



Imron® 3480S™ Clearcoat



GENERAL

DESCRIPTION

A 3.5 lb. /gal (420 g/l) VOC, two-component, polyurethane clearcoat designed for spot, panel and overall repairs. It delivers premium appearance with excellent durability and chemical resistance.

SUGGESTED USES

Imron 3480S is designed for panel and overall repairs. It is highly recommended for accounts with force dry capabilities.

NOT RECOMMENDED FOR

Immersion service or over alkyd enamels, acrylic enamels or lacquer finishes.

DRY FILM CHARACTERISTICS

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

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



MIXING

MIX RATIO

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

Components

Components	Parts by Volume
Imron 3480S Clearcoat	3
194S™ Activator	1

ADDITIVES

Extend pot life and improve dry time:

Add up to 2 oz. of 389S™ Accelerator to activated gal.

INITIAL APPLICATION VISCOSITY

12-14 seconds with #3 Zahn Cup.

INDUCTION TIME

No induction time is required.

POT LIFE - 70°F (21°C)

2 hours as activated
2-4 hours with 389S™ Accelerator



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
Suction Spray
Air-Assisted Airless

APPLICATION

- Apply using a cross-coat technique - a wet coat using a top-to-bottom motion and a medium-wet second coat using a side-to-side motion. Flash 30 seconds to 5 minutes between coats. In general, the shorter the flash the smoother the appearance.
- When recoating 3480S™ with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.
- For pressure pot application fluid delivery should be set for 10-12 fluid oz/min.

APPLICATION SOLVENTS

No reduction necessary; product is ready-to-spray at less than 3.5 lbs. /gal VOC upon activation. Further reduction may result in greater than 3.5 VOC.

CLEANUP SOLVENTS

3602S™ Lacquer Thinner
106™ Lacquer Thinner
107™ Low VOC Gun Cleaner
108™ Low HAPS Cleaning Solvent

ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.



DRY TIMES

AIR DRY

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

	Without 389S	With 389S
Dry to touch	4-6 hours	1-2 hours
Tack free	10-12 hours	2-4 hours
Tape free	12-24 hours	4-6 hours
Dry to assemble	72 hours	72 hours

FORCE DRY

30 minutes at 140-160°F (60-71°C)



PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	8.02 lbs.
Weight Per Liter (component only)	961 grams
Suggested Dry Film Thickness	1.8 – 2.2 mils
Gloss	High
Color	Clear
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum



RTS mixed 3:1 with: Includes 389S	194S
Gallon Weight pounds per gallon	8.28
Gallon Weight grams per liter	992
VOC AP pounds per gallon	3.3
VOC AP grams per liter	397
VOC LE pounds. per gallon	3.4
VOC LE grams per liter	409
Weight Solids	57.6%
Volume Solids	50.1%
Weight Volatiles	42.4%
Weight Water	0.0%
Volume Water	0.0%
Weight Exempt Solvents	2.3%
Volume Exempt Solvents	2.9%
Theoretical Coverage per RTS Gallon at 1 mil DFT	804 ft ² (74.7 m ²)

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.

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