



TECHNICAL MANUAL

IMRON® EZ-3460S™

POLYURETHANE CLEARCOAT

TYPE

A two-component, low VOC (<3.5 lbs/gal), polyurethane enamel clearcoat.

DESCRIPTION

Imron® EZ-3460S™ Clearcoat is a two-component, polyurethane, low VOC clear designed for use with Imron® 6000™ polyurethane basecoat colors. Imron® EZ-3460S™ can also be used over Imron® 5000™. It has excellent cleaning properties and resists dirt, road tar and tree sap. This high gloss, extremely durable, chemical and solvent resistant, air dry clear resists yellowing and is easy to use. Imron® EZ-3460S™ has good flow out and excellent sag resistance.

SUGGESTED USES

When high chemical and graffiti resistance are desired, Imron® EZ-3460S™ is ideal for use over Imron® Elite BC, or Imron® 6000™ solid and metallic and pearl base colors, and can also be used over Imron® Elite SS or Imron® 5000™.

NOT RECOMMENDED FOR

- Immersion service.
- Use over Dulux® or other air dry alkyd enamels, Centari® or other air dry acrylic enamels, or over OEM, Lucite® or other air dry lacquer finishes.

COMPATIBILITY WITH OTHER COATINGS

Imron® EZ-3460S™ is recommended for use over Imron® Elite BC, Imron 6000™, Imron® Elite SS and Imron® 5000™ solid or metallic colors.

Note: For wet-on-wet applications, the base color must be activated with Imron® EZ-3461S™ Activator.

DRY FILM CHARACTERISTICS

- | | |
|-----------------------|-----------|
| ■ Chemical Resistance | EXCELLENT |
| ■ Humidity Resistance | EXCELLENT |
| ■ Weatherability | EXCELLENT |
| ■ Acid Resistance | EXCELLENT |
| ■ Alkali Resistance | EXCELLENT |
| ■ Solvent Resistance | EXCELLENT |
| ■ Abrasion Resistance | EXCELLENT |
| ■ Flexibility | EXCELLENT |

MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service
- 300°F (148°C) in intermittent heat

VOLUME SOLIDS

- 42.6% unactivated
- 49.4% RTS mixed 3:1 with Imron® EZ-3461S™ Activator

WEIGHT SOLIDS

- 50.4% unactivated
- 57.3% RTS mixed 3:1 with Imron® EZ-3461S™

WEIGHT PER GALLON

- 7.87 lbs/gallon unactivated

SUGGESTED DRY FILM THICKNESS

- 1.8 – 2.0 mils dry film thickness

THEORETICAL COVERAGE PER GAL.

- 793 sq ft/gal@1mil DFT mixed 3:1 with Imron® EZ-3461S™

GLOSS

- High

COLOR

- Clear

FLASH POINT (CLOSED CUP)

- Below 20 - 73°F (-6.7 - 23°C)

SHELF LIFE

- 12 months minimum

APPLICATION SOLVENTS

- No reduction necessary; product is ready-to-spray at < 3.5 lbs/gal VOC upon activation.

Note: the use of Imron® 8685S™ or Imron® 8695S™ Reducers will increase the ready-to-spray VOC.

IMRON® EZ-3460S™

POLYURETHANE CLEARCOAT

CLEANUP SOLVENTS

- DuPont 3602S™ Thinner
- Imron® 8685S™ Reducer

ACTIVATION (mix ratio)

- Stir Imron® EZ-3460S™ Low VOC Clear thoroughly prior to activation. Mix 3 parts Imron® EZ-3460S™ clear with 1 part Imron® EZ-3461S™ Activator and mix thoroughly. Filter material prior to spray application. Use up to 2 oz. MasterTint® 389S™ Accelerator to extend pot life and improve dry time.

INDUCTION TIME

- No induction time is required.

POT LIFE

- 2 hours at 70°F (21°C)
- 2-4 hours at 70°F (21°C) with MasterTint® 389S™ Accelerator

ADDITIONAL COMMENTS

- For optimum application and appearance, the clearcoat should be heated to 90°F (32°C). *Note: MasterTint® 389S™ should be used to extend pot life.*
- Heating activated material above 110°F (43°C) will cause gelation.
- The use of MasterTint® 389S™ is recommended for improved dry time in air dry applications. Use up to 2 ounces per ready-to-spray gallon.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 100°F (43°C). The substrate must be at least 5°F (3°C) below the dew point. Relative humidity should be below 90%.

APPLICATION

- Thoroughly stir Imron® EZ-3460S™ prior to activation
- To 3 parts Imron® EZ-3460S™ add 1 part Imron® EZ-3461S™ Activator. Up to 2 ounces of MasterTint® 389S™ should be used to improve dry time. Spray viscosity should be 12 – 14 seconds using a Zahn #3 cup.
- Filter material prior to spray application. No induction time is required.
- Apply one cross-coat technique (two passes with no flash time) to a dry film build of 1.8 – 2.0 mils.

- For pressure pot equipment, use 65 pounds atomizing air pressure at the gun with a fluid delivery of 10 – 12 fluid ounces per minute.
- Imron® EZ-3460S™ can only be repaired with itself. Do not use other products for spot or panel repairs.
- Imron® EZ-3461S™ must be used in the Imron® Basecoat during repairs to an Imron® Basecoat / EZ-3460S™ finish.

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

	Without MasterTint® 389S™	With MasterTint® 389S™
■ Dry to Touch	4-6 hours	1-2 hours
■ Tack Free	10-12 hours	2-4 hours
■ Tape Free	12-24 hours	4-6 hours
■ Dry to Assemble	72 hours	72 hours

Product may be force dried 30 min @140-160°F (60-71°C)

APPLICATION EQUIPMENT

- Pressure Pot (recommended)
- Gravity Feed Gun
- HVLP

ENVIRONMENTAL

■ VOC content (lbs/gal)	<u>LE</u>	<u>AP</u>
■ Imron® EZ-3460S™	3.8	3.8
■ RTS mixed 3:1 w/Imron® EZ-3461S™	3.5	3.5

FOR VOC REGULATED AREAS

These directions refer to the use of products which 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 or using. These products are for industrial use by trained professional painters only.

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