



Imron® 2.1 PR™ Polyurethane Primer



GENERAL

DESCRIPTION

A two-package, VOC conforming (2.1 lbs/gal) low HAPS primer based on Axalta polyurethane technology. The resulting primer is designed to deliver a smooth surface for maximum topcoat appearance.

PERFORMANCE PROPERTIES

Adhesion	Excellent
Solvent Resistance	Very Good
Chemical Resistance (watch glass)	Very Good
Color & Gloss Retention	Excellent
Salt Fog & Humidity	Excellent

SUGGESTED USES:

As a high performance primer coating on properly prepared carbon steel, galvanized steel, aluminum or fiberglass where:

- A sandable primer will produce a smooth surface for maximum topcoat appearance
- Low VOC and low HAPS will reduce the environmental footprint
- Outstanding flexibility/ chip resistance is required
- Application by brush and roller, in addition to spraying, may be necessary
- Fast dry to recoat and handling times will improve productivity

NOT RECOMMENDED FOR:

- Immersion Service
- Highly Corrosive environments
- Marginally prepared surfaces

COMPATIBILITY WITH OTHER COATINGS

Imron 2.1 PR can be topcoated with other Axalta coatings including, but not limited to Imron 2.1 HG polyurethane enamel, Imron 1.2 HG™, Imron 1.5 ST-D™, and Imron 3.5 HG™ high gloss and variable gloss polyurethane enamels. Imron 2.1 PR™ 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.

Imron 2.1 PR **should not be** topcoated with epoxies. However, Imron 2.1 PR can be applied over epoxies such as Corlar® 2.8 PR™, Corlar 2.1 PR-P™, Corlar 2.1 ST™, Corlar LV SG™, when additional corrosion protection is desired.

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

COLOR

162-1632™ White	162-1060™ ANSI 70 Gray	162-711™ Red Oxide
162- 705™ Buff	162-1072™ ANSI 61 Gray	162-1640™ Black



MIXING

COMPONENTS

Imron 2.1 PR	1 gallon (80% full)
FG-0162™ Activator	1 quart (80% full)

MIX RATIO

Component	Part by Vol.
Imron 2.1 PR (162-XXXXX)	4
FG-0162Activator	1

ACTIVATION

4 parts Imron 2.1 PR (162-XXXXX) to 1 part FG-0162

MIXING AND REDUCTION

Thoroughly mix 4 parts Imron 2.1 PR (162-XXXXX) primer base. To it add 1 part Imron FG-0162 Activator. Mix until all ingredients are uniform. 0-5% Reduction is adequate for brush, roll and spray applications, under most conditions. To maximize pot life, reduce 5% with T-1022 thinner.

- Can be accelerated with VG-805 Accelerator, 2 oz per RTS gallon.
- When rolling, add 1 oz/mixed gallon of RT002P™

APPLICATION THINNERS

Brush, Roll or Spray - T-1022- 0-5%

INDUCTION TIME

None

POT LIFE

@ 70°F (21°C)	
With 2 oz. VG-805	1.5 hours
With 2 oz. VG-805 (with 5% T-1022)	1.5 hours
Without accelerator (with 5% T-1022)	2.5 hours



APPLICATION

APPLICATION CONDITIONS

Do not apply if the application surface or ambient temperature is below 50°F (10°C) or above 95°F (35°C), or if the atmospheric temperature is within 5°F of the dew point. Relative Humidity should be below 90%.

SURFACE PREPARATION

For best results, all surfaces must be clean, dry and free of loose rust, oil, grease, and all other contamination. SSPC-SP-1 Solvent Cleaning should be done at a minimum. For best results, prepare surface to an SSPC-SP-6 Commercial Blast. Or sand with 220 grit sandpaper to roughen surface.

APPLICATION EQUIPMENT

Apply by spray for best results. Imron 2.1 PR may also be applied by brush or roller with some sacrifice in appearance.

Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

Roller

Wooster® Pro/Doo-Z®, ¼" – ½" nap

Brush

Wooster Nylon Bristle



Conventional Spray

Manufacturer	Model	Tip Size
Sata	K3 or 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	1.2-1.8mm
Binks	2001 or 95	1.2-1.8mm
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

CLEAN UP THINNERS

Use Axalta Y32035™ or T-1022. Dispose of waste following local guidelines.



DRY TIMES

Cure Time At Recommended Thickness @ 77°F (25°C), 50% RH

	Without Accelerator + 5% T-1022	With 2 oz VG-805 + 5% T-1022
Dry to Touch	1.5 hrs	30 min
Dry to Recoat	3 hrs	45 min
Dry to Handle	5-6 hrs	1.5 hrs
Pack/Ship	8-12 hrs	3 hrs
Pot Life	2.5 hrs	1.5 hrs

- Higher temperatures and air flow will reduce dry times.
- Can be topcoated wet-on-wet with Imron topcoats after a 15 – 20 minute flash.
- When applying waterborne coatings on top of Imron 2.1 PR, DOUBLE recoat times listed.
- For max pot life, reduce 5% with T-1022 thinner.

To ensure optimum adhesion, Imron 2.1 PR should be topcoated within 72 hours. When allowed to sit for longer than 72 hours, Imron 2.1 PR must be sanded. If recoating Imron 2.1 PR with itself, sanding is also required if primer has been force dried or has been allowed to air dry more than 16 hours.

Product can be force dried 30 min at 130 -180°F.

For optimum appearance, Imron 2.1 PR can be sanded using 320 grit sandpaper or finer.



PHYSICAL PROPERTIES

Maximum Service Temperature:	250°F (121°C)
Gloss (ASTM D 523)	Satin gloss 30-35 @ 60° angle
Weight Solids (Avg. varies by color):	68% ± 1%
Weight per gallon-(Avg. varies by color):	10.8 lbs. ± 2%
Flash Point-Tag Closed Cup:	20 – 70°F (-7 to 23°C)
Volume Solids (Avg. varies by color):	53% ± 1%
Shipping Weight (varies by color):	1 gallon container – 11 lbs
Shelf Life:	1 year minimum
Theoretical Coverage Per Gallon*:	850 ft ² (20.8m ² /L) @ 1 mil DFT 283 ft ² (6.93 m ² /L) @ 3 mils DFT
Suggested Film Builds**:	6 – 8 mils (150 – 200 µm) wet (WFT) 3 – 4 mils (75 – 100 µm) dry (DFT)

*Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

**Application by brush and roller may require additional coats to achieve recommended films thickness.

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between -30°F (-34°C) and 120°F (48°C).

THEORETICAL VOC (LESS WATER AND EXEMPT COMPOUNDS)

Activated 4:1 with FG-0162 and with 5% T-1022	<2.1 lbs./gal
Activated 4:1 with FG-0162, 2 oz VG-805 and 5% T-1022	<2.2 lbs./gal.

HAPS

Activated 4:1 with FG-0162 and with 5 % T -1022	<0.1 lbs./gal. solids
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ASTM INFORMATION

Performance properties are for Imron 2.1 PR and Imron 2.1 HG High Gloss Polyurethane Topcoat. Properties may be enhanced by use of appropriate primers. For other system recommendations, please contact Axalta.

Paint System:	Imron 2.1 PR Imron 2.1 HG	
Type Color:	Urethane/Urethane	Color: Ansi 61 Grey/White
DFT:	2 4 mils	

TEST

Salt Fog (ASTM B117)
(ASTM D 714) (ASTM D 1654)

RESULTS

Blasted Steel(SSPC-SP 6)

	2000 Hours	Scribe rating 10 Blister rating 2 few
	3000 Hours	Scribe rating 10 Blister rating 2 few
Humidity (ASTM D2247)	Bondrite Steel B 1000	
	2000 Hours	Blister rating 8 medium
	3000 Hours	Blister rating 8 medium
Cleveland Cond. (ASTMD4585)	Bondrite Steel B 1000	
	2000 Hours	Blister rating 10 (no blistering)
	3000 Hours	Blister rating 8 few
Impact (ASTM D2794)	48 inch lbs (forward)	
Mandrel Bend	Passes 1/8" No failure	
Chip Resistance	8	(Scale 0-10, 10=best)
Pencil Hardness	5H (primer alone)	



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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