



## Imron® Elite Productive Topcoat 3.5 VOC (EX quality)



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### GENERAL

#### DESCRIPTION

A 3.5 lb. /gal (420 g/l) VOC, two-component, productive, polyurethane topcoat designed for panel and overall and two-tone applications. It features an extensive color palette, premium appearance and excellent performance. Available in solid and metallic colors, this topcoat uses the Axalta Multi-Temperature activator/reducer platform.

#### SUGGESTED USES

- Panel, multi-panel, overall and two-tone applications
- Commercial vehicles, transit bus and light rail, beverage and delivery trailers, emergency vehicles

#### 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	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.



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### MIXING

#### COMPONENT

Imron Elite Productive (EX Quality)  
15303S™ Low Temp Activator  
15305S™ Mid Temp Activator  
15307S™ High Temp Activator  
15308S™ Very High Temp Activator

#### 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 Elite Productive (EX Quality)	3
15303S / 15305S / 15307S / 15308S Activator	1

#### ADDITIVES

##### Pot Life Extension:

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

**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.

**VISCOSITY**

Depending on color, the activated paint will have a viscosity of 10-20 seconds in a #3 Zahn cup.

**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 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**

- 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 Imron Elite Productive with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.

**ADDITIONAL COMMENTS**

Heating activated material above 110°F (43°C) will cause gelation.

**APPLICATION SOLVENTS**

Ready-to-spray VOC (LE) is below 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



## DRY TIMES

### AIR DRY

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

	With 189S	With 389S
Dry to Touch:	3-5 hours	0.5-1 hr
Tack Free:	6-8 hours	2-3 hours
Tape Free:	10-12 hours	3-5 hours
Dry to Assemble:	72 hours	72 hours

### FORCE DRY

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

### POINT TO POINT MELT-IN GUIDE - 70°F (21°C) AND 50% RH

Activator	Mixing Reducer	Time
15303S	15375S Low Temp Reducer	5-10 min
15305S	15385S Mid Temp Reducer	10-15 min
15307S	15395S High Temp Reducer	15-20 min
15308S	15397S Extra Slow Reducer	20-25 min

Depending on the surface area being coated, air temperature, and booth air flow, the above combinations of activators and mixing reducers will assist with 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 Imron Elite Productive color and activate 3:1.



## 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 389S

Gallon Weight pounds per gallon - Average	9.13
Gallon Weight grams per liter - Average	1094
VOC AP pounds per gallon - Maximum	3.0
VOC AP grams per liter - Maximum	363
VOC LE pounds. per gallon - Maximum	3.4
VOC LE grams per liter - Maximum	403
Weight Solids - Average	59.2%
Volume Solids - Average	48.3%
Weight Volatiles - Average	51.7%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	7.6%
Volume Exempt Solvents - Average	9.7%
Theoretical Coverage per RTS Gallon at 1 mil DFT	775 ft <sup>2</sup> (72.0 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.

**Revised: November 2021**

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