



Imron® Elite Basecoat 3.5 VOC (EB Quality)



GENERAL

DESCRIPTION

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

SUGGESTED USES

Designed for panel and overall applications.

NOT RECOMMENDED FOR

Immersion service or over lacquer finishes.

COMPATIBILITY WITH OTHER COATINGS

Compatible with all Axalta transportation coatings.
Must be clearcoated with 8840S™, 8821S™ or EZ-3460S™.

DRY FILM CHARACTERISTICS

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

* Note - when properly clearcoated.

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.

Components

| Components | Volume |
|-----------------------------------|--------|
| Imron Elite Basecoat (EB quality) | 3 |
| 194S™ Activator | 1 |

ADDITIVES

Improve pot life and dry time:

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

Increased cure (small area repair, stripes):

Add up to 1 oz. of 8989S™ Accelerator per RTS.

Note: MasterTint® 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 EQUIPMENT

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

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

- 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.
- Imron Elite Basecoat (EB) must be clearcoated.
- Imron Elite Basecoat (EB) may be clearcoated wet-on-wet with 8840S™ 3.5 VOC, 8821S™ 2.1 VOC or EZ-3460S™ 3.5 VOC Easy Clean clearcoat.
- Open time of basecoat prior to clearcoat is between wet-on-wet to 16 hours.
- When clear coating Imron Elite Basecoat, or recoating with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried
- Do not spray Imron Elite basecoat 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

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

CLEANUP SOLVENTS

3850S™ Equipment Cleaner
32030S™ Acetone

ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will cause the product to gel.



DRY TIMES

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 | ½ -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 |



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 | Apply until hiding is achieved. Solid and effect colors: 1.0-1.5 mils DFT, depending on color. |
| Gloss | High, when clearcoated |
| Color | Available in solid, metallic and pearl 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 | 9.04 |
| Gallon Weight grams per liter - Average | 1083 |
| VOC AP pounds per gallon - Maximum | 3.5 |
| VOC AP grams per liter - Maximum | 418 |
| VOC LE pounds. per gallon - Maximum | 3.5 |
| VOC LE grams per liter - Maximum | 418 |
| Weight Solids - Average | 61.4% |
| Volume Solids - Average | 51.3% |
| Weight Volatiles - Average | 38.6% |
| Weight Water - Average | 0.0% |
| Volume Water - Average | 0.0% |
| Weight Exempt Solvents - Average | 0.0% |
| Volume Exempt Solvents - Average | 0.0% |
| Theoretical Coverage per RTS Gallon at 1 mil DFT | 824 ft ² (76.6 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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