

# Imron® Elite Productive 8890S™ Clearcoat



## GENERAL

### DESCRIPTION

A 3.5 lbs/gal (420 g/l) VOC, two-component clearcoat designed be easy to use and to deliver high-performance for use on panel and overall applications. It is formulated to provide a premium appearance with excellent durability and chemical resistance. Highly recommended for accounts with force dry capabilities.

### SUGGESTED USES

It is highly recommended for accounts with force dry capabilities.

### RECOMMENDED FOR USE OVER

Imron Elite Productive Basecoat (EY Quality)  
Imron Elite Productive Basecoat (EW Quality)  
Imron Elite Express Basecoat (EG Quality)

### NOT RECOMMENDED FOR

Immersion service or lacquer finishes.

### DRY FILM CHARACTERISTICS

Chemical resistance	EXCELLENT
Humidity resistance	EXCELLENT
Weatherability	EXCELLENT
Acid resistance	EXCELLENT
Alkali resistance	EXCELLENT
Solvent resistance	EXCELLENT
Abrasion resistance	EXCELLENT
Flexibility	EXCELLENT



## MIXING

### MIX RATIO

Stir clearcoat thoroughly prior to activation. Combine components and mix thoroughly. Filter material prior to spray application.

### Components

Imron Elite Productive 8890S Clearcoat  
294S™ Activator

### Parts by Volume

3  
1

### ADDITIVES

#### Extend pot life and improve dry time:

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

#### Improve dry time (small area repair):

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

### INITIAL APPLICATION VISCOSITY

12-14 seconds with #3 Zahn Cup.

### INDUCTION TIME

No induction time is required.

### POT LIFE - 70°F (21°C)

2 hours as activated  
2-4 hours with 389S Accelerator  
1 hour with 8989S Accelerator



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## 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

- 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 8890S can be applied wet-on-wet over Imron Elite (EY) Productive Basecoat solid and metallic colors with minimal flash times.
- Imron Elite (EW) and (EG) basecoat qualities should flash for 30 minutes prior to clearcoat application.
- Imron Elite basecoat should be lightly scuff-sanded if allowed to dry for more than 16 hours or has been force dried prior to application of Imron Elite Productive Clearcoat 8890S.
- When recoating 8890S with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.
- For pressure pot application fluid delivery should be set for 10-12 fluid oz/min.

### APPLICATION SOLVENTS

No reduction necessary; product is ready-to-spray at less than 3.5 lbs/gal VOC upon activation. Further reduction may result in greater than 3.5 lbs/gal VOC.

### CLEANUP SOLVENTS

3850S™ Equipment Cleaner

8875S™ Reducer

### ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.



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## DRY TIMES

### AIR DRY

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

	<u>without 389S</u>	<u>with 389S</u>
Dry to touch	4-6 hours	1-2 hours
Tack free	10-12 hours	2-4 hours
Tape free	12-24 hours	4-6 hours
Dry to assemble	72 hours	72 hours

### FORCE DRY

20 minutes at 160°F (71°C) substrate temperature.

30 minutes at 140°F (60°C) substrate temperature.



## PHYSICAL PROPERTIES

Maximum service temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight per gallon (component only)	8.14 lbs.
Weight per liter (component only)	975 grams
Suggested dry film thickness	1.8 – 2.2 mils
Gloss	high
Color	clear
Flash point (closed cup)	see MSDS
Shelf life	12 months minimum

### RTS mixed 3:1 with:

Includes 389S	294S
Gallon weight pounds per gallon	8.37
Gallon weight grams per liter	1003
VOC AP pounds per gallon	3.34
VOC AP grams per liter	400
VOC LE pounds. per gallon	3.46
VOC LE grams per liter	414
Weight solids	57.4%
Volume solids	50.5%
Weight volatiles	42.6%
Weight water	0.0%
Volume water	0.0%
Weight exempt solvents	2.7%
Volume exempt solvents	3.5%
Theoretical square foot coverage per RTS gallon at 1 mil DFT	810 ft <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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