



# Axalta 13520S™ Urethane Surfacer



## GENERAL

### DESCRIPTION

A sanding urethane primer-surfacer that provides a level, texture-free surface for single or multi-stage topcoats. It provides productive dry times and excellent topcoat holdout. This high-solids primer has a ready-to-spray VOC of less than 2.9 lbs. /gal.

### RECOMMENDED USES

13520S is recommended for use as a sanding surfacer over properly treated and/or primed substrates. 13520S is ideal for spot-repair or similar applications requiring productive dry times. It is compatible with most epoxy primers and polyurethane topcoats. 13520S is recommended for use with:

Primers	Corlar® 13550S™
Surfacers	Corlar 13580S™
Topcoats	Imron® AF3500™, Imron AF400™
Basecoat/Clearcoat	Imron AF700™

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



## MIXING

### COMPONENTS

13520S Urethane Surfacer  
13100S™ Polyurethane Activator

### MIX RATIO

Thoroughly mix 13520S prior to activation. Filter activated material prior to spray application.

<u>Component</u>	<u>Parts by Volume</u>
13520S Urethane Surfacer	4
13100S Polyurethane Activator	1

### ADDITIVES

#### To improve dry time

- Add up to 2 oz. 13803S™ Accelerator per RTS gallon

#### For fast dry, limited are work

- Add up to 1 oz. 13808S™ Accelerator per RTS gallon

### INDUCTION TIME

No induction time is required.

### POT LIFE

1 hour at 70°F (21°C)  
2 hours with 2 oz. /gal. of 13803S at 70°F (21°C)  
45 minutes with 1 oz. /gal. of 13808S at 70°F (21°C)



## APPLICATION

### SUBSTRATES AND SURFACE PREPARATION

Substrate must be properly prepared for application. 13520S is recommended for application over epoxy primers including Corlar 13550S and over epoxy surfacers including



Corlar 13580S. Follow primer or surfacer recoat-window guidelines to ensure proper adhesion—scuff sanding before 13520S™ application as required.

### GUN SETUP

13520S can be applied with conventional, HVLP, and electrostatic spray equipment using pressure, or gravity fluid delivery.

#### Conventional Fluid Tip

Pressure Pot	1.2 mm-1.5 mm (.047"- .059")
Gravity Feed	1.3 mm-1.6 mm (.051"- .063")

#### HVLP

Pressure Pot	1.0 mm-1.4 mm (.039"- .055")
Gravity Feed	1.2 mm-1.5 mm (.047"- .059")

### FLUID DELIVERY

Conventional	8-10 oz./minute
HVLP	8-10 oz./minute

### AIR PRESSURE

Conventional	50-60 psi atomizing air
HVLP	25-30 psi atomizing air

### ENVIRONMENTAL CONDITIONS

Substrate and ambient temperature must be between 50°F (10°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated material above 110°F (43°C) may cause gelation.

### APPLICATION

Apply using a cross-coat technique. Spray a wet first coat using a top-to-bottom motion. Spray a medium-wet second coat using a side-to-side motion. No flash is required between coats. Apply to a maximum dry-film thickness of 2.5 mils (approximately 5 mils wet).

### CLEANUP SOLVENTS

Axalta 107™ Low VOC Gun & Equipment Cleaner  
Axalta 105™ Gun & Equipment Cleaner



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## DRY TIMES

### AIR DRY

At 70°F (21°C) with 2 oz 13803S per ready-to-spray gallon

Dry to Touch	30 minutes
Dry to Sand	1 hour

### FORCE DRY

At 130°F (54°C) with 2 oz 13803S per ready-to-spray gallon

Flash Before Force Dry	None required
Dry to Touch	15 minutes
Dry to Sand	45 minutes

### RECOAT

Prior to topcoat application, sand with 240-grit or higher using a dual action orbital sander. For optimal topcoat appearance, sand or finish sand with 320-grit or higher. Recoat window is 16 hours for 13520S which has been either air dried or force dried for up to 1 hour at 130°F (54°C).



## PHYSICAL PROPERTIES

### VOC

	Less Exempts (LE)	As Packaged (AP)
13520S	2.4 lbs./gal	2.0 lbs./gal
Ready-to-Spray 13520S	2.4 lbs./gal	2.0 lbs./gal

### FACTORY-PACKAGED PRIMER

Color	Light Gray
Closed Cup Flash Point	20°F-73°F
Shelf Life	2 years (Unopened at 50°-110°F)

### READY-TO-SPRAY

Theoretical Coverage	925 ft <sup>2</sup> /gal at 1 mil dry film thickness
Weight Solids	76%
Volume Solids	58%
Gallon Weight	12.0 lbs./gal

### DRY FILM

Gloss	Satin
Recommended Film Thickness	1.2-2.5 mils dry

### COATING PERFORMANCE

Adhesion	Excellent
Chemical and Solvent Resistance	Excellent
Weatherability w/ Topcoat	Excellent
Topcoat Holdout	Excellent
Humidity Resistance	Excellent
Flexibility	Very Good

## 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 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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In the United States:  
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In Canada:  
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axalta.ca

