



# Excel™ Pro Topcoat 2.8 VOC (EZ quality)



## GENERAL

### DESCRIPTION

A 2.8 lb/gal (340 g/l) VOC, two-component, acrylic urethane topcoat designed for panel and overall applications. Excel Pro is ideal for refinishers who want a cost-effective finish that features good performance, good color capability and very good appearance. Available in solid and metallic colors, this topcoat uses the Axalta Multi-Temperature reducer platform.

### COMPATIBILITY WITH OTHER COATINGS

Compatible with all Axalta Transportation primer systems.

### NOT RECOMMENDED FOR

- Immersion Service
- Use over lacquer finishes

### DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Weatherability	VERY GOOD
Humidity Resistance	EXCELLENT
Acid Resistance	EXCELLENT
Alkali Resistance	EXCELLENT
Solvent Resistance	VERY GOOD
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT



## 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.

Component	Volume
Excel™ Pro "EZ" Quality	2.5
15309S™ Low VOC Activator	1

### ADDITIVES

#### Pot Life Extension:

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

#### Increased cure (small area repair, stripes):

Add up to 2 oz. 389S™ Accelerator per RTS gallon.

Note: 8989S™ Accelerator will shorten pot life, and is not recommended.

### VISCOCITY

Depending on color 10-20 seconds in a Zahn #3.

### INDUCTION TIME

No induction time required.

### POT LIFE - 70°F (21°C)

30 minutes as activated  
1 hour with 189S™ accelerator  
45 minutes with 389S™ 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

- 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 Excel™ Pro with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.

### APPLICATION SOLVENTS

Ready-to-spray VOC is below 2.8 lbs. /gal VOC upon activation. Further reduction may result in greater than 2.8 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 cause gelation.



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## DRY TIMES

### AIR DRY

Cure Time At Recommended Thickness – 77°F (25°C) and 50% RH

Dry to Touch	With 189S™	With 389S™
Tack Free	3-5 hours	30-60 minutes
Tape Free	6-8 hours	2-3 hours
Dry to Assemble	10-12 hours	3-5 hours
	72 hours	72 hours

### FORCE DRY

30 min between 120°F-140°F (48°C- 60°C) after a flash time of 15 min following application of final coat.

### Point to Point Melt-In Guide - 70°F (25°C) AND 50% RH

Activator	Mixing Reducer	Flash Time
15309S™	15375S™ Low Temp Reducer	5-10 min
15309S™	15385S™ Mid Temp Reducer	10-15 min
15309S™	15395S™ High Temp Reducer	15-20 min
15309S™	15397S™ High Temp Reducer	20-25 min

Depending on the surface area being coated, air temperature, and booth air flow, the above combinations of mixing reducers should provide excellent overspray melt-in for the stated times.

### HOT WEATHER APPLICATION



In addition to using the high temperature activator and reducers, add up to 10% by volume 15399S™ High Temp Additive to unactivated Excel™ Pro color and activate 2.5:1.

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## 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	1.8 – 2.2 mils
Gloss	High
Color	Available in Solid and Metallic Colors
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

### RTS mixed 2.5:1 with:

#### Includes 389S

	15309S
Gallon Weight pounds per gallon - Average	9.07
Gallon Weight grams per liter - Average	1087
VOC AP pounds per gallon - Maximum	2.5
VOC AP grams per liter - Maximum	300
VOC LE pounds. per gallon - Maximum	2.8
VOC LE grams per liter - Maximum	340
Weight Solids - Average	62.4%
Volume Solids - Average	53.0%
Weight Volatiles - Average	37.6%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	10.0%
Volume Exempt Solvents - Average	12.6%
Theoretical Coverage per RTS Gallon at 1 mil DFT	850 ft <sup>2</sup> (79.0 m <sup>2</sup> )

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## 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.

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## 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.

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