

## Commercial Transportation | Aviation

## Product System Chart

Product	Components	Mix Ratio	VOC	Additives	Gun Set Up-HVLP Fluid Delivery	Flash / Dry Times
<b>Epoxy Pre-Treatments</b>	<b>Epoxy Pre-Treatment</b> 13238S™ Epoxy Pre-Treatment 13138S™ Pre-Treatment Activator	<b>1 Part Primer 1 Part Activator</b>	<b>5.0 lbs/gal 600 g/L</b>	None	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 240-300 mL/min	10 min. to touch 30 min. to prime/topcoat one med wet coat <b>9-11 secs Gardco EZ #3</b>
<b>Primers</b>	<b>Corlar® Corrosion -Resistant Epoxy Primer</b> 13550S™ Chromate Epoxy Primer 13150S™ Epoxy Activator 13756S™ VOC- Exempt Reducer	<b>3 Parts Primer 1 Part Activator 2 Parts Reducer</b>	<b>2.8 lbs/gal 336 g/L</b>	13813S™ up to 8 g per RTS litre	Pressure- 1.0 to 1.4 mm Gravity - 1.0 to 1.4 mm 240-300 mL/min	30 min induction time 10 hour pot life 2 hours to topcoat one medium coat <b>17-21 secs Gardco EZ #2</b>
	<b>Corlar® Non-Chromate Epoxy Primer</b> 13580S™ Corrosion-Resistant Epoxy Primer 13180S™ Epoxy Activator 13756S™ VOC- Exempt Reducer	<b>4 Parts Primer 1 Part Activator 1 Part Reducer</b>	<b>2.7 lbs/gal 324 g/L</b>	13813S™ up to 8 g per RTS litre  <b>30 minute induction time</b>	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 240-355 mL/min	30 min induction time 8 hour pot life 30 min to touch 2-6 hours to topcoat one med coat <b>18-22 secs Gardco EZ #2</b>
<b>Surfacers</b>	<b>Corlar® Non-Chromate Epoxy Surfacers</b> 13580S™ Corrosion-Resistant Epoxy Primer 13180S™ Epoxy Activator 13756S™ VOC- Exempt Reducer	<b>4 Parts Primer 1 Part Activator 0.5 Part Reducer</b>	<b>2.8 lbs/gal 336 g/L</b>	13813S™ up to 8 g per RTS litre  <b>30 minute induction time</b>	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 240-355 mL/min	30 min induction time 8 hour pot life Bake 55°C x 1hr touch 15 min/tape 1 hr Hi-Build 2-3 coats <b>18-22 secs Gardco EZ #2</b>



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Topcoats	<b>Imron® Polyurethane Topcoat</b> AF3500™ Color Solid colors only 13110S™ Urethane Activator 13865S™, 13875S™ Pot-Life Extenders 13765S™, 13775S™ - Exempt Reducers	<b>2 Parts Topcoat</b> <b>1 Part Activator</b> <b>0.25 Part Pot life Ext.</b> <b>0.25 Part Reducer</b>	<b>3.5 lbs/gal</b> <b>420 g/L</b>	8 to 15 g of 389S™ per RTS litre 8 g of 8989S™ per RTS litre <b>13100S™ for parts/repair</b> 8 g of 13813S™ Anti Crater / L	Pressure - 1.0 to 1.4 mm 20-25 cm from surface Gravity - 1.2 to 1.4 mm 20-25 cm from surface E-Stat - 1.2 to 1.5 mm 30-35 cm from surface <b>Fluid Delivery</b> <b>240-300 mL per minute</b>	8 hour pot life one med wet coat 15-45 min flash Apply either a second medium coat, Allow 15-45 mn flash followed by a third medium coat if not hid. Or apply second coat as a cross coat <b>15-20 seconds Zahn #2</b>
	<b>Imron Polyurethane Basecoat</b> AF700™ Color Solid, Metallics, & Pearls 13100S™ Urethane Activator 13765S™ or 13775S™ VOC Exempt Reducers Check Viscosity 10-18 seconds Zahn EZ-#3 Target is 10-14 seconds	<b>3 Parts Colour</b> <b>1 Part Activator</b> <b>Check Viscosity</b> <b>Prior to addition of</b> <b>Reducer</b>	<b>3.4 lbs/gal</b> <b>408 g/L</b>	8 to 15 g of 389S™ per RTS litre 8 g of 8989S™ per RTS litre 8 g of 13813S™ Anti Crater / L	Pressure - 1.0 to 1.4 mm 20-25 cm from surface Gravity - 1.2 to 1.4 mm 20-25 cm from surface E-Stat - 1.2 to 1.5 mm 30-35 cm from surface <b>Fluid Delivery</b> <b>240-300 mL per minute</b>	Accelerator aids in dry to tape, Solid colors - Apply either a cross coat or two medium coats. Effect - Medium first (1st) coat Don't achieve complete hiding Follow with a second (2nd) medium coat. Apply 45° orientation coat as necessary <b>Don't Spray like Single Stage</b>
	<b>Imron Polyurethane Topcoat</b> <b>Gloss and Reduced Gloss</b> AF400™ Colour Solid and Metallics 13110S™ Activator for overall Solid Colours 13100S™ Activator for Effect Colours for Overalls, Stripes, and Repair 13765S™, 13775S™, 13785S™ VOC- Exempt Reducers	<b>3 Parts Colour</b> <b>1 Part Activator</b> <b>Reduce per viscosity</b>	<b>3.4 lbs/gal</b> <b>408 g/L</b>	8 to 15 g of 389S™ per RTS litre 8 g of 8989S™ per RTS litre 8 g of 13813S™ Anti Crater / L	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.6 mm 240-300 mL per minute	2 hour pot life one med wet coat 5- 15 min flash second coat is a wet cross coat <b>9-13 seconds Zahn #3</b>
Clearcoats	<b>Imron Polyurethane Clearcoat -Split Base/Overall</b> AF740™ Clearcoat 13110S™ Urethane Activator 13775S™, 13930S™ Reducer Check Viscosity 10-13 seconds Zahn EZ-#3	<b>3 Parts Colour</b> <b>2 Parts Activator</b> <b>up to 1 Part</b>	<b>3.4 lbs/gal</b> <b>408 g/L</b>	8 to 15 g of 389S™ per RTS litre 8 g of 8989S™ per RTS litre 8 g of 13813S™ per litre for contamination	Pressure - 1.0 to 1.4 mm 20-25 cm from surface Gravity - 1.2 to 1.4 mm 20-25 cm from surface E-Stat - 1.2 to 1.5 mm 30-35 cm from surface <b>Fluid Delivery</b> <b>240-300 mL per minute</b>	First (1st) coat use 13775S for reducing. Apply first (1st) coat in medium wet application 65% overlap. Follow with a wet second (2nd) coat after pots have been refreshed using combination of 10% 13775S™ and 10% 13930S™ in freshly activated AF740™.
	<b>Imron Polyurethane Clearcoat - Stripes only</b> AF740™ Resistant Clearcoat 13110S™ Urethane Activators 13765S™, 13775S™ Reducer Check Viscosity 10-13 seconds Zahn EZ#3 For E bands, Reg numbers, and Repairs replace 13110S™ with 13100S™	<b>3 Parts Colour</b> <b>2 Parts Activator</b> <b>up to 1 Part</b>	<b>3.4 lbs/gal</b> <b>408 g/L</b>	8 to 15 g of 389S™ per RTS litre 8 g of 8989S™ per RTS litre 8 g of 13813S™ per litre for contamination	Pressure - 1.0 to 1.4 mm 20-25 cm from surface Gravity - 1.2 to 1.4 mm 20-25 cm from surface E-Stat - 1.2 to 1.5 mm 30-35 cm from surface <b>Fluid Delivery</b> <b>240-300 mL per minute</b>	Accelerator aids in dry to tape, Will increase orange peel/texture Gloss may die back Apply first (1st) coat in medium wet application 65% overlap. Follow with a wet second (2nd) coat after clear has been refreshed.

Customer Name

Distributor Name

