



# DuPont OEM/Fleet Finishes

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## TECHNICAL MANUAL

IMRON® ELITE 8840S™ LOW VOC/LOW HAPS

POLYURETHANE CLEARCOAT

### TYPE

A two-component, low VOC (<3.5 lbs/gal), low HAPS, polyurethane enamel clearcoat, for use with Imron® Elite™ Basecoat and single stage color systems.

### DESCRIPTION

A two-component polyurethane, low VOC clearcoat designed for use with Imron® Elite SS™ enamels and Imron® Elite BC™ polyurethane basecoat colors. Imron® Elite 8840S™ Low VOC, Low HAPS Clear has excellent appearance, handling, durability and chemical resistance properties.

### SUGGESTED USES

A high-gloss, extremely durable, chemical and solvent resistant air dry clear that resistant to yellowing and is easy to use. Imron® Elite 8840S™ has good flow out, excellent sag resistance and is for use with Imron® Elite SS™ enamels and Imron® Elite BC™ polyurethane basecoat solid, metallic, and pearl basecoat colors. Highly recommended for accounts with force dry capabilities.

### 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® Elite 8840S™ is recommended for use over Imron® Elite SS™ and Imron® Elite BC™ topcoat systems.

### 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

- 46.4% unactivated
- 51.4% RTS mixed 3:1 w/ DuPont 194S™

### WEIGHT SOLIDS

- 53.7% unactivated
- 58.6% RTS mixed 3:1 w/ DuPont 194S™

### WEIGHT PER GALLON

- 7.98 lbs/gal. unactivated

### SUGGESTED DRY FILM THICKNESS

- 1.8 – 2.2 mils dry film thickness

### THEORETICAL COVERAGE PER GALLON

- 824 sq ft/gal @ 1 mil DFT RTS mixed 3:1 w/ DuPont 194S™

### GLOSS

- High

### COLOR

- Clear

### FLASH POINT (CLOSED CUP)

- Below 80°F (27°C)

### SHELF LIFE

- 12 months minimum

### APPLICATION SOLVENTS

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

*Note: the use of Imron® Reducers will increase the ready-to-spray VOC.*

**CLEANUP SOLVENTS**

- DuPont 3602S™ Thinner

**ACTIVATION**

- Stir thoroughly prior to activation to secure uniform mixture. Mix 3 parts Imron® Elite 8840S™ Low VOC, Low HAPS Clear with 1 part DuPont 194S™ Activator and mix thoroughly. Filter material prior to spray application. Up to 2 oz MasterTint® 389S™ Accelerator may be added per gallon 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**

- Heating activated material above 110°F (43°C) will cause gelation.
- The use of MasterTint® 389S™ is recommended for improved pot life and dry time. 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 110°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 mix Imron® Elite 8840S™ Low VOC Clearcoat prior to activation. Filter activated material.
- To 3 parts Imron® Elite 8840S™, add 1 part DuPont 194S™. Up to 2 ounces of MasterTint® 389S™ Accelerator can be used to improve dry time. Spray viscosity should be 12 – 14 seconds using a Zahn #3 cup.
- Imron® Elite 8840S™ can be applied wet-on-wet over Imron® Elite BC™ Basecoat Color and Imron® Elite SS™ solid colors with minimal flash times. To avoid mottling of the metallic flake, Imron® Elite SS™ Metallic colors are recommended to be allowed to cure overnight prior

to applying clearcoat. Imron® Elite SS™ Single Stage and Imron® Elite BC™ basecoat enamels should be lightly scuff-sanded if allowed to dry for more than 16 hours prior to application of Imron® Elite 8840S™ Clearcoat.

- Apply one cross-coat technique (two medium-wet passes with no flash time) to a dry film build of 1.8 – 2.2 mils.
- For pressure pot application set air pressure at 55 – 60 psi at the gun for solid colors and effect colors. Fluid delivery should be set for 10 – 12 fluid oz/min.

**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
- Gravity Feed Gun
- Suction Spray

**ENVIRONMENTAL**

■ VOC content (lbs/gal)	<u>LE</u>	<u>AP</u>
Imron® Elite 8840S™	3.5	3.2
RTS mixed 3:1 w/ DuPont 194S™	3.5	3.0

**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.

**03/04**