IMRON™

# Imron® AF3500™ Polyurethane Topcoat (EJ Quality)

## GENERAL

### DESCRIPTION

A 3.5 VOC compliant polyurethane topcoat intended for use on jet aircraft. This high-performance topcoat is designed to deliver premium appearance and durability. It is available in factory packaged whites and mixed solid colors.

### RECOMMENDED USES

Imron® AF3500™ is recommended for jet aircraft and similar general aviation applications where exceptional appearance, long-term fluid resistance, and outstanding durability are required. Imron® AF3500™ is recommended for use with:

| | |
|---|---|
| Epoxy Primer/Surfacer | Corlar® 13550S™, Corlar® 13580S™ |
| Basecoat/Clearcoat | Imron® AF700™, Imron® AF740™ |

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

## MIXING

### COMPONENTS

Imron® AF3500™ mixed color (EJ Quality)
Imron® AF3503™ Snow White Factory Package
Imron® AF3504™ Matterhorn White Factory Package
Imron® AF3523™ Matterhorn White High Rheology Factory Package
13110S™ Activator
13100S™ Activator (Small Parts/Repair)
Imron® 13865S™ Fast Pot-Life Extender
Imron® 13875S™ Medium Pot-Life Extender
Imron® 13885S™ Slow Pot-Life Extender
Imron® 13895S™ Very Slow Pot-Life Extender
13765S™ Fast VOC-Exempt Reducer
13775S™ Medium VOC-Exempt Reducer
13785S™ Slow VOC-Exempt Reducer
13821S™ Fast Reducer with Rheology Control

Imron pot-life extenders and VOC-exempt reducers are available for a range of application conditions. Suggested usage ranges are dependent on the air flow and relative humidity.

| | 70°F | 80°F | 90°F | 100°F |
|---|---|---|---|---|
| Riveted Aircraft | 13865S<br>13821S | 13875S<br>13821S | 13885S<br>13821S | 13895S<br>13821S |
| Flush-Surface Aircraft | 13865S<br>13765S | 13875S<br>13765S | 13885S<br>13775S | 13895S<br>13785S |

### MIX RATIO

Thoroughly mix Imron AF3500 color prior to activation. Filter activated material prior to spray application.

| **Components (Riveted)** | **Regular Parts by Volume** | **Small Parts/Repair Parts by Volume** |
|---|---|---|
| Imron® AF3500™ Color (EJ Quality) | 2 | 2 |
| 13110S / 13100S Activator | 1 (13110S) | 1 (13100S) |
| Imron 138X5S Pot-Life Extender | 0.25 | 0.25 |
| ***13821S Rheology Reducer*** | 0.25 | 0.25 |

| Components (Flush-Surface) | Regular Parts by Volume | Small Parts/Repair Parts by Volume |
|---|---|---|
| Imron® AF3500™ Color (EJ Quality) | 2 | 2 |
| 13110S / 13100S Activator | 1 (13110S) | 1 (13100S) |
| Imron 138X5S Pot-Life Extender | 0.25 | 0.25 |
| ***137X5S VOC-Exempt Reducer*** | 0.25 | 0.25 |

### VISCOSITY
15-20 seconds in a Zahn #2 cup.

Listed ranges were established using GARDCO EZ Zahn (ASTM) Cup. measuring with other Zahn type cups may provide different results.

### INDUCTION TIME
No induction time is required prior to application.

### POT LIFE
8 hours at 70°F (21°C)

### ADDITIVES
**Accelerator**
- Add up to 2 oz. 13803S™ per RTS gallon
- Add up to 1 oz. 13808S™ per RTS gallon for spot work only

**Anti-Crater**
- Add up to 1 oz. 13813S™ per RTS gallon
- Do not use FEE

## APPLICATION

### SUBSTRATES AND SURFACE PREPARATION
Surface preparation is critical to topcoat appearance. Primer and surfacer should be properly applied and cured per product recommendations. Surfaced substrate should be DA sanded with 320-grit or finer paper for best appearance. Substrate should always be thoroughly wiped/tacked immediately prior to topcoat application.

### 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. For optimum appearance spray Imron® AF3500™ at 75°F (24°C) or warmer.

### GUN SETUP
Imron® AF3500™ can be applied with conventional, HVLP, air-assisted airless and electrostatic spray equipment using pressure or gravity fluid delivery.

**Conventional Fluid Tip**

| | |
|---|---|
| Pressure Pot | 1.2 mm-1.6 mm (.047”-.063”) |
| Gravity Feed | 1.4 mm-1.6 mm (.055”-.063”) |

**HVLP**

| | |
|---|---|
| Pressure Pot | 1.0 mm-1.4 mm (.039”-.055”) |
| Gravity Feed | 1.2 mm-1.6 mm (.047”-.063”) |

### FLUID DELIVERY

| | |
|---|---|
| Conventional | 10-12 oz./minute |
| HVLP | 10-12 oz./minute |

### AIR PRESSURE

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

### APPLICATION

Spray a medium-wet first coat. Allow first coat to flash for 30-45 minutes and tack-up prior to second coat. Apply second coat as a wet cross-coat to achieve 2.0-2.5 mils dry film build.

### CLEANUP SOLVENTS

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

## DRY TIMES

### AIR DRY

At 70°F (21°C)

| | |
|---|---|
| Dry to Touch | 12 hours |
| Dry to Tape | 24 hours |

### FORCE DRY

At 130°F (54°C)

| | |
|---|---|
| Flash Before Force Dry | 3 hours |
| Dry to Touch | 6 hours |
| Dry to Tape | 10 hours |

### RECOAT

When recoating Imron® AF3500™ with itself, Imron® AF700™, Imron® AF740™ clearcoat for stripes, or Imron® AF400™ topcoat for stripes, scuff sanding is required if the topcoat has air dried for more than 36 hours or if the topcoat has been force dried.

## PHYSICAL PROPERTIES

| VOC | Less Exempts (LE) | As Packaged (AP) |
|---|---|---|
| Imron AF3500 | 3.6 lbs./gal | 3.6 lbs./gal |
| RTS Imron AF3500 | 3.5 lbs./gal | 3.2 lbs./gal |

### FACTORY-PACKAGED AND MIXED COLORS

| | |
|---|---|
| Color | Whites and solid colors |
| Closed Cup Flash Point | 20°F-73°F |
| Shelf Life | Factory Package – 2 yrs. (Unopened at 50°-110°F) |
| | Mixed Color – 1 yr. |

### READY-TO-SPRAY* (WILL VARY WITH COLOR)

| | |
|---|---|
| Theoretical Coverage | 780 $ft^2$/gal average at 1 mil dry film thickness (775-790 $ft^2$/gal) |
| Weight Solids | 60% average (55-64%) |
| Volume Solids | 49% average (48-50%) |
| Gallon Weight | 9.4 lbs./gal average (8.4-10.3 lbs./gal) |

*Using Imron 13875S Pot-Life Extender and 13765S VOC-Exempt Reducer

### DRY FILM

| | |
|---|---|
| Gloss | ≥ 90 measured at 60° |
| Recommended Film Thickness | 2.0-2.5 mils |

### COATING PERFORMANCE

| | |
|---|---|
| SKYDROL Resistance | Excellent |
| Chemical and Solvent Resistance | Excellent |
| Weathering | Excellent |
| Humidity Resistance | Excellent |
| Acid and Alkali Resistance | Excellent |
| Abrasion Resistance | Excellent |
| Flexibility | Excellent |

## 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:**
**1.855.6.AXALTA**
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**In Canada:**
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