

Imron® 2.8 FT-C Flat Polyurethane Clearcoat



GENERAL

DESCRIPTION

An aliphatic polyurethane enamel, high-solids, two-package, VOC conforming product (2.8 lbs./gal.) based on unique Axalta resin technology, producing properties of both polyester and acrylic polyurethanes. This clearcoat is designed to be a highly durable finish that delivers industry leading polyurethane performance.

SUGGESTED USES

As a high performance clear topcoat over finishes in sound condition on steel, galvanized steel, stainless steel, aluminum, concrete, concrete block, fiberglass, plastics and wood where:

- Restoring faded finishes without gloss avoids the cost of complete re-painting
- Outstanding color protection without gloss is desired
- Resistance to chemical and/or marine environments is required
- Application must be made at temperatures as low as 35°F

COMPATIBILITY WITH OTHER COATINGS

- Imron 2.8 FT-C can be applied over other Axalta coatings including, but not limited to, Imron solventborne polyurethanes, Imron waterborne polyurethane copolymer coatings, Corlar® epoxies, Tufcote™ acrylics and Tufcote alkyd primers. See Re-Coat Section for additional details.
- Imron 2.8 FT-C 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 Abuse	Excellent
Adhesion	Excellent
Acids	Excellent
Alkalis	Excellent
Color & Gloss Retention	Excellent
Cutting Oil	Excellent
Humidity	Very Good
Salts	Excellent
Solvents	Very Good
Weather	Excellent

COLOR

Clear

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



MIXING

COMPONENTS

Imron 2.8 FT-C (613P) Clearcoat 1 gallon container 75% Full
VGY-611 Activator quart container 100% Full

MIX RATIO

Component	Part by Vol.
Imron 2.8 FT-C (613P) Clearcoat	3
VGY-611 Activator	1

Gloss Adjustment Ratios

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

Imron 613P	+ Imron 611P	= Approximate Gloss Range (@60°)
1 part	--	<10
2 parts	1 parts	15-25
1.5 parts	1.5 parts	40-50
1 part	2 parts	75-85

ACTIVATION

Thoroughly mix 3 parts Imron 2.8 FT-C (613P) Enamel, then add 1 part Imron VGY-611 Activator while stirring. No induction period is necessary.

Note: Enamel is short-filled to allow for addition of activator. Do not shake. If air bubbles are excessive as a result of stirring, agitating or boxing the base material, allow the bubbles to dissipate prior to activation.

REDUCTION

Normally 0-3% (1-4 oz.) reduction is adequate for spray application depending upon conditions and equipment. Maximum reduction should not exceed 3%. Use Axalta 68083™ Thinner. If faster recoat and handling is required, add up to 2 oz./gal VG-805 Accelerator.

ADDITIVES & APPLICATION THINNERS

Spray: Axalta 68083
Acceleration: VG-805 Accelerator
Brush & Roll: Not recommended due to uneven appearance

INDUCTION TIME

None

POT LIFE

1.5 – 2 hours @ 77°F (25°C) & 50% RH
Higher temperatures and humidity will severely shorten pot life.



APPLICATION

SURFACE PREPARATION

Newly primed 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. See Re-Coat section for additional details.

APPLICATION CONDITIONS

This product is best applied by spray. 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 best results, application temperature should be between 65°F and 85°F. Relative Humidity should be below 90%. For application temperatures below 45°F, the use of VG-805 Accelerator is required. Mix only amounts that can be applied within a 1.5 – 2 hour period.

APPLICATION EQUIPMENT

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

SPRAY APPLICATION

Conventional Pressure Fed Liquid		Tip Size
Sata	K3 RP or LM 3000 RP	1.0-1.3mm
Devilbiss	JGA, MBC, or FLG	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 Pressure Fed

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

For airless spray application, tip size must not exceed .011".

Air Assisted Airless Spray		Tip	Cap
Graco	AA4000 HVLP	.021 - .027	AA10HP
	Alpha or Alpha Plus	.015 - .021	
Sata	Shark 32:1 or Dolphin 14:1	.011-.018	K3 spray mix
Iwata	MSG 2000 Gun		
	MSU11 13:1 or MSU32 17:1	.011 - .018	
Binks	AA 1500	.013 - .019	
Kremlin	Airmix MVX	.011 - .020	

Fluid lines > 1/4" ID are recommended for lengths up to 25', 3/8" ID or larger are required for proper fluid delivery at lengths longer than 25'.

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

Axalta 68083 or MEK



DRY TIMES

Cure Time At Recommended Thickness 2.0 to 2.5 mils DTF 77°F (25°C) and 50% RH

	Without Accelerator	With 2 oz. VG-805
Dry to Touch	4-6 hrs	1 hr
To Recoat	10-12 hrs	1.5 hrs
To Handle	10-12 hrs	2.5 hrs
Pack Ship	24 hrs	5-6 hrs
Pot Life	1.5-2 hrs	3 hrs
Full Cure	7 days	5 days

RE-COAT

May be recoated by spray when tack-free.

For best results when applying Imron 2.8 FT-C over itself or over other Imron product, the clear should be applied within 72 hours @ 77°F. If more than 72 hours has elapsed, the surface should be scuffed with very fine (400-600 grit) sand paper before applying the Imron 2.8 FT-C.

If accelerators have been used, recoating must be done within 48 hours. If more time has elapsed, scuff sand to ensure adhesion



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	52% ± 2%
Weight Solids	62% ± 2%
Theoretical Coverage Per Gallon	834 ft ² (20.5 m ² /l) @ 1 mil DFT 417 ft ² (10.2 m ² /l) @ suggested DFT of 2 mil
Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.	
Weight Per Gallon	8.85 lbs./gal ± 0.2 lbs. – avg. varies with color
Packaging Clear	1 gallon (75% fill)
Activator	quarts (100% fill)
Shipping Weight (approximate)	
Clear	1 gallon: 8 lbs.
Activator	1 quart: 3 lbs.
Suggested Film Thickness:	3-4 mils (75-100 µm) wet 1.5-2 mils (37-50 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 23°C)
Gloss (ASTM D523):	>90 measured at 60° angle
Shelf Life:	12 months minimum

STORAGE CONDITIONS

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

Rotate stock and invert cans every 30 days to prevent hard settling. If settling occurs, reincorporate by manually breaking up the solids and shaking or power mixing for 30 minutes.

Mixed product will have the properties of all mixing components. Please consult MSDS for both products for proper protective equipment and safety and health information.

VOC REGULATIONS

VOC (Theoretical less water and exempt compounds).

Mixed VOC, no reduction 2.8 lbs./gal. (336 g/l)

Mixed VOC, 3% reduction w/ 68083 or 2 oz. VG-805 Accelerator 3.0 lbs./gal. (360 g/l)

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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1.855.6.AXALTA
axalta.us/industrial

In Canada:
1.800.668.6945

