

# Imron® Industrial Strength 9C01 Ultra Low VOC Polyurethane Clearcoat Reduced Gloss Modifications



## GENERAL

### DESCRIPTION

A high gloss, high performance clearcoat designed to add extra appearance and performance to existing systems.

A reduced gloss position can be achieved by combining 9C01 High Gloss clearcoat and 9T20 Flattener. This combination results in a 0.3 lbs./gal VOC conforming, low HAPS, polyurethane reduced gloss clearcoat for brush, roll or spray application suitable for any environment where additional long term color and reduced gloss are desired.

### SUGGESTED USES

As a high performance, tough, industrial strength polyurethane clearcoat 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 Clearcoat may be re-coated with itself following washing with clean, fresh water-no mechanical surface preparation is required.
- Imron Industrial Strength Reduced Gloss Clearcoat 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 or call 1-855-6-AXALTA

### 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



## MIXING

### COMPONENTS

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

### MIX RATIO

Use the following reduced gloss mix ratios as a guide to achieve variable gloss ranges:

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

### ACTIVATION

Combine components and mix thoroughly until uniform 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.

Component	Part by Vol.
9C01 Clearcoat and 9T20 Flattener mixture	8
Imron 9T00-A Activator	1
9M01 or 9M02 Thinner (Optional*)	10-20%

### \*REDUCTION

- 10-20% reduction with Imron 9M01 or 9M02 Reducer is adequate for spray application, pressure pot and airless, depending upon conditions and equipment.
- Use of 9M02™ Pot Life Extender / Reducer will affect VOC. Please see VOC section.

### ADDITIVES

- To maximize pot life: add up to 25% Imron 9M01 or 9M02.
- For maximum appearance: add up to 25% Imron 9M01 or 9M02.
- For cold weather application: add 1 oz. of VGY-691. Use only recommended reduction solvents.
- For brush applications: add 10-15% 9M01 or 9M02 Thinner.
- For roll applications: add 1 oz. of Imron 9M05 Rolling Additive per activated gallon and 10-15% 9M01 or 9M02 Reducer. After the addition of Imron 9M05, allow 5 minutes induction before application.
- For faster recoat and handling: add up to 1 oz. VG-805 Accelerator.
- To improve dry time: Add up to 2 oz. of Axalta VG-805 Accelerator per activated gallon.

### APPLICATION THINNERS

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



## 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.

### 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%. 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.

**ROLL APPLICATION**

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 APPLICATION**

Manufacturer: Wooster® China Bristle

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

**SPRAY APPLICATION**

**Conventional**

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

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

**HVLP**

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

**AIRLESS**

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

**CLEAN UP THINNERS**

Imron 9M01, T-1021



## 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	20% 9M01 And 2 oz. VG-805	20% 9M02	20% 9M02 And 2 oz. VG-805
Dry to Touch	3 hours	1 hours	2 hours	1 hours
Tack Free	3 hours	2 hours	2 hours	1 hours
To Handle	4.5 hours	2 hours	3.5 hours	2 hours
To Recoat	4 hours	2 hours	3 hours	2 hours
Hard Dry	18 hours	12 hours	16 hours	10 hours
Pot Life	1.5 hours	2 hours	3 hours	2 hours
Full Cure	7 days	6 days	7 days	6 days

Note: Dry times are based upon high gloss. Sometimes 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 <sup>2</sup> (17.7 m <sup>2</sup> /l) @ 1 mil DFT 362 ft <sup>2</sup> ( 8.9 m <sup>2</sup> /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.

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In the United States:  
**1.855.6.AXALTA**  
[axalta.us/industrial](http://axalta.us/industrial)

In Canada:  
**1.800.668.6945**

