



IMRON® ELITE EXPRESS B/C POLYURETHANE ENAMEL BASECOAT

TYPE

A productive, high solids, high-performance, low VOC, two-component polyurethane enamel basecoat.

DESCRIPTION

Imron® Elite Express BC Basecoat is designed to deliver premium quality and performance at a maximum applied VOC of 3.5 lbs/gal. The Imron® Elite Express BC Basecoat line includes factory package and mixing machine capability. Imron® Elite Express BC Basecoat is ultra low in HAPS, and is lead and chrome free.

SUGGESTED USES

A high-gloss, extremely durable, chemical and solvent resistant air-dry enamel that is available in solid, metallic and pearl colors. It is an extremely versatile product and is recommended for use on commercial vehicles, trucks, trailers and other applications where superior performance and appearance is required.

NOT RECOMMENDED FOR

- Immersion service
- Use over lacquer finishes

COMPATIBILITY WITH OTHER COATINGS

- Compatible with all DuPont OEM Primer systems
- Must be clear coated with DuPont 8420S™ or 8840S™ clear coats

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 clear coated with 8420S™ or 8840S™

MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service

VOLUME SOLIDS – WILL VARY WITH COLOR SELECTED

- 47.0% average unactivated
- 51.0% average RTS mixed 3:1 w/DuPont™ 196S™ Activator

WEIGHT SOLIDS – WILL VARY WITH COLOR SELECTED

- 58.0% average unactivated
- 62.5% average RTS mixed 3:1 w/DuPont™ 196S™ Activator

WEIGHT PER GALLON

- 9.79 lbs/gal average unactivated

SUGGESTED DRY FILM THICKNESS

- Apply to Hiding
- Solid and Effect Colors: 1.0 – 1.5 mils DFT, depending on color

THEORETICAL COVERAGE PER GALLON

- 754 sq. ft./gal average @1mil DFT

GLOSS

- High when clear coat is applied

COLOR

- Available in solid, metallic and pearl colors

FLASH POINT (CLOSED CUP)

- Between 20 - 70°F (-7 to 23°C)

SHELF LIFE

- 12 months minimum

APPLICATION SOLVENTS

Ready-to-spray below 3.5 lbs/gal VOC upon activation. Further reduction may result in greater than 3.5 VOC.

CLEANUP SOLVENTS

- DuPont 3602S™ Thinner
- DuPont 8475S™ Reducer



ACTIVATION (MIX RATIO)

Add 3 parts Imron® Elite Express BC Basecoat with 1 part DuPont 196S™ activator and mix thoroughly. Filter material prior to spray application. To an activated gallon, add up to 2 oz. DuPont 189S™ Accelerator to extend pot life. (Note: MasterTint® 389S™ and 8989S™ will shorten pot life and is not recommended.) Activated product will have a viscosity of 10 – 18 seconds in a Zahn 3 cup, depending on color.

INDUCTION TIME

- No induction time required

POT LIFE

- 1 hour at 70°F (21°C)
- 1.5 hours at 70°F (21°C) with 2 oz DuPont 189S™ per activated gallon

ADDITIONAL COMMENTS

- Heating activated material above 110°F (43°C) will cause gelling.
- When recoating Imron® Elite Express BC Basecoat with itself, sanding is required if the enamel has air dried more than 8 hours, or has been force dried.

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

- Thoroughly mix Imron® Elite Express BC Basecoat prior to activation.
- For pressure pot application, set air pressure at 55 – 60 PSI at the gun for solid, metallic and pearl colors. Fluid delivery should be set for 10 – 12 fluid oz/min.
- For siphon gun application, set air pressure to 50 – 55 PSI at the gun for solids, metallic and pearl colors.
- 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. Flash times between coats will vary between 30 seconds and 5 minutes. In general, the shorter the flash the smoother the appearance.
- Imron® Elite Express BC Basecoat must be clear coated with either DuPont 8420S™ or 8840S™ Clear coat.
- Allow Imron® Elite Express BC Basecoat to flash a minimum of 30 minutes prior to application of clear coat, with a maximum time of 16 hours.

- Do not spray Imron® Elite Express BC Basecoat if the liquid paint temperature is less than 75°F (24°C). Use warm water or paint heaters to heat the paint to an optimum temperature of 85-95°F (29-35°C).
- In case of fish eyes, use 1 oz DuPont 359S™ Paint Additive per ready-to-spray gallon on Imron® Elite Express BC Basecoat for solid colors, use 1 oz of DuPont VG-F-70050™ for metallic colors. Do not use FEE.

CURE TIME AT RECOMMENDED THICKNESS – 77°F (25°C) & 50% RH

- * Basecoat only w/ DuPont 189S™ Accelerator
- Dry to Touch 30 minutes
- Tack Free 45 minutes
- Tape Free - Solids 45 minutes
- Tape Free – Metallics 60 minutes
- Dry to Clear coat 30 minutes to 16 hours

APPLICATION EQUIPMENT

- Pressure Pot (recommended)
- Gravity Feed
- Suction Spray
- HVLP or Conventional

ENVIRONMENTAL

VOC content (lbs/gal)	LE	AP
Imron® Elite Express BC (“EG” Quality)	3.9	3.9
RTS mixed 3:1 w/ DuPont 196S™	3.5	3.5

FOR VOC REGULATED AREAS

These directions refer to the use of products that may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

SAFETY AND HANDLING

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling and using. These products are for industrial use by trained professional painters only.

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