Imron® 2.8 PR
Polyurethane Primer

GENERAL

DESCRIPTION
A two-package, VOC conforming (2.8 lbs/gal) Low HAPS primer based on Axalta polyurethane technology. The resulting flexible primer delivers a smooth surface for maximum topcoat appearance.

PERFORMANCE PROPERTIES

Adhesion	Excellent	(under appropriate topcoat)
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 or direct-to-metal (DTM) coating on properly prepared carbon steel, galvanized steel, or Aluminum, 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 2.8 PR can be topcoated with other Axalta coatings including, but not limited to Imron 2.8 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 2.8 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

62-1632 White	62-1060 ANSI 70 Gray	62-711 Red Oxide
62- 705 Buff	62-1072 ANSI 61 Gray	62-1640 Black

MIXING

COMPONENTS

Imron 2.8 PR	1 gallon (80% full) 5 gallons (4-gallon fill)
FG-062 Activator	1 quart (80% full) 1 gallon (full)

MIX RATIO

Component	Part by Vol.
Imron 2.8 PR (62-XXXXX)	4
FG-062 Activator	1

ACTIVATION

4 parts Imron 2.8 PR (62-XXXXX) to 1 part FG-062

MIXING AND REDUCTION

Thoroughly mix 4 parts Imron 2.8 PR (62-XXXXX) primer base. To it add 1 part Imron FG-062 Activator. Mix until all ingredients are uniform. No further reduction is required.

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

APPLICATION THINNERS

None

INDUCTION TIME

None

POT LIFE

@ 77°F (25°C)

With 2 oz. VG-805	1.5 hours
Without accelerator	1 hour

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 2.8 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 @ 70°F (25°C), 50% RH

	Without Accelerator	With 2 oz VG-805
Dry to Touch	2 hrs	30 min
Dry to Recoat	4 hrs	1 hr
Dry to Handle	5-6 hrs	1.5 hrs
Pack/Ship	8-12 hrs	3 hrs
Pot Life	1 hr	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.

To ensure optimum adhesion, Imron 2.8 PR should be topcoated within 72 hours. When allowed to sit for longer than 72 hours, Imron 2.1 PR must be sanded. Sanding is also required if primer has been force dried.

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

For optimum appearance, Imron 2.8 PR can be sanded using 320 grit sandpaper or finer.

IMRON INDUSTRIAL

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):	67% ± 2%
Weight per gallon-(Avg. varies by color):	10.6 lbs. ± 2%
Flash Point-Tag Closed Cup:	20 – 70°F (-7 to 23°C)
Volume Solids (Avg. varies by color):	51% ± 2%
Shipping Weight (varies by color):	1 gallon container – 10 lbs 5 gallon container – 48 lbs
Shelf Life:	1 year minimum
Theoretical Coverage Per Gallon*:	818 ft² (20.0m²/L) @ 1 mil DFT 410 ft² (10.0 m²/L) @ 2 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-062	2.8 lbs./gal. average
Activated 4:1 with FG-062 + with 2 oz VG-805	2.9 lbs./gal. average

HAPS

Activated 4:1 with FG-062 0.41 lbs./gal. of paint	0.81 lbs./gal. solids

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

In Canada:
1.800.668.6945

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