



Imron® High Performance Urethane DTM 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 it is recommended that the substrate be blasted prior to application of primer to promote adhesion to the surface.
- Galvanized steel surface preparation may include detergent washing, pre-treatment and abrasion for new surfaces; for weathered surfaces, detergent washing and sanding.

NOT RECOMMENDED FOR

Immersion Service

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

Imron® 362-300™ Primer Filler
CS8407™ Activator

Volume

6
1

POT LIFE - 70°F (21°C)

4 hours 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
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.
- Flash between topcoat a minimum of 5 minutes to a maximum of 16 hours. Dry time over 16 hours will require sanding before topcoat.

APPLICATION SOLVENTS

Ready-to-spray below 2.8 lb. /gal (336 g/l) VOC upon activation. Further reduction may result in greater than 2.8 lb. /gal (336 g/l) VOC. Exempt solvents that can be used are 9M01, T-1021, and T-1022. Y32401 can be used to help eliminate overspray in high temperatures, but will increase the ready to spray VOC.

CLEANUP SOLVENTS

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



DRY TIMES

AIR DRY

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

Dry to touch:	15-30 Minutes
Tack Free:	30-60 Minutes
Print Free:	2-3 hours

FORCE DRY

30 minutes at 140-180°F (60°-82°C)

Primer that is force dried prior to topcoat application must be sanded before topcoat can be applied.



PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
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RTS Mixed 6:1 with:

CS8407

Max. VOC (LE):	336 g/L (2.8 lbs./gal)
Max. VOC (AP):	271 g/L (2.3 lbs./gal)
Gallon Weight:	1344 g/L (11.22 lbs./gal)
Weight % Solids:	68.2%
Volume % Solids:	50.1%
Weight % Volatiles:	31.8%
Weight % Water	0.0%
Volume % Water	0.0%
Weight % Exempt Solvent:	11.6%
Volume % Exempt Solvent:	19.2%



Suggested Dry Film Thickness:	1.5 - 2.0 mil (smooth substrate) 1.5 mil above blast profile average for blasted
Gloss:	Satin
Color:	Med. Gray
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: February 2021

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