



# Imron® Medium Solids Topcoat 5.0 VOC (EU Quality)



## GENERAL

### DESCRIPTION

A 5.0 lb. /gal (600 g/l) VOC, two-component, polyurethane topcoat designed for overall applications. This medium solids topcoat is very durable and features a high gloss finish.

### SUGGESTED USES

Designed for overall applications.

### NOT RECOMMENDED FOR

Immersion service or over lacquer finishes.

### COMPATIBILITY WITH OTHER COATINGS

Compatible with all Axalta Transportation primer systems.

### DRY FILM CHARACTERISTICS

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

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
Imron Medium Solids Topcoat (EU quality)	3
Imron V-192S™ Activator	1

### ADDITIVES

#### Pot Life Extender

Add up to 2 oz. of 189S™ accelerator per RTS gallon

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

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

Note: 389S™ accelerator will shorten pot life.

### INITIAL APPLICATION VISCOSITY

17-24 seconds with #2 Zahn Cup, depending on color.

### INDUCTION TIME

No induction time required.

### POT LIFE - 70°F (21°C)

1 hour as activated

2 hours with 189S accelerator.



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## APPLICATION

### APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.

Pressure Pot  
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

- Apply a medium wet first coat. Allow to tack. Follow with a full wet second coat to achieve desired film build and coverage. If desired hiding has not been reached, allow to tack and apply an additional full wet coat.
- Sanding is recommended for recoating if the topcoat has been air-dried more than 16 hours or force dried.

### ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will cause the product to gel.

### APPLICATION SOLVENTS

Ready-to-spray VOC is below 5.0 lbs. /gal VOC upon activation. Further reduction may result in greater than 5.0 VOC.

### CLEANUP SOLVENTS

130™ Acetone  
105™ Lacquer Thinner  
107™ Low VOC Gun Cleaner  
108™ Low HAPS Cleaning Solvent



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## DRY TIMES

### AIR DRY

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

	No Accelerator	With Accelerator
Dry to Touch	1 hour	30 min
Tack Free	3 hours	1-2 hours
Tape Free	6-10 hours	3-5 hours
Dry to Assemble	72 hours	72 hours

### FORCE DRY

30 minutes at 140°F (60°C)



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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 3:1 with:**

**Includes 189S**

	<b>V-192S</b>
Gallon Weight pounds per gallon - Average	8.73
Gallon Weight grams per liter - Average	1046
VOC AP pounds per gallon - Maximum	4.5
VOC AP grams per liter - Maximum	543
VOC LE pounds. per gallon - Maximum	4.7
VOC LE grams per liter - Maximum	559
Weight Solids - Average	45.9%
Volume Solids - Average	35.3%
Weight Volatiles - Average	54.1%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	2.2%
Volume Exempt Solvents - Average	2.9%
Theoretical Coverage per RTS Gallon at 1 mil DFT	567 ft <sup>2</sup> (53.7 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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