



## Imron® Elite Express Basecoat 3.5 VOC (EG Quality)



### GENERAL

#### DESCRIPTION

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

#### SUGGESTED USES

Designed for spot and panel applications.

#### NOT RECOMMENDED FOR

Immersion service or over lacquer finishes.

#### COMPATIBILITY WITH OTHER COATINGS

Compatible with all Axalta Transportation primers.  
Must be clearcoated with 8460S™, 8840S™, 8890S™ or 8831S™ Clearcoats

#### 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 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	Parts by Volume
Imron Elite Express Basecoat (EG 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 with 189S accelerator
- 1-1.5 hours with 389S accelerator
- 45 min with 8989S accelerator



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**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%.
- Do not spray 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**

- 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.
- Basecoat must be clearcoated.
- 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.

**APPLICATION SOLVENTS**

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

**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. When recoating Imron Elite Express Basecoat with itself, sanding is required if the enamel has air dried more than 8 hours or has been force dried.



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**DRY TIMES**

**AIR DRY**

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

Dry to Touch	<b>With 189S</b> 30 minutes
Tack Free	45 minutes
Tape Free-Solids	45 minutes
Tape Free-Metallics	60 minutes
Dry to clearcoat	30 minutes to 16 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 189S	196S
Gallon Weight pounds per gallon - Average	9.27
Gallon Weight grams per liter - Average	1111
VOC AP pounds per gallon - Maximum	3.2
VOC AP grams per liter - Maximum	389
VOC LE pounds. per gallon - Maximum	3.5
VOC LE grams per liter - Maximum	419
Weight Solids - Average	59.9%
Volume Solids - Average	48.0%
Weight Volatiles - Average	40.1%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	5.2%
Volume Exempt Solvents - Average	7.3%
Theoretical Coverage per RTS Gallon at 1 mil DFT	770 ft <sup>2</sup> (71.5 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 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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In the United States:  
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