



Imron® Elite Topcoat 3.5 VOC (EA Quality)



GENERAL

DESCRIPTION

A 3.5 lb. /gal (420 g/l) VOC, two-component, high performance, polyurethane topcoat designed for panel and overall applications. It delivers excellent durability, premium appearance and excellent color match. Can be air or force dried. Designed for panel and overall applications.

NOT RECOMMENDED FOR

Immersion service or over lacquer finishes.

COMPATIBILITY WITH OTHER COATINGS

Compatible with all Axalta Transportation primer systems.

DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Weatherability	EXCELLENT
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
Imron Elite Topcoat (EA quality)	3
194S™ Activator	1

ADDITIVES

Improve pot life and dry time:

Add up to 2 oz. of 389S™ Accelerator or 1 oz. of 8989S™ Accelerator to activated gal.

Note: 8989S™ will shorten pot life.

INITIAL APPLICATION VISCOSITY

10-18 seconds with #3 Zahn Cup, depending on color

INDUCTION TIME

No induction time required.

POT LIFE - 70°F (21°C)

2 hours as activated
2-4 hours with 389S accelerator
45 min with 8989S 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

- Pressure pot fluid delivery should be set for 10-12 ounces per minute.
- Apply topcoat using a cross-coat technique. Spray a wet first pass using a top to bottom motion. Spray a medium-wet second coat using a side-to-side motion.
- Flash times between coats will vary between 30 seconds and 5 minutes. In general, the shorter the flash the smoother the appearance
- Do not spray Imron Elite Topcoat if the paint temperature is less than 75°F (24°C). Use warm water or paint heaters to heat the paint to an optimum temperature of 85-95°F (29-35°C).

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

ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will cause the product to gel. Sanding is recommended for recoating if the topcoat has been air-dried more than 16 hours or force dried.



DRY TIMES

AIR DRY

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

	No Accelerator	With 389S	With 8989S
Dry to Touch	4-6 hours	1-2 hours	0.5-1 hr
Tack Free	10-12 hours	2-4 hours	1-2 hours
Tape Free	12-24 hours	4-6 hours	2-4 hours
Dry to Assemble	72 hours	72 hours	72 hours

FORCE DRY

30 min at 140-160°F (60-71°C) after a 15 minute flash time following application of final coat.



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 3:1 with:

Includes 389S

	194S
Gallon Weight pounds per gallon - Average	9.08
Gallon Weight grams per liter - Average	1088
VOC AP pounds per gallon - Maximum	3.4
VOC AP grams per liter - Maximum	412
VOC LE pounds. per gallon - Maximum	3.5
VOC LE grams per liter - Maximum	418
Weight Solids - Average	61.2%
Volume Solids - Average	51.1%
Weight Volatiles - Average	38.8%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	0.9%
Volume Exempt Solvents - Average	1.3%
Theoretical Coverage per RTS Gallon at 1 mil DFT	820 ft ² (76.2 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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