

Imron® NISO 3325 Non-Isocyanate Cross Linked Acrylic Enamel Single Stage Topcoat



GENERAL

DESCRIPTION

Imron® NISO 3325 is a two-component, 3.5 VOC, lead and chrome-free non-isocyanate cross linked solventborne acrylic enamel topcoat that is designed to deliver superior weathering performance, comparable to urethanes, 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. It is available in factory packaged colors.

SUGGESTED USES

- Recommended for use on agricultural equipment, construction equipment and other applications where similar performance and appearance is desired.

COMPATIBILITY WITH OTHER COATINGS

- Compatible with all Corlar® 3.0 and Tufcote™ 3.0 PR epoxy primers

DRY FILM CHARACTERISTICS

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

COLOR

Solid factory package and mixing machine colors

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



MIXING

COMPONENTS

Imron® NISO 3325 Cross Linked Acrylic Enamel Single-Stage Topcoat
3395-F1825™ Activator

MIX RATIO

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

Component	Volume
Imron® NISO 3325 Topcoat	2
3395-F1825 Activator	1

ADDITIVES

Add up to 5 oz. Axalta 3375-45021™ Accelerator per activated gallon.

VISCOSITY

Depending on color, the activated paint will have a viscosity of 20 – 30 seconds in a #3 Zahn cup.

INDUCTION TIME

No induction time required.

POT LIFE (70°F (21°C))

12 hours as activated



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® NISO 3325 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.
- For air assisted airless, use .011 to .013 tip in 8 to 12-inch pattern. Pump pressure of 900-1400 lbs. and 25-50 psi atomizing air
- Do not spray Axalta Imron® NISO 3325 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).

ADDITIONAL COMMENTS

- Heating activated material above 110°F (43°C) will cause gelation.
- When recoating Axalta Imron® NISO 3325 Cross linked acrylic 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

BLENDING

1. Prepare repair using normal repair procedures.
2. Finish sand primer and surrounding area with 320 – 400 grit sandpaper
3. Mix Imron® NISO 3325 color 2:1 with 3395-F1825.
4. Spray the first coat beyond the primer area and just within the sanded area.
5. Spray the second beyond the first coat and just into the area that has not been sanded.
6. Add 50% by volume 3401S to the remaining RTS paint in the cup and spray a coat beyond the second
7. Add 50% by volume 3401S to the already reduced RTS paint and spray a fourth coat beyond the third.
8. Clean cup and pour 3401S into gun. Apply blender the the edge of the fourth coat and blend into original paint.

Characteristic	Method	Tufcote™ NISO
Gloss	ASTM D 523	20: 80+ 60: 90+
Pencil Hardness	ASTM D3363	H-2H
Flexibility	ASTM D522	1/8" (over Corlar 3.0)
Impact Resistance	ASTM D2794	40 in-lbs. (over Corlar 3.0)
Conical Mandrel Bend	ASTM D522	32% Elongation (over Corlar 3.0)
Xenon (Quartz/Boro)	SAE J2527	<u>1200 hours (average of all colors)</u> 60° Gloss Retention: 87% ΔE: 2.5
Salt Spray (1000 hrs) Blasted HRS Total DFT Ave 5.0 mils	ASTM B117	Creep Before Scrape 4.88mm average Creep After Scrape 1.95 mm average Blister rating of 10 Rust rating of 10
Humidity Resistance (1000 hrs)	ASTM D2247	Blister and Rust rating of 10 over B1000 P99X and Blasted

Chemical Resistance ASTM D 1308

Chemical	Type	Tufcote™ NISO
Engine Oil	24 hr spot	No Effect
Hydraulic Oil	24 hr spot	No Effect
Antifreeze	24 hr spot	No Effect
10% Nitric Acid	24 hr spot	No Effect
Battery Acid	24 hr spot	Slight downgloss
Motor Oil	24 hr spot	No Effect
Gasoline	24 hr spot	No Effect
Water Immersion	1000 hours immersion	No Effect
Diesel Immersion	24 hr immersion	No Effect
Motor Oil Immersion	500 hours immersion	No Effect
TSP	24 hr immersion	No Effect



DRY TIMES

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

Dust Free: 20-30 mins.
 Dry to Handle: 4-6 hrs.
 Dry to Assemble: 16-18 hrs.

Product may be force dried after a flash time of 10 minutes following application of final coat.

30 min at 140-160°F (60-71°C)
 25 min at 170-180°F (77-82°C)



PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (92°C) in continuous service
Volume Solids F1825	48% average RTS mixed 2:1 w/ 3395-
Weight Solids F1825 Activator	58% average RTS mixed 2:1 w/ 3395-
Theoretical Coverage (average)	787 ft ² /gal @ 1 mil DFT
Weight Per Gallon	8 ± 2 lbs./gal average unactivated
Suggested Film Thickness dependent on color	1.5 – 2.5 mils dry film thickness
Gloss	≥ 90° @ 60°
Flash Point (Closed cup)	Below 80°F (27°C)
Shelf Life	12 months minimum

VOC REGULATIONS

Average VOC content (lbs./gal)	LE	AP
Axalta Imron® NISO Topcoat	3.8	3.6
RTS mixed 2:1 w/Axalta 3395-F1825	3.5	3.3

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.

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