical Coverage:	42 square feet/gal at 30 mils

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Do not allow material or overspray to enter drain or waterway.

E-R 4690/K-17183
Revised 11/2007