

# Imron® Plus 1827-39209 Caterpillar® Black 2K Urethane Enamel Single Stage Topcoat



---

## GENERAL

### COMPATIBILITY WITH OTHER COATINGS

Compatible with Caterpillar® approved primers

### COLOR

Black

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



---

## MIXING

### COMPONENTS

Imron Plus 1827-39209 2K Urethane Enamel Single Stage Topcoat  
CS8407™ Activator

### MIX RATIO

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

Component	Volume
Imron Plus 1827-39209	3
CS8407 Activator	1

### VISCOSITY

The activated paint will have a viscosity of 10 – 14 seconds in a #3 Zahn cup at 77°F.

### POT LIFE (70°F (21°C))

60 minutes



---

## APPLICATION

### APPLICATION EQUIPMENT

HVLP  
Conventional  
Electrostatic  
AA Airless

### APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 55°F (13°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%.

### CLEAN UP SOLVENTS

TP33364, Axalta 105, Axalta 107



---

## DRY TIMES

Cure Time At Recommended Thickness – 77°F (25°C) and 50% RH  
Force dry: 30 minutes at 140°F



## PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	362 g/L (3.0 lbs./gal)
Max. VOC (AP):	304 g/L (2.5 lbs./gal)
Avg. Gallon Weight:	1008 g/L (8.41 lbs./gal)
Avg. Weight % Volatiles:	44.0%
Avg. Weight % Water:	0.1%
Avg. Weight % Exempt Solvent:	13.7%
Avg. Volume % Water:	0.1%
Avg. Volume % Exempt Solvent:	16.0%
HAPS per gallon of solids	0.186 lb/gal
Suggested Film Thickness (primer/topcoat)	1.8 – 3.0 mils dry film thickness
Maximum Fil Thickness	4.0 mils dry film thickness
Shelf Life <sup>1</sup>	60 months
Theoretical Coverage per gallon	783 sq.ft <sup>2</sup> /gal @ 1 mil DFT
Gloss	≥95° at 60°
Flash Point (Closed cup)	See SDS

<sup>1</sup> This information should be used for guidelines applied to only sealed/unopened materials, stored in a temperature range of 50° - 120° F, in a non-corrosive environment to maximize shelf life.

## 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.

Revised: October 2017

In the United States:  
**1.855.6.AXALTA**  
axalta.us

In Canada:  
**1.800.668.6945**  
axalta.ca

