

Imron® 262-400 DTM Urethane Primer



GENERAL

DESCRIPTION

A two-component, low VOC, direct to metal, urethane primer. It delivers high quality topcoat holdout, minimum over-spray, excellent over spray melt in and high build over properly treated metal substrates.

SUGGESTED USES

- For use over properly treated substrates such as aluminum, steel, fiberglass and plastic.
- When used over stainless and galvanized steel, the substrate should be sanded and treated with Metalok® 250S or Metalok 235S pretreatment coating.

NOT RECOMMENDED FOR

Immersion Service
Direct to galvanized substrate

COMPATIBILITY WITH OTHER COATINGS

Compatible with Axalta General Industrial topcoat.

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



MIXING

MIX RATIO

Thoroughly mix prior to activation. The use of a Cyclone® shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

COMPONENT

	Volume
Imron 262-400 Primer Filler	7
CS8407 or TCP8475 Activator	1

ADDITIVES

Add up to 2 oz. 389S™ Accelerator per activated gallon.

POT LIFE - 70°F (21°C)

3 hour as activated



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) above the dew point. Relative humidity should be below 90%.

APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.
Pressure Pot (recommended)
Gravity Feed Gun
Siphon Gun
Air Assisted Airless
Airless Spray

APPLICATION

- Pressure pot application is recommended to provide the best atomization and delivery. Fluid delivery is recommended at 10-12 fluid oz/min.
- Apply using a cross-coat technique, top-to-bottom, and then side-to-side. Each coat should be medium-wet with no flash between coats.
- Paint heaters can help provide a smoother appearance by controlling the temperature and viscosity of the product.

APPLICATION SOLVENTS

Ready-to-spray below 3.5 lb. /gal (420 g/l) VOC upon activation. Further reduction may result in greater than 3.5 lb. /gal (420 g/l) VOC.

CLEANUP SOLVENTS

- TP33364 Equipment Cleaner
- 106™ Lacquer Thinner
- 107™ Low VOC Gun Cleaner
- 108™ Low HAPS Cleaning Solvent



DRY TIMES

AIR DRY

60-90 minutes at 77°F (25°C)

FORCE DRY

30 minutes at 140°F (60°C)



PHYSICAL PROPERTIES

Maximum Service Temperature: 200°F (92°C) in continuous service
300°F (148°C) in intermittent heat

RTS Mixed 7:1 with:

CS8407/TCP8475

Max. VOC (LE):	409 g/L (3.4 lbs./gal)
Max. VOC (AP):	364 g/L (3.0 lbs./gal)
Gallon Weight:	1287 g/L (10.74 lbs./gal)
Weight % Solids:	64.7%
Volume % Solids:	45.8%
Weight % Volatiles:	35.3%
Weight % Water	0.0%
Volume % Water	0.0%
Weight % Exempt Solvent:	6.9%
Volume % Exempt Solvent:	10.9%

Suggested Dry Film Thickness:	1.6 - 2.0 mil
Gloss:	Satin
Color:	Med. Gray (ValueShade® 4)
Flash Point:	(closed cup) see SDS
Shelf Life:	12 months minimum

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.

Revised: April 2018

In the United States:
1.855.6.AXALTA
axalta.us/industrial

In Canada:
1.800.668.6945

