



Imron® EZ-3460S™ Clearcoat



GENERAL

DESCRIPTION

A 3.5 lb. /gal (420 g/l) VOC, two-component, easy clean, polyurethane clearcoat designed for overall refinishing. It provides excellent cleaning properties (resists dirt, road tar and tree sap), durability and chemical resistance.

SUGGESTED USES

Designed for overall repairs.

RECOMMENDED FOR USE OVER

Imron Elite Basecoat (EB Quality)
Imron Elite Productive Basecoat (EW Quality)
Imron Elite Express Basecoat (EG Quality)
Imron Elite Single Stage Topcoat (EA Quality)
Imron Elite Productive Single Stage Topcoat (EX Quality)
Imron Elite Express Single Stage Topcoat (EF Quality)

NOT RECOMMENDED FOR

Immersion service or over alkyd enamels, acrylic enamels 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

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

MIX RATIO

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

Components

Components	Parts by Volume
Imron EZ-3460S Clearcoat	3
Imron EZ-3461S™ Activator	1

ADDITIVES

Extend pot life and improve dry time:

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

INITIAL APPLICATION VISCOSITY

12-14 seconds with #3 Zahn Cup

INDUCTION TIME

No induction time is required.



IMRON™

POT LIFE - 70°F (21°C)

2 hours as activated
2-4 hours with 389S™ Accelerator.



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%. For optimum application and appearance, the clearcoat should be heated to 90°F (32°C).

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 EZ-3460 can be applied wet-on-wet over Imron Elite EB basecoat solid and metallic colors / Imron Elite EA topcoat solid colors with minimal flash times.
- For wet-on-wet applications, the base color must be activated with Imron EZ-3461S Activator
- Imron Elite EG and EW basecoat qualities should flash for 30 minutes prior to clearcoat application
- Imron Elite EF and EX topcoat solid colors should flash for 30 minutes prior to clearcoat application
- Allowing Imron Elite EA / EF / EX topcoat metallic colors to cure overnight prior to application of clearcoat is recommended to avoid mottling of the metallic flake.
- Imron Elite basecoat and topcoat should be lightly scuff-sanded if allowed to dry for more than 16 hours prior to application of Imron EZ-3460.
- When recoating Imron EZ-3460S with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.
- Imron EZ-3460S can only be repaired with itself. Do not use other products for spot or panel repairs. Imron EZ-3461S Activator must be used in the Imron basecoat / topcoat during the repair to the Imron Basecoat / Imron EZ-3460S finish.
- 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 VOC.

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 shorten pot life and cause product to gel.



DRY TIMES

AIR DRY

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

	Without 389S	With 389S
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

30 minutes at 140-160°F (60-71°C).



PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	7.86 lbs.
Weight Per Liter (component only)	942 grams
Suggested Dry Film Thickness	1.8 – 2.2 mils
Gloss	High
Color	Clear
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

RTS mixed 3:1 with:

Includes 389S

Gallon Weight pounds per gallon	8.17
Gallon Weight grams per liter	979
VOC AP pounds per gallon	3.3
VOC AP grams per liter	398
VOC LE pounds. per gallon	3.5
VOC LE grams per liter	414
Weight Solids	56.1%
Volume Solids	48.3%
Weight Volatiles	43.9%
Weight Water	0.0%
Volume Water	0.0%
Weight Exempt Solvents	3.2%
Volume Exempt Solvents	3.9%
Theoretical Coverage per RTS Gallon at 1 mil DFT	775 ft ² (72.0 m ²)

EZ-3461S

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: November 2021

In the United States:
1.855.6.AXALTA
axalta.us

In Canada:
1.800.668.6945
axalta.ca

