



Excel™ Pro Topcoat 3.5 VOC (EZ quality)



GENERAL

DESCRIPTION

A 3.5 lb. /gal (420 g/l) VOC, two-component, acrylic urethane topcoat designed for panel, multi-panel and overall applications. Excel Pro is ideal for refinishers who want a cost-effective finish that features good performance, good color capability and very good appearance. Available in solid and metallic colors, this topcoat uses the Axalta Multi-Temperature activator/reducer platform.

COMPATIBILITY WITH OTHER COATINGS

Compatible with all Axalta Transportation primer systems.

NOT RECOMMENDED FOR

- Immersion Service
- Use over lacquer finishes

DRY FILM CHARACTERISTICS

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

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	Volume
Excel™ Pro (EZ Quality)	4
Axalta 1530XS™ Activator	1

15303S™ Low Temp Activator
15305S™ Mid Temp Activator
15307S™ High Temp Activator
15308S™ Very High Temp Activator

ADDITIVES

Pot Life extension:

Add 2 oz. 189S™ Accelerator per RTS gallon.

Increased cure (small area repair, stripes):

Add up to 2 oz. 389S™ Accelerator per RTS gallon.

Note: 8989S™ Accelerator will shorten pot life and is not recommended.

VISCOCITY

10 – 20 with #3 Zahn cup, depending on color.



INDUCTION TIME

No induction time required.

POT LIFE - 70°F (21°C)

30 minutes as activated
1 hour with 189S™ accelerator
45 minutes with 389S™ accelerator

APPLICATION

APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.
Pressure Pot (recommended)
Gravity Feed
Suction Spray
Air-Assisted Airless

APPLICATION

- Pressure pot fluid delivery should be set for 10-12 ounces per minute.
- 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 Excel™ Pro with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.

APPLICATION SOLVENTS

Ready-to-spray VOC is below 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 cause gelation.



DRY TIMES

AIR DRY

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

	With 189S™	With 389S™
Dry to Touch	3-5 hours	30-60 minutes
Tack Free	6-8 hours	2-3 hours
Tape Free	10-12 hours	3-5 hours
Dry to Assemble	72 hours	72 hours

FORCE DRY

30 min between 120°F-140°F (48°C- 60°C) after a flash time of 15 min following application of final coat.

Point to Point Melt-In Guide - 70°F (21°C) AND 50% RH

Activator	Mixing Reducer	Flash Time
15303S™	15375S™ Low Temp Reducer	5-10 min
15305S™	15385S™ Mid Temp Reducer	10-15 min
15307S™	15395S™ High Temp Reducer	15-20 min
15308S™	15397S™ Extra Slow Reducer	20-25 min



Depending on the surface area being coated, air temperature, and booth air flow, the above combinations of activators and mixing reducers should provide excellent overspray melt-in for the stated times.

HOT WEATHER APPLICATION

In addition to using the high temperature activator and reducers, add up to 10% by volume 15399S™ High Temp Additive to unactivated Excel™ Pro color and activate 4:1.



PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service
Weight Per Gallon (component only)	Various
Weight Per Liter (component only)	Various
Suggested Dry Film Thickness	1.8 – 2.2 mils
Gloss	High
Color	Available in Solid and Metallic Colors
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

**RTS mixed 4:1 with:
Includes 189S**

	15303S
	15305S
	15307S
	15308S
Gallon Weight pounds per gallon - Average	8.96
Gallon Weight grams per liter - Average	1074
VOC AP pounds per gallon - Maximum	3.1
VOC AP grams per liter - Maximum	371
VOC LE pounds. per gallon - Maximum	3.4
VOC LE grams per liter - Maximum	413
Weight Solids - Average	57.4%
Volume Solids - Average	47.0%
Weight Volatiles - Average	42.6%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	8.0%
Volume Exempt Solvents - Average	10.3%
Theoretical Coverage per RTS Gallon at 1 mil DFT	754 ft ² (70.0 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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