



**IMRON™**

# Imron® Elite Productive 8401EW™ Blending Bed



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## GENERAL

### DESCRIPTION

A 3.5 lb/gal (420 g/l) VOC, two-component, non-pigmented basecoat blender formulated to improve blending of PowerTint® mixing system basecoats in spot repair applications.

### SUGGESTED USES

Over properly prepared OE finishes of Imron Elite.  
Under properly activated and applied PowerTint basecoat finishes.

### NOT RECOMMENDED FOR

Blending procedures that are not PowerTint basecoat finishes.

### COMPATIBILITY WITH OTHER COATINGS

Compatible with all cured urethane substrates and properly prepared Axalta Transportation PowerTint basecoats (EB, EG, EW, EK qualities).

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



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## MIXING

### MIX RATIO

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

Component	Volume
Imron Elite Productive 8401EW ColorNet® Mix	3
196S™ Activator or 15303S™ Activator	1
196S	Basecoat Quality EG
15305S	Basecoat Qualities EW, EK, EB

### ADDITIVES

#### Pot Life Extension:

Add up to 2 oz. of 189S™ Accelerator to RTS gallon.

### INDUCTION TIME

No induction time required.

### POT LIFE - 70°F (21°C)

30-60 minutes with 189S accelerator



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## 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%.

### GUN SETUP

Gravity Feed (recommended)

### APPLICATION SOLVENTS

Ready to spray below 3.5 lbs. /gal VOC upon activation. Further reduction will result in greater than 3.5 lbs. /gal VOC.

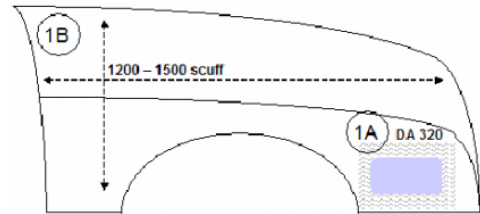
### CLEANUP SOLVENTS

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

### APPLICATION

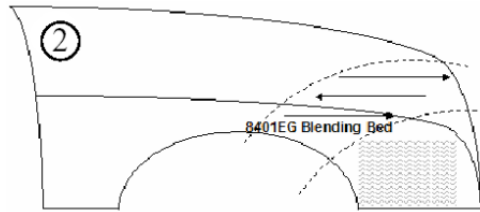
#### Step 1: Prepare the Surface

- (1A) Prepare the repair area appropriate using primer and sand, clean and prep for sealing. Finish sanding with P320 DA.
- (1B) Sand area for adhesion promoter application with 1200-1500 grit sand paper or fine scuff pad.
  - Use appropriate surface cleaners for your area regulations.



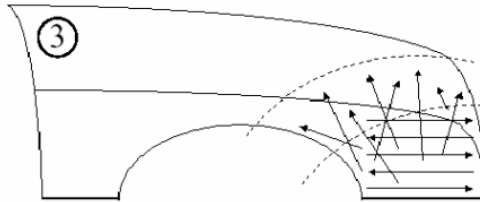
#### Step 2: Apply the Blending Bed

- Apply 1 medium-wet, single pass coat of the activated, ready to spray, 8401EW Blending Bed material to the area where the color blend transition will take place. Starting at the outer edge of the repaired zone, and extending outward.
- Immediately clean equipment and mix the appropriate amount of basecoat material. Minimal flash of the blending bed is recommended prior to basecoat application, 1-2 minutes is recommended.



#### Step 3: Apply the Basecoat

- Apply the first coat of PowerTint basecoat color over the repaired area. Allow 30 seconds to 1 minute flash and follow with application of a second coat of color, extending it beyond the first coat until hiding is achieved. Spray technique should be to apply color outward from the repair zone, feathering color into Blending Bed.
- Do not reduce the basecoat material with solvent. Do not integrate blending bed material or clearcoat with the basecoat color.
- Application pressure for spray equipment may be adjusted up or down in order to lighten or darken the appearance of metallic basecoat colors.
- Use of Gravity Feed Gun is recommended.
  - Suggested 35-40 PSI (Conventional)
  - Suggested inlet 30 PSI Air cap Pressure 10 (HVLP)



#### Step 4: Apply the Clearcoat

- Allow final coat of basecoat to flash 30 minutes. Apply clearcoat over the entire panel per technical data sheet instructions.



## PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service
Weight Per Gallon (component only)	7.94 lbs.
Weight Per Liter (component only)	951 grams
Suggested Dry Film Thickness	0.8-1.0 mils DFT
Gloss	Satin
Color	Clear
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

### RTS mixed 3:1 with: Includes 189S

	196S	15303S
Gallon Weight pounds per gallon	8.09	8.15
Gallon Weight grams per liter	970	977
VOC AP pounds per gallon	2.775	2.8
VOC AP grams per liter	333	332
VOC LE pounds. per gallon	3.328	3.3
VOC LE grams per liter	399	394
Weight Solids	52.1%	52.7%
Volume Solids	44.5%	45.3%
Weight Volatiles	47.9%	47.3%
Weight Water	0.0%	0.0%
Volume Water	0.0%	0.0%
Weight Exempt Solvents	13.6%	13.2%
Volume Exempt Solvents	16.6%	15.5%
Theoretical Coverage per RTS gallon at 1 mil DFT	714 ft <sup>2</sup> (66.3 m <sup>2</sup> )	727 ft <sup>2</sup> (67.5 m <sup>2</sup> )

## 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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