



## Imron® Elite Express Topcoat 3.5 VOC (EF Quality)



### GENERAL

#### DESCRIPTION

A 3.5 lb/gal (420 g/l) VOC, two-component, ultra-productive, polyurethane topcoat designed for spot, panel and two tone repairs. It delivers excellent durability, premium appearance and excellent color match. Can be air or force dried.

#### SUGGESTED USES

Designed for spot, panel and two tone applications.

#### NOT RECOMMENDED FOR

- Immersion Service
- Use 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 Express Topcoat (EF quality)	3
196S™ Activator	1

#### 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™ 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)**

1 hours as activated  
2 hours 189S accelerator  
1-1.5 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 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.
- When recoating Imron Elite Express with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.

**ADDITIONAL COMMENTS**

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

**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



---

**DRY TIMES**

**AIR DRY**

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

	<b>No Accelerator</b>	<b>With 389S</b>
Dry to Touch:	30-60 minutes	30-45 minutes
Tack Free:	1-2 hours	45-60 minutes
Tape Free:	3-6 hours	2-4 hours
Dry to Assemble:	6 hours to overnight	3-8 hours

**FORCE DRY**

30 min at 120-140°F (50-60°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
Theoretical Coverage per RTS Gallon at 1 mil DFT	759 ft <sup>2</sup>

### RTS mixed 3:1:

inc. 189S	196S
Gallon Weight pounds per gallon - Average	8.96
Gallon Weight grams per liter - Average	1074
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	420
Weight Solids - Average	57.8%
Volume Solids - Average	47.3%
Weight Volatiles - Average	42.2%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	3.8%
Volume Exempt Solvents - Average	5.0%

## 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.

Revised: September 2014

In the United States:  
**1.855.6.AXALTA**  
axalta.us

In Canada:  
**1.800.668.6945**  
axalta.ca

