



Imron® Elite Productive Basecoat 3.5 VOC (EW Quality)



GENERAL

DESCRIPTION

A 3.5 lb/gal (420 g/l) VOC, two-component, polyurethane basecoat designed for spot, panel and overall repairs. It delivers a highly productive finish that features an extensive color palette, premium appearance and excellent performance. Available in solid, metallic and pearl colors, this basecoat uses the Axalta Multi-Temperature Platform for greater control over the application variables that affect cycle time and final appearance.

SUGGESTED USES

- Panel, multi-panel, overall and two-tone applications
- Commercial vehicles, transit bus and light rail, beverage and delivery trailers, emergency vehicles

NOT RECOMMENDED FOR

Immersion service or over lacquer finishes.

COMPATIBILITY WITH OTHER COATINGS Compatible with all Axalta transportation coatings. Must be clearcoated with 8460S™, 8840S™, 8890S™ or 8831S™.

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	Parts by Volume
Imron Elite Productive Basecoat (EW quality)	3
1530XS Activator	1
15303S™ Low Temp Activator	
15305S™ Mid Temp Activator	
15307S™ High Temp Activator	

ADDITIVES

Pot Life extension:

Add 2 oz. 189S™ Accelerator per RTS gallon.

Increased cure (small area repair, stripes):

Add up to 2 oz 389S™ per RTS gal. or up to 1 oz. 8989S™ per RTS gal.

Note: use of 389S or 8989S will shorten pot life.

VISCOSITY

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

INDUCTION TIME

No induction time required.

POT LIFE - 70°F (21°C)

30 minutes as activated
1 ½ hours with 189S accelerator
45 minutes with 389S accelerator
20 minutes 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.
- When recoating Imron Elite Productive Basecoat with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried
- Basecoat must be clearcoated.

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..



DRY TIMES

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

	With 189S
Dry to Touch	30 minutes
Tack Free	60 minutes
Tape Free-Solids	90 minutes
Tape Free-Metallics	90 minutes
Dry to clearcoat	30 minutes to 16 hours



Based on activation with 15305S Activator. 15303S and 15307S activator can be used at the prescribed ratio to adjust spray latitude for overspray melt-in and drying and tape times.



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

	15303S / 15305S / 15307S
Gallon Weight pounds per gallon - Average	9.12
Gallon Weight grams per liter - Average	1093
VOC AP pounds per gallon - Maximum	3.1
VOC AP grams per liter - Maximum	375
VOC LE pounds. per gallon - Maximum	3.3
VOC LE grams per liter - Maximum	399
Weight Solids - Average	60.8%
Volume Solids - Average	50.4%
Weight Volatiles - Average	39.2%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	4.9%
Volume Exempt Solvents - Average	5.9%
Theoretical Coverage per RTS Gallon at 1 mil DFT	808 ft ² (75.0 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.

Revised: May 2017

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