

Imron® 2100 HG-C High Gloss Clearcoat



GENERAL

DESCRIPTION

A 2.1 lb/gal (250 g/l) VOC, two-component, low HAPS polyurethane clearcoat that is based on unique Axalta resin technology, producing properties of both polyester and acrylic urethanes designed for high appearance applications.

It delivers a crystal clear finish, no amber or yellow cast and excellent chemical resistant properties. Easily applied and repaired.

SUGGESTED USES

- Designed for maximum appearance and additional protection is system desiring a clear coat.
- Only the cleanest, “wet look” appearance is acceptable
- Restoring gloss to dull, faded finishes avoids the cost of complete re-painting
- Outstanding gloss and color retention are desired
- Excellent resistance to chemical and/or marine environments is required
- Excellent repair capability

RECOMMENDED FOR USE OVER

Imron 3.5 HG+ and Imron 2.1 HG+ polyurethane topcoats.

NOT RECOMMENDED FOR

Immersion service or with lacquer finishes

DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Humidity Resistance	EXCELLENT
Weatherability	EXCELLENT
Acid Resistance	EXCELLENT
Alkali Resistance	EXCELLENT
Solvent Resistance	EXCELLENT
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT

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



MIXING

MIX RATIO

Stir clearcoat thoroughly prior to activation. Combine components and mix thoroughly. Filter material prior to spray application.

Component	Parts by Volume
Imron 2100 HG-C (21HGC-2100) Clearcoat	5
9T00-A™ Activator	1

ADDITIVES

Increased cure rate:

Add up to 2 oz. V-389S™ Accelerator per RTS gallon.

VISCOCITY

9-11 seconds with #3 Zahn Cup.

INDUCTION TIME

No induction time required.

2 hours as activated

45 minutes with 2 oz V-389S or 389S, accelerator per activated gallon



APPLICATION

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) below the dew point. Relative humidity should be below 90%.

APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.

Pressure Pot (recommended)

Air-Assisted Airless

APPLICATION

- Apply using a cross-coat technique - a wet coat using a top-to-bottom motion and a medium-wet second coat using a side-to-side motion. Flash 30 seconds to 5 minutes between coats. In general, the shorter the flash the smoother the appearance.
- Imron 2100 HG-C can be applied wet-on-wet over Imron 3.5 or 2.1 HG+ topcoats.
- When recoating Imron 2100 HG-C with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.
- For pressure pot application fluid delivery should be set for 10-12 fluid oz/min.

APPLICATION SOLVENTS

No reduction recommended; product is ready-to-spray at less than 2.1 lbs. /gal VOC upon activation. Further reduction may result in greater than 2.1 VOC.

CLEANUP SOLVENTS

68083 or MEK

ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.



DRY TIMES

AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

Without V-389S

Dry to touch

1-2 hours

Tack free

2-4 hours

Tape free

4-6 hours

Dry to assemble

72 hours

FORCE DRY

30 minutes at 140-160°F (60-71°C).



PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	8.74 lbs.
Weight Per Liter (component only)	1050 grams
Suggested Dry Film Thickness	1.8 – 2.2 mils
Gloss	High
Color	Clear
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

RTS mixed 5:1 with:	9T00-A
Gallon Weight pounds per gallon	8.91
Gallon Weight grams per liter	1070
VOC AP pounds per gallon	1.5
VOC AP grams per liter	180
VOC LE pounds. per gallon	2.1
VOC LE grams per liter	250
Weight Solids	51.5% +/- 2%
Volume Solids	48% +/- 2%
Theoretical Coverage per RTS Gallon at 1 mil DFT	777 ft ² (72.2m ²)

VOC REGULATED AREAS

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/SDS 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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