Imron® 6600 CT Basecoat (CT Quality)

GENERAL

DESCRIPTION
A low solids, 3.5 lb/gal (420 g/l) VOC, 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.

SUGGESTED USES
Panel, multi-panel, overall and two-tone applications
Commercial vehicles, transit bus, recreation/leisure and 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™, 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 6600 CT Basecoat (CT quality)	4
Axalta Activator per below	1
Imron 66xxS Application Binder	12

6665S™ Application Binder - Fast
6675S™ Application Binder - Medium
6685S™ Application Binder - Slow

Note: Hand shake the 6675S / 6675S / 6685S Application Binder prior to use.

Activator used for Basecoat mix ratio is the same activator for the clearcoat selected.
- Use 15305S™ when 8430S clearcoat is selected.
- Use 294S™ when 8890S clearcoat is selected.
- Use 15309S™ when 8831S clearcoat is selected.

Note: Activator amount may be increased to 1.5 parts to assist with surface wetting on larger surface area or higher temperature application.

ADDITIVES
Pot Life extension: Not recommended.
Increased cure: Not recommended.

VISCOSITY
16-22 seconds with #2 Zahn Cup, depending on color.

INDUCTION TIME
No induction time required.

POT LIFE - 70°F (21°C)
8 hours

APPLICATION

APPLICATION EQUIPMENT
Gravity Feed
Pressure Pot – agitating model preferred

GUN SETUPS

Compliant Gravity Feed:	1.3-1.4 mm
HVLP Gravity Feed:	1.3-1.4 mm
Pressure Pot:	1.0-1.2 mm

AIR PRESSURE

Compliant Gravity Feed:	18-20 psi at the heel	
Compliant Pressure Pot:	18-20 psi at the heel	10-12 fluid oz. per minute

Refer to spray equipment documentation for spray gun specific recommendations.

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%.

SUBSTRATES
Properly sanded OEM finishes
Sanded URO® Primer 1220S™ / 1380S™
Properly flashed primer – sealers:
821CR™ Corlar Epoxy Primer
921S™ Corlar Epoxy Primer
934S™ Corlar High Solids Epoxy Primer

SANDING PREPARATION

	Sanding - with No sealer	**Sanding - with Sealer**
Dry - Mechanical or Hand	P500 or finer (solids)	P400 or finer
Dry - Mechanical or Hand	P600 (metallic)	P400 or finer
Wet	P600	P400 or finer

APPLICATION
- Apply 2 wet coats or until hiding is achieved, using a single pass with flash before additional passes are applied.
- Overlap of stroke fan pattern should be 70%
- Hand shake the spray equipment paint vessel prior to application of each coat of material to ensure full incorporation of the ready to spray material. Settling of the material takes place while idle.

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APPLICATION (CONTINUED)

- When applying additional coats of basecoat, allow the previous basecoat to flash to a consistent dull appearance. In general, higher number of coats will require additional time to flash dull.
- For high aluminum colors, a flake alignment coat may be applied for improved orientation. This would be performed once hiding is achieved, by immediately applying the alignment pass at an increased panel to spray nozzle distance (add approximately 4 to 6") and slightly faster stroke speed (approximately 50% increase).
- Basecoat must be clearcoated.
- When recoating Imron 6600 CT Basecoat with itself, sanding is required if the basecoat has air dried more than 24 hours or has been force dried.

BASECOAT BLENDING

6650S Blender is used as a blending bed to perform the color blend into to assist with color transition.

- Hand Shake 6650S Blender prior to use.
- 6650S Blender is activated 16 parts blender to 1 part activator. Activator used is the same activator chosen for use in the basecoat color.
- Prepare the area for full panel clearcoat. Sand repair area with grit recommendation above. The blend area is to be sanded with P600 or finer.
- Apply color to full hiding over the repair area. Apply subsequent coats just beyond the previous coats.
- With a second spray gun, apply activated 6650S Blender to the remainder of the panel. Apply from the outer surface back to the repair area.
- Immediately apply a final coat of basecoat to the repair area, tapering out the transition of the new color into the old color.
- Clearcoat is recommended as full panel application.

SANDING

Basecoat may be nib or color sanded upon dry. Any nibbed or sanded basecoat must be recoated with itself prior to clearcoating. Nib with P1000 grit, Color sand with P800 Wet.

APPLICATION SOLVENTS

Not recommended. Ready to spray below 3.5 lbs. /gal VOC upon activation and reduction with Application Binder.

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.

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

Flash before Clearcoat	20 - 40 minutes*
Flash before Two Tone	45 – 60 minutes
Maximum Dry Time before Clearcoating:	24 hours

*Flash before clearcoat is equal to 10 minutes per coat times the number of coats.

FORCE DRY

Not recommended

RECOATABILITY/RE-REPAIR

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Basecoat may be recoated with itself within 24 hours when air dried.

Maximum Service Temperature:	200°F (92°C) in continuous service
Weight Per Gallon (component only)	11.0 pounds (average)
Weight Per Liter (component only)	1320 grams (average)
Suggested Dry Film Thickness	Apply until hiding is achieved. Solid and effect colors: 0.5-1.0 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

	15303S / 15309S
RTS mixed 4:1:12 with 6685S	**294S**
Gallon Weight pounds per gallon – Average	10.49
Gallon Weight grams per liter – Average	1256
VOC AP pounds per gallon – Maximum	1.4
VOC AP grams per liter – Maximum	168
VOC LE pounds. per gallon – Maximum	3.5
VOC LE grams per liter – Maximum	420
Weight Solids – Average	23.7%
Volume Solids – Average	19.0%
Weight Volatiles – Average	76.3%
Weight Water – Average	0.0%
Volume Water – Average	0.0%
Weight Exempt Solvents - Average	64.6%
Volume Exempt Solvents - Average	81.0%
Theoretical Coverage per RTS Gallon at 1 mil DFT	304 ft^2 (28.3 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.

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