



# DuPont OEM/Fleet Finishes

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## TECHNICAL MANUAL

IMRON® ELITE BC™ LOW VOC

POLYURETHANE ENAMEL BASECOAT

### TYPE

A high performance, low VOC (<3.5 lbs/gal), two-component polyurethane basecoat enamel, for use with high solids polyurethane clearcoats.

### DESCRIPTION

The Imron® Elite BC™ system is a high-hiding, high performance polyurethane basecoat enamel formulated to work with Imron® Elite 8840S™ Urethane Clear. The Imron® Elite BC™ system is a high gloss, extremely durable, chemical and solvent resistant air dry system that is available in solid, metallic and pearl colors. Imron® Elite BC™ basecoat colors can deliver hiding in one cross coat, and is lead- and chrome-free.

### SUGGESTED USES

Imron® Elite BC™ is an extremely versatile product and is recommended for use on commercial trucks, fleet vehicles, and other applications where superior performance and/or superior appearance is required.

### NOT RECOMMENDED FOR

- Immersion service.
- Use over lacquer finishes.

### COMPATIBILITY WITH OTHER COATINGS

Compatible with all Dupont OEM/Fleet Primer 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 |

\*With Imron® Elite 8840S™ Clearcoat

### MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service.

### VOLUME SOLIDS – WILL VARY WITH COLOR SELECTED

- 46.8% average unactivated
- 52.3% average RTS mixed 3:1 with DuPont 194S™ Activator

### WEIGHT SOLIDS – WILL VARY WITH COLOR SELECTED

- 58.1% average unactivated
- 62.0% average RTS mixed 3:1 with DuPont 194S™ Activator

### WEIGHT PER GALLION (UPDATED)

- 9.15 lbs/gal average unactivated

### SUGGESTED DRY FILM THICKNESS

- Apply to Hiding
- Solid & Effect Colors: 1.0-1.5 mils DFT

### THEORETICAL COVERAGE PER GALLON

- 839 sq ft/gal average @1mil DFT

### GLOSS

- High (with Imron® Elite 8840S™ Clearcoat)

### COLOR

- Available in solid, metallic, and pearl colors

### FLASH POINT (CLOSED CUP)

- Below 80°F (27°C)

### SHELF LIFE

- 12 months minimum

### APPLICATION SOLVENTS

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

### CLEANUP SOLVENTS

- DuPont 3602S™ Thinner
- DuPont 8285S™ Reducer

# IMRON® ELITE BC™ LOW VOC

## ACTIVATION (MIX RATIO)

- Add 3 parts Imron® Elite BC™ Basecoat with 1 part DuPont 194S™ activator and mix thoroughly. Filter material prior to spray application. Activated product will have a viscosity of 10 – 18 seconds in a Zahn 3 cup, depending on color.
- Up to 2 oz/gal MasterTint® 389S™ Accelerator should be added for improved pot life and dry time.
- 1 ounce MasterTint® 8989S™ Accelerator may be added instead of MasterTint® 389S™.

*Note: MasterTint® 8989S™ will shorten pot life.*

## INDUCTION TIME

- No induction time required.

## POT LIFE

- 2 hours at 70°F (21°C)
- 2-4 hours at 70°F (21°C) with MasterTint® 389S™
- 45 minutes at 70°F (21°C) with MasterTint® 8989S™

## ADDITIONAL COMMENTS

- Heating activated material above 110°F (43°C) will cause gelation.
- Sanding is recommended for recoating if the basecoat is force dried or cured > 16 hours ambient.
- When striping, for improved tape time use up to 1 oz/gal of MasterTint® 8989S™.

## 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 BC™ prior to activation.
- Pressure pot application is recommended for best color match and performance.
- 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.
- For siphon gun application, set air pressure to 50 – 55 psi at the gun for solid and effect colors.
- Apply Imron® Elite BC™ 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.

# POLYURETHANE ENAMEL

- Imron® Elite BC Basecoat must be clearcoated with Imron® Elite 8840S™ Urethane Clear or Imron® EZ-3460S™ Clearcoat.
- Do not spray Imron® Elite BC™ if the 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 DuPont 359S™ Paint Additive to 1 ounce per ready-to-spray gallon of Imron® Elite BC™ for solid colors; or 1 oz DuPont VG-F-70050™ for metallic colors. Do not use FEE.
- Purge lines with DuPont 3602S™ Thinner or DuPont 8285S™ Reducer.

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

	Without Accelerator	w/MasterTint® 389S™	w/MasterTint® 8989S™
■ Dry to Touch	4-6 hours	1-2 hours	0.5-1 hour
■ Tack Free	10-12 hours	2-4 hours	1-2 hours
■ Tape Free	12-24 hours	4-6 hours	2-4 hours
■ Dry to Assemble	72 hours	72 hours	72 hours

## APPLICATION EQUIPMENT

- Pressure Pot (recommended)
- Gravity Feed
- HVLP
- Siphon Feed
- Air-Assisted Airless
- Airless

## ENVIRONMENTAL

■ VOC content (lbs/gal)	<u>LE</u>	<u>AP</u>
Imron® Elite BC™ EB	3.8	3.8
RTS mixed 3:1 w/ DuPont 194S™	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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