

Imron® 3.5 Plus FX 33F-43033 Black Flexible Single Stage Topcoat



GENERAL

DESCRIPTION

Imron 33F-43033 is a two-component, Low VOC, lead and chrome-free polyurethane enamel topcoat that is designed to deliver superior weathering performance, high gloss and distinctness of image (DOI), as well as excellent flexibility and chip resistance. It is formulated to provide a robust application with good flow and leveling for excellent appearance. Dry times may allow for quicker handling of part and assembly.

SUGGESTED USES

- Recommended for use on surfaces that need exceptional flexibility.

COMPATIBILITY WITH OTHER COATINGS

- Compatible with all Axalta OEM primers and AquaEC 6100 e-coat

DRY FILM CHARACTERISTICS

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

COLOR

Solid black factory package color

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



MIXING 33F

COMPONENTS

33F-43033 Imron 3.5 + FX
15309S Activator

MIX RATIO

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

Component	Volume
33F-43033 Imron 3.5 + FX	2.5
15309S Activator	1

ADDITIVES

None.

VISCOSITY

The activated paint will have a viscosity of 16 – 20 seconds in a #3 Zahn cup.

INDUCTION TIME

No induction time required.

POT LIFE (70°F (21°C))

1 hour as activated

2-4 hours with 2 oz Axalta MasterTint® 389S per activated gallon

45 minutes with 1 oz Axalta MasterTint 8989S per activated gallon



APPLICATION

APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.

Pressure Pot

Gravity Feed

Suction Spray

Air-Assisted Airless

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

- Thoroughly mix Axalta Imron 33F-43033 Topcoat prior to activation.
- Pressure pot or air assisted airless application is recommended.
- For pressure pot set air pressure at 55 – 65 psi at the gun. Fluid delivery should be set for 10 – 12 oz/min.
- Air assisted airless tip .013-.017
- Do not spray Axalta Imron 33F-43033 Topcoat if the paint temperature is less than 70°F (21°C). Use warm water or paint heaters to heat the paint to an optimum temperature of 75-85°F (24-29°C).
- In case of fish eyes, use 1 oz Axalta 359S Paint Additive per ready-to-spray gallon on Imron 2K Topcoat solid colors. Do not use FEE.

ADDITIONAL COMMENTS

- Heating activated material above 110°F (43°C) will cause gelation.
- When recoating Axalta Imron 2K Urethane with itself, sanding is required if the topcoat has cured more than 48 hours.

APPLICATION SOLVENTS

Ready-to-spray VOC (le) is below 3.5 lbs/gal VOC upon activation. Further reduction may result in greater than 3.5 VOC.

CLEAN UP SOLVENTS

Axalta 105

Axalta 107

Axalta TP33364 Thinner



DRY TIMES

Cure Time At Recommended Thickness – 77°F (25°C) and 50% RH

	Without Accelerator	w/MasterTint 389S	w/MasterTint 8989S
Dry to Touch:	2-4 hrs	1-2 hr	0.5-1 hr
Tack Free:	4-6 hrs	2-3 hrs	1-2 hrs
Tape Free:	10-12 hrs	3-5 hrs	2-3 hrs
Dry to Assemble:	72 hrs	48 hrs	48 hrs

Product may be force dried 30 min at 120-140°F (48-60°C) after a flash time of 15 minutes following application of final coat.



PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (92°C) in continuous service
Volume Solids	48% average unactivated 56% average RTS mixed 2.5:1 w/ 15309S
Weight Solids	55% average unactivated 63% average RTS mixed 2.5:1 w/ 15309S
Theoretical Coverage	898 ft ² /gal @ 1 mil DFT
Weight Per Gallon	8.2 lbs/gal average unactivated
Suggested Film Thickness	1.5 – 2.5 mils dry film thickness
Gloss	High.
Flash Point (Closed cup)	Below 80°F (27°C)
Shelf Life	12 months minimum

VOC REGULATIONS

VOC content (lbs/gal)	LE	AP
Axalta Imron 3.5 + FX 33F-43033	3.5	3.2
RTS mixed 2.5:1 w/ Axalta 15309S	2.6	2.3

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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