

# Imron® Industrial Strength Low VOC Polyurethane Primer



## GENERAL

### DESCRIPTION

The newest generation of Imron technology. Based upon unique Axalta formulations and resin technology, Imron Industrial Strength is engineered to be the fastest Imron yet, with the lowest environmental impact. Imron Industrial Strength Low VOC Polyurethane Primer is formulated as a durable, fast dry, high solids, two-package, VOC conforming, 0.8 lbs/ gal, for most conditions, low HAPS product based on Axalta polyurethane technology. The resulting product is designed to deliver high performance and provides a smooth surface for maximum topcoat appearance.

### SUGGESTED USES

As a high performance, tough, industrial strength polyurethane primer over properly prepared aluminum, carbon steel, galvanized or fiberglass where:

- A smooth primer will provide maximum topcoat appearance
- Low VOC and HAPS will reduce the environmental footprint
- Application by brush, roll or spray is desired
- Outstanding flexibility is needed
- Faster dry times are desired
- Wet on wet applications
- Application down to 35°F

### COMPATIBILITY WITH OTHER COATINGS

Imron Industrial Strength Primer can be top coated with other Axalta products including, but not limited to: Imron Industrial Strength topcoats, High Gloss (GN), Semi Gloss (GO), Satin Gloss (GP) and Flat (GQ), Imron 2.1 HG, Imron 2.1 SG, Imron 2.1 ST, Imron 2.1 FT and Imron 3.5 HG, Imron 3.5 SG, Imron 3.5 ST, Imron 3.5 FT.

Imron Industrial Strength Primer 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

### PERFORMANCE PROPERTIES

Abrasion & Mechanical	Excellent	(when used with appropriate topcoat)
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.

### COLOR

Imron Industrial Strength Primer is available in the following colors:

- 9P01 White
- 9P02 Red Oxide
- 9P03 Black

Note: To reach a medium grey color, mix 9 parts white to one part black



## MIXING

### COMPONENTS

9P0X Primer Base  
9T00-A Activator

1 gallon container 100% full (128 oz)  
pint container 100% full (16 oz.)

### MIX RATIO

#### Component

Imron 9P0X Primer Base  
Imron 9T00-A Activator

#### Part by Vol.

8  
1



## APPLICATION

### SURFACE PREPARATION

For best results, all surfaces must be clean, dry and free of rust, oil, grease and all other contamination. All surfaces should be cleaned with solvent (SSPC-1) to remove oils and greases. SSPC-SP6 Commercial Blast Cleaning will provide very good results. Surface profile should be 2-2.5 mils. If blasting is not possible or practical, then Hand Tool Clean to an SSPC SP -2 or Power Tool Cleaned to an SSPC SP -3 with some sacrifice in performance. Newly primed surfaces should be clean and dry before application of topcoats. If contaminated, detergent/water wash, then blow dry. For optimum appearance of topcoat, Imron Industrial Strength Primer may be sanded with 320 grit sand paper.

### ACTIVATION

Thoroughly mix all colored portions until uniform. To 8 parts 9PXX Primer base, add one part Axalta Imron 9T00-A Activator. Measure out appropriate amounts, add activator and mix thoroughly. For most applications, add 10 – 15% Imron 9M01, 9M02 or T-1022 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.**

**Note: Upon activation of 8:1 with 9T00-A Activator, the mix produces 1.125 gallons. 1 full gallon of 9PXX Primer Base to 1 pint (0.125 gal) of activator for a total of 1.125 gallons.**

### REDUCTION

Normally 10-15% reduction with Imron 9M01, 9M02 or T-1022 Reducer is adequate for spray application, pressure pot and airless, depending upon conditions and equipment. To help maximize pot life, up to 20% may be added. For brush applications, add 5-10% 9M01, 9M02 or T-1022 Thinner. For rolling applications, add 1 oz of Imron 9M05 (RT002P) Rolling Additive per activated gallon and 5-10% 9M01, 9M02 or T-1022. After addition of 9M05 (RT002P) Rolling Additive, allow 5 minutes induction before application. If faster recoat and handling are required, add up to 2 oz. VG-805 Accelerator. For cold weather application, use VHY-691 at 2 oz. per gallon. Use only Axalta recommended thinners. If accelerators have been used, recoating must be done within 72 hours. If more time has elapsed, scuff sand to ensure adhesion.

### APPLICATION THINNERS

Spray, Brush and Roll – Below 80°F    Imron 9M01 or T-1022  
Spray, Brush and Roll – Above 80°F    Imron 9M02  
Rolling Additive - Imron 9M05

### 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 2 oz. Imron VHY-691 is recommended. Relative humidity should be below 90%.

**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 5-10% Imron 9M01, 9M02 or T-1022 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 5-150% Imron 9M01, 9M02 or T-1022 reducer to maintain wet edge. Do not cross brush to reduce lap marks.

**CONVENTIONAL**

Manufacturer | Model | Tip Size

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

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

**HVLP SPRAY**

Manufacturer | Model | Tip Size

Sata	DeVilbiss	Graco	Iwata	Binks	Kremlin
3000RP	JGHV, EXL, or	DeltaSpray	LPH 200 LVLP	MACH 1 & 1SL	E3K HVLP
HVLP	FLG	XT - HVLP			
1.2 – 1.6 mm	1.3 - 1.8 mm	1.3 – 2.2 mm	0.8 – 1.2 mm	1.0 – 1.7 mm	1.5 – 1.8 mm

**AIRLESS SPRAY**

Manufacturer  
Model

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



**DRY TIMES**

Cure Time At Recommended Thickness 3 to 5 mils DTF 75°F (23°C) and 50% RH

	75°F (23°C) and 50% RH		90°F (32°C) and <25% RH	
	10% T-1022	10% T-1022	10% T-1022	10% T-1022
	<u>Without VG-805</u>	<u>With 2 oz. VG-805</u>	<u>Without VG-805</u>	<u>With 2 oz. VG-805</u>
Dust free	15 min	15 min	45 min	10 min
To recoat	1 hr 15 min	45 min	1 hr 15 min	15 min
Tack free	2 hr 45 min	1 hr 15 min	2 hours	20 min
Hard Dry/Handle	3 hr 25 min	1 hr 15 min	2 hr 20 min	30 min
Pack/Ship	8-10 hours	3 hours	3-5 hours	2 hours
Pot Life	4 hours	2 hours	3 hr 30 min	1 hr 30 min



## PHYSICAL PROPERTIES

Maximum Service Temperature	250°F (93°C) in continuous service 300°F (148°C) in intermittent heat	
Some yellowing of light colors may occur at elevated temperatures.		
Volume Solids	53 % +/- 2%	
Weight Solids	68% +/- 2%	
Theoretical Coverage Per Gallon	850 ft <sup>2</sup> (20.9 m <sup>2</sup> /l) @ 1 mil dft 283 ft <sup>2</sup> (6.9 m <sup>2</sup> /l) @ 3 mil dft	
Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.		
Weight Per Gallon	11.2 – 11.5 lbs/ gal - average varies with color	
Shipping Weight (approximate)	1 gallon container:	12-13 lbs
	Pint activator:	1-2 lbs
Suggested Film Thickness	6-10 mils (150-250 µm) wet 3-5 mils (75-125 µm) dry	
Application by brush and roller may require additional coats to achieve recommended films thickness.		
Flash Point	Between 20° to 73°F (-6° to 22.77°C)	
Gloss	85° angle - 30 – 35 60° angle - 4.5– 5.5	
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)

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 15% Reduction TBAC Exempt*			8 to 1 10% Reduction TBAC Non-Exempt		
	<u>9M01</u>	<u>9M02</u>	<u>T-1022</u>	<u>9M01</u>	<u>9M02</u>	<u>T-1022</u>
Without 1 oz VG-805	0.61	1.05	0.60	2.09	2.30	2.09
With 1 oz VG-805	0.61	1.05	0.60	2.09	2.30	2.09

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

## HAPS INFORMATION – THEORETICAL

Imron Industrial Strength Primer – Mixed 8 to 1, 15 % reduction with Imron 9M01, 9M02 or T-1022 Thinner – 0.022 lbs/gal solids

Imron Industrial Strength Primer – Mixed 8 to 1, 15 % reduction with Imron 9M01, 9M02 or T-1022 Thinner and 2 oz VG-805™ - 0.023 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.

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## ASTM INFORMATION

Physical properties are averages. Properties for Imron Industrial Strength Primer 9P01 and Imron Industrial Strength Topcoat 9T11. For other system recommendations, please contact Axalta Coating Systems.

Paint System: Imron Industrial Strength Primer 9P01  
Imron Industrial Strength Topcoat 9T11  
Type | Color: Urethane, white | Urethane, white  
DFT: 6.0 mils = Primer 4.0, Topcoat 2.0

Salt Fog (ASTM B117, D714, D1654)	Blasted Steel (SSPC-SP6) 1000 hours Scribe rating – 10 Blister rating – 2 few around scribe only
Humidity (ASTM D2247)	Bonderite Steel B 1000 1000 hours Blister rating – 8 medium
Cleveland Condensation (ASTM D4585)	Bonderite Steel B 1000 1000 hours Blister rating – 8 few
Impact (ASTM D2794)	No failure at 80 inch lbs
Mandrel Bend (ASTM D522)	Passes 1/8" No failure
Chip Resistance (ASTM D3170)	8 (Scale rating 0 – 10. 10 best)
Pencil Hardness (ASTM D3363)	5 H

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## 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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