



# Imron® Elite Productive Basecoat 3.5 VOC (EY quality)



## GENERAL

### DESCRIPTION

A 3.5 lbs/gal (420 g/l) VOC, two-component polyurethane basecoat designed for high-performance for use on panel and overall repairs. It is formulated to deliver 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 Axalta Commercial Transportation coatings. Must be clearcoated with Imron Elite Productive 8890S™, 8831S™ or EZ-3460S™ Clearcoat.

### 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



## 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	Volume
Imron Elite Productive Basecoat (EY quality)	3
294S™ 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 gallon.

Note: 8989S Accelerator will shorten pot life.

### INITIAL APPLICATION VISCOSITY

9-28 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 minutes 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%.

**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 (EY) must be clearcoated.
- Imron Elite Basecoat (EY) may be clearcoated wet-on-wet with 8890S™ 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**

130™ Acetone  
105™ 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.



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**DRY TIMES**

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

	<u>no accelerator</u>	<u>with 389S</u>	<u>with 8989S</u>
Dry to touch	4-6 hours	1-2 hours	½ -1 hour
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	1.0-1.5 mils DFT, or until hiding is achieved.
Gloss	high, when clearcoated
Color	available in solid, metallic and pearl colors
Flash point (closed cup)	see MSDS
Shelf life	12 months minimum

### RTS mixed 3:1 with:

Includes 389S	294S
Gallon weight pounds per gallon - average	8.93
Gallon weight grams per liter - average	1070
VOC AP pounds per gallon - maximum	3.5
VOC AP grams per liter - maximum	419
VOC LE pounds. per gallon - maximum	3.5
VOC LE grams per liter - maximum	419
Weight solids - average	60.8%
Volume solids - average	51.4%
Weight volatiles - average	39.2%
Weight water - average	0.0%
Volume water - average	0.0%
Weight exempt solvents - average	0.0%
Volume exempt solvents - average	0.0%
Theoretical square foot coverage per RTS gallon at 1 mil DFT	825 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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