

Commercial Transportation | Aviation

Product System Chart

Product	Components	Mix Ratio	VOC	Use Comments	Gun Set Up-HVLP Fluid Delivery	Flash / Dry Times
Epoxy Pre-Treatments	Epoxy Pre-Treatment 13238 SM Epoxy Pre-Treatment 13138 SM Pre-Treatment Activator	1 Part Primer 1 Part Activator	5.0	No additives required. No induction time. Viscosity: 9-11 secs Gardco EZ #3	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-10 oz/min	10 min. to touch 30 min. to prime/topcoat one med wet coat
	Epoxy Pre-Treatment Metalok® 235 SM Metalok 236 SM Activator	4 Parts Primer 1 Part Activator	3.5	No additives required. No induction time. Viscosity: 9-13 secs Gardco EZ #3	Pressure- 1.0 to 1.2 mm Gravity - 1.0 to 1.4 mm 8-10 oz/min	10 min. to touch 30 min. to prime/topcoat one med wet coat
Primers	Corlar® Corrosion-Resistant Epoxy Primer 13550 SM Chromate Epoxy Primer 13150 SM Epoxy Activator 13756 SM VOC- Exempt Reducer	3 Parts Primer 1 Part Activator 2 Parts Reducer	2.8	13813 SM up to 1 oz /RTS gallons Induction time: 30 minutes Viscosity: 17-21 secs Gardco EZ #2	Pressure- 1.0 to 1.4 mm Gravity - 1.0 to 1.4 mm 8-10 oz/min	10 hour pot life 2 hours to topcoat one medium coat
	Corlar Non-Chromate Epoxy Primer 13580 SM Corrosion-Resistant Epoxy Primer 13180 SM Epoxy Activator 13756S VOC- Exempt Reducer	4 Parts Primer 1 Part Activator 1 Part Reducer	2.7	13813S up to 1 oz /RTS gallons Induction time: 30 minutes Viscosity: 18-22 secs Gardco EZ #2	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-12 oz/min	8 hour pot life 30 min to touch 2-6 hours to topcoat one med coat
Surfacers	Corlar Non-Chromate Epoxy Surfacer 13580S Corrosion-Resistant Epoxy Primer 13180S Epoxy Activator 13756S VOC- Exempt Reducer	4 Parts Primer 1 Part Activator 0.5 Part Reducer	2.8	13813S up to 1 oz /RTS gallons Induction time: 30 minutes Viscosity: 18-22 secs Gardco EZ #2	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-12 oz/min	8 hour pot life Bake 130°F x 1hr touch 15 min/tape 1 hr High-Build 2-3 coats
	Uro™ Urethane Surfacer 13520 SM Uro Urethane Surfacer 13100 SM Polyurethane Activator	4 Parts Primer 1 Part Activator	2.1	1 to 2 oz of 13803 SM per RTS gal 1 to 2 oz of 13808 SM per RTS gal No induction time.	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-10 oz/min	2hr pot life w/ 13803S 45min pot life w/ 13808S dry to touch 30-45 min Flash between coats
Topcoats	Imron® Polyurethane Topcoat AF3500 TM Color Solid colors only 13110 SM Urethane Activator 13865 SM , 13875 SM , 13885 SM , 13895 SM Pot-Life Extenders 13765 SM , 13775 SM , 13785 SM , 13795 SM VOC- Exempt Reducers 13100S Urethane Activator can be used for small parts or repairs	2 Parts Topcoat 1 Part Activator .25 Part Pot Life Ext. .25 Part Reducer	3.5	1 oz of 13801 SM per RTS gallon 1 to 2 oz of 13803s per RTS gallon 1 to 2 oz of 13808S per RTS gallon 1 oz of 13813S Anti Crater /gal Viscosity: 15-20 seconds Zahn #2	Pressure- 1.0 to 1.4 mm 8-10 inches from surface Gravity - 1.2 to 1.4 mm 8-10 inches from surface E-Stat - 1.2 to 1.5 mm 12-14 inches from surface	8 hour pot life one med wet coat 15-45 min flash Apply either a second medium coat, Allow 15-45 mn flash followed by a third medium coat if not hid. Or apply second coat as a cross coat Fluid delivery: 8-10 oz/min
	Imron Polyurethane Basecoat AF700 TM Color Solid, Metallics, & Pearls 13100 SM Urethane Activator 13765S or 13775S VOC Exempt Reducers Check Viscosity 10-18 seconds Zahn EZ-#3 Target is 10-14 seconds	3 Parts Color 1 Part Activator Check Viscosity Prior to addition of Reducer	3.4	1 oz of 13801S per RTS gallon 1 to 2 oz of 13803S per RTS gallon 1 to 2 oz of 13808S per RTS gallon 1 oz of 13813S Anti Crater /gal	Pressure- 1.0 to 1.4 mm 8-10 inches from surface Gravity - 1.2 to 1.4 mm 8-10 inches from surface E-Stat - 1.2 to 1.5 mm 12-14 inches from surface Fluid Delivery 8-10 ounces per minute	Accelerator aids in dry to tape, Solid colors - Apply either a cross coat or two medium coats. Effect - Medium first (1st) coat Don't achieve complete hiding Follow with a 2nd medium coat Apply 45° orientation coat as needed Don't Spray like Single Stage
	Imron Polyurethane Topcoat AF400 TM Color Solid and Metallics 13110S Activator for overall Solid Colors 13100S Activator for Effect Colors for Overalls, Stripes, and Repair 13765S, 13775S, 13785S VOC- Exempt Reducers	3 Parts Color 1 Part Activator Reduce per viscosity	3.4	1 to 2 oz of 13801S per RTS gallon 1 to 2 oz of 13803S per RTS gallon 1 to 2 oz of 13808S per RTS gallon 1 oz of 13813S Anti Crater /gal Viscosity: 9-13 seconds Zahn #3	Pressure- 1.0 to 1.4 mm Gravity - 1.2 to 1.6 mm Fluid delivery: 8-10 oz/min.	2 hour pot life one med wet coat 5- 15 min flash second coat is a wet cross coat Gloss can be adjusted.
Clearcoats	Imron Polyurethane Clearcoat -Split Base/Overall AF740 TM Clearcoat 13110S Urethane Activators 13775S, 13930 SM Reducer Check Viscosity 10-13 seconds Zahn EZ-#3	3 Parts Color 2 Parts Activator 1 Part	3.4	1 to 2 oz of 13801S per RTS gallon 1 to 2 oz of 13803S per RTS gallon 1 to 2 oz of 13808S per RTS gallon 1 oz. of 13813S per gallon for contamination	Pressure- 1.0 to 1.4 mm 8-10 inches from surface Gravity - 1.2 to 1.4 mm 8-10 inches from surface E-Stat - 1.2 to 1.5 mm 12-14 inches from surface Fluid delivery: 8-10 oz/min.	Method 1: Apply 1st coat medium wet w/ 65% overlap. Allow to flash 5 min followed by 2nd medium wet coat with 65% overlap. Method 2: Apply 1st as a cross coat top to bottom, then side-to-side. Allow 5 min flash followed by 2nd coat side-to-side w/ 65% overlap. DFT: 2.0-2.5 Wet 4-5 mils
	Imron Polyurethane Clearcoat - Stripes only AF740 Resistant Clearcoat 13110S Urethane Activators 13765S, 13775S Reducer Check Viscosity 10-13 seconds Zahn EZ#3 For E bands, Reg numbers, and Repairs replace 13110S with 13100S	3 Parts Color 2 Parts Activator 1 Part	3.4	1 to 2 oz of 13803S per RTS gallon 1 to 2 oz of 13808S per RTS gallon 1 oz. of 13813S per gallon for contamination	Pressure- 1.0 to 1.4 mm 8-10 inches from surface Gravity - 1.2 to 1.4 mm 8-10 inches from surface E-Stat - 1.2 to 1.5 mm 12-14 inches from surface Fluid delivery: 8-10 oz/min.	Accelerator aids in dry to tape, Will increase orange peel/texture Gloss may die back Apply first (1st) coat in medium wet application 65% overlap. Follow with wet second (2nd) coat after clear has been refreshed.

Customer Name

Distributor Name

