



Imron® Industrial Strength Ultra Low VOC Polyurethane Clear Reduced Gloss Modifications



GENERAL

DESCRIPTION

Imron Industrial Strength Clear, 9C01™, is a high gloss, high performance clear coat designed to be used to add extra appearance and performance to existing systems. Occasionally, a reduced gloss position is desired when using clear coats. This reduced gloss position can be achieved with the use of 9C01 High Gloss clear and 9T20™ Flattener. Imron Industrial Strength Ultra Low VOC Polyurethane Clear 9C01™, when combined with 9T20, is a 0.3 lbs/gal VOC conforming, low HAPS, polyurethane reduced gloss clear coat. The resulting finish product provides a brush, roll or sprayable topcoat, suitable for use in any environment where additional long term color and reduced gloss are desired.

SUGGESTED USES

As a high performance, tough, industrial strength polyurethane clear coat over properly prepared, primed and top-coated aluminum, carbon steel, galvanized, concrete or dry wall where:

- The extra protection of a clear is desired.
- Outstanding color protection without gloss is desired
- Low environmental footprint is desired
- Application by brush, roll or spray is desired (spray recommended)
- Excellent chemical resistance
- Outstanding flexibility is needed
- Faster dry times are desired

COMPATIBILITY WITH OTHER COATINGS

- Aged Imron Industrial Strength Reduced Gloss Clear may be re-coated with itself following washing with clean, fresh water – no mechanical surface preparation is required.
- Imron Industrial Strength Reduced Gloss Clear can be applied over other Axalta coatings including, but not limited to Imron Waterborne Polyurethane Copolymer coatings, Imron Industrial Strength topcoats, and other Imron solvent-borne topcoats.
- Imron Industrial Strength Reduced Gloss Clear may be used over most aged and hard-cured coatings in good condition. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact your Axalta representative for specific recommendations.

NOT RECOMMENDED FOR

Immersion Service

Use caution for brush and roll applications: for small touch up areas only and with controlled application techniques

PERFORMANCE PROPERTIES

Abrasion & Mechanical	Excellent
Alkalis	Excellent
Humidity	Excellent
Solvents	Very Good
Color & Gloss Retention	Excellent
Acids	Excellent
Salts	Excellent
Weather	Excellent

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Clear 9C01	1 gallon container 80% Full (102.4 oz.)
9T20 Flattener	1 gallon container 100% Full (128 oz.)
Activator – 9T00-A™	pint container 100% Full (16 oz.)

MIX RATIO

Reduced Gloss Mixing Ratios

To achieve variable gloss ranges, the following ratios can be used as a guide:

<u>Approximate Gloss Range (@60°)</u>	<u>9C01</u>	<u>9T20</u>
Flat (0-10 °)	2 parts	3 parts
Satin Gloss (25-45 °)	1 part	1 part
Semi-Gloss (50-65 °)	3 parts	2 parts



APPLICATION

SURFACE PREPARATION

Newly primed and top-coated surfaces should be clean and dry. If contaminated, detergent/water wash, then blow dry. Previously painted surfaces should have all loose paint removed and the edges feathered. Prime bare spots with appropriate primer, then restore color before applying clear.

ACTIVATION

To 8 parts Imron Industrial Strength Clear, 9C01 and 9T20 mixture, add one part Axalta Imron 9T00-A Activator. Measure out appropriate amounts, add activator and mix thoroughly. For most applications, add 10-20% Imron 9M01™ or 9M02™ Thinner reducer depending upon application conditions and methods. Mix until uniform. (See reduction section below.) Mix thoroughly using a mechanically powered sheer “Jiffy” mixer with variable RPM settings; use medium speed RPM. Move mixer up and down through paint for uniform mixing. DO NOT SHAKE.

REDUCTION

Normally 10-20% reduction with Imron 9M01 or 9M02 Reducer is adequate for spray application, pressure pot and airless, depending upon conditions and equipment. To help maximize pot life, up to 25% may be added. For maximum appearance, up to 25% Imron 9M01 or 9M02 may be added. For brush applications, add 10-15% 9M01 or 9M02 Thinner. For rolling applications, add 1 oz of Imron 9M05™ Rolling Additive per activated gallon and 10-15% 9M01 or 9M02 Reducer. After addition of 9M05 Rolling Additive, allow 5 minutes induction before application. If faster recoat and handling are required, add up to 1 oz. VG-805™ Accelerator. Use of 9M02™ Pot Life Extender / Reducer will affect VOC. Please see VOC section. For cold weather application, add 1 oz. of VGY-691™. Use only recommended reduction solvents.

APPLICATION THINNERS

Spray, Brush and Roll – Below 80°F	Imron 9M01	Rolling Additive - Imron 9M05
Spray, Brush and Roll – Above 80°F	Imron 9M02	

CLEAN UP THINNERS

Imron 9M01, T-1021

APPLICATION CONDITIONS

Do not apply if the application surface temperature is below 45°F (7°C) or above 110°F (43°C), or if the atmospheric temperature is within 5°F of the dew point. For application temperatures below 45°F, the use of 1 oz. Imron VHY-691 is recommended. Relative humidity should be below 90%. Dry times can be improved by adding up to 2 oz. of Axalta VG-805 Accelerator per activated gallon. If accelerators have been used, recoating must be done within 48 hours. If more time has elapsed, scuff sand to ensure adhesion. May be recoated by spray when tack-free.



APPLICATION EQUIPMENT

- Apply by spray, brush or roll
- Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

ROLL

Manufacturer: Wooster® Pro/Doo-Z™ ¼” – ½” nap

- Add 1 oz./gallon Imron 9M05 Rolling Additive to eliminate bubbles. Craters may develop if you exceed 2 oz./gallon.
- Add 10-15% Imron 9M01 or 9M02 reducer to maintain wet edge.
- May be cross-rolled.
- For best results, allow 5 minutes mix time after adding Imron 9M05.
- Do not use Imron 9M05 in spray applications.

BRUSH

Manufacturer: Wooster® China Bristle

- Add 10-15% Imron 9M01 or 9M02 reducer to maintain wet edge. Do not cross brush to reduce lap marks.

CONVENTIONAL

Manufacturer | Model | Tip Size

Sata	K3 RP	1.0-1.3mm
Devilbiss	JGA, MBC	1.1-1.4mm
Graco	DeltaSpray XT	1.0-1.5mm
Iwata	W-77, W-71, or W-200	1.2-1.4mm
Binks	2001 or 95	1.2-1.3mm
Kremlin	M22HPAP	1.2-1.8mm

*Fluid lines 3/8” ID or larger are required for proper fluid delivery.

HVLP SPRAY

Manufacturer | Model | Tip Size

Sata	3000RP HVLP	1.2-1.6mm
Devilbiss	JGVH, EXL, or FLG	1.3-1.8mm
Graco	DeltaSpray XT - HVLP	1.3-2.2mm
Iwata	LPH 200 L VLP	0.8-1.2mm
Binks	Mach 1 & 1SL	1.0-1.7mm
Kremlin	E3K HVLP	1.5-1.8mm

AIRLESS SPRAY

Graco	Silver or Plus	Airless tip size .011 - .015	Pump 30:1 min
Iwata	ALG or Airlessco Guns	Airless Tip Size .011 - .015	Pump ALG 30:1 min
Binks	Airless 1	Airless Tip Size .011 - .017	Pump 30:1 min
Kremlin	Airless 250 II	Airless Tip Size .013 - .017	Pump Orca 32:1



DRY TIMES

Cure Time At Recommended Thickness 1.5 to 2 mils DTF 77°F (25°C) and 50% RH

	77°F (25°C) and 50% RH		90°F (32°C) and <25% RH	
	20% 9M01 Reducer Without VG-805	20% 9M01 Reducer With 2 oz. VG-805	20% 9M02 Reducer Without VG-805	20% 9M02 Reducer With 2 oz. VG-805
Dry to Touch	3	1	2	1
Tack Free	3	2	2	1
To Handle	4.5	2	3.5	2
To Recoat	4	2	3	2
Hard Dry	18	12	16	10
Pot Life	1.5	2	3	2
Full Cure	7 days	6 days	7 days	6 days

Note: Dry times are based upon high gloss. Some times may change due to addition of flattener.



PHYSICAL PROPERTIES

Maximum Service Temperature	250°F (93°C) in continuous service 300°F (148°C) in intermittent heat
Volume Solids	46%
Weight Solids	46%
Theoretical Coverage Per Gallon	724 ft ² (17.7 m ² /l) @ 1 mil dft 362 ft ² (8.9 m ² /l) @ 2 mil dft Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements
Weight Per Gallon	9.2 lbs/gal - average varies with color
Shipping Weight (approximate)	
1 gallon container:	10 lbs
Quart Activator:	2-3 lbs
Suggested Film Thickness	3-5 mils (75-125 µm) wet 2-3 mils (50 – 75 µm) dry Application by brush and roller may require additional coats to achieve recommended films thickness.
Flash Point	Between 73° to 100°F (23° to 38°C)
Gloss	Reduced gloss
Shelf Life	12 months minimum

Storage Conditions
 Store in a dry, well-ventilated area. Storage conditions should be between 35°F (2°C) and 120°F (48°C)

Mixed reduced gloss levels will have the properties of both the 9T20™ Flattener and 9C01™ Clear. Please consult MSDS for both products for proper protective equipment and safety and health information.

VOC REGULATIONS

VOC (Theoretical less water and exempt compounds).
 This product contains TBAC.

	8 to 1 25% Reduction TBAC Exempt*			8 to 1 25% Reduction TBAC Non-Exempt		
	No Reduction	9M01	9M02	No Reduction	9M01	9M02
Without 1 oz VG-805	0.3	--	--	2.3	--	--
With 1 oz VG-805	--	0.4	1.0	--	2.4	2.9

*Where TBAC is considered an exempt solvent for contains requirements.

HAPS INFORMATION – THEORETICAL

Imron Industrial Strength Clear – Mixed 8 to 1 no reduction – 0.01 lbs/gal solids
 Imron Industrial Strength Clear – Mixed 8 to 1 with 25% Imron 9M01 or 9M02 Thinner and 1 oz. VG-805 Accelerator – 0.01 lbs/gal solids

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.



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.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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