



# DuPont OEM/Fleet Finishes

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## TECHNICAL MANUAL

IMRON® ELITE SS™ LOW VOC 3.5

POLYURETHANE ENAMEL TOPCOAT

### TYPE

Imron® Elite SS™ is a high-performance, low VOC (<3.5 lbs/gal RTS), two-component single stage, polyurethane enamel.

### DESCRIPTION

Imron® Elite SS™ is designed to deliver the premium quality and performance of Imron® Polyurethane Enamel at a maximum applied VOC of 3.5 lbs/gal. The Imron® Elite SS™ line includes factory package and mixing machine capability. Imron® Elite SS™ is lead- and chrome-free.

### SUGGESTED USES

A high-gloss, extremely durable, chemical and solvent resistant air-dry enamel that is available in both solid and metallic 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.

### DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Weatherability	EXCELLENT
Humidity Resistance	EXCELLENT
Acid Resistance	EXCELLENT
Alkali Resistance	EXCELLENT
Solvent Resistance	VERY GOOD
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT

### MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service

### VOLUME SOLIDS – WILL VARY WITH COLOR SELECTED

- 46.5% average unactivated
- 51.9% average RTS mixed 3:1 w/DuPont 194S™ Activator

### WEIGHT SOLIDS – WILL VARY WITH COLOR SELECTED

- 57.9% average unactivated
- 62.0% average RTS mixed 3:1 w/DuPont 194S™ Activator

### WEIGHT PER GALLON (UPDATED)

- 9.18 lbs/gal average unactivated

### SUGGESTED DRY FILM THICKNESS

- 1.8 – 2.2 mils

### THEORETICAL COVERAGE PER GALLON

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

### GLOSS

- High
- PowerTint PT196™ Flattener Additive is available to obtain lower gloss if desired.

### COLOR

- Available in solid or metallic 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 may result in greater than 3.5 VOC.

### CLEANUP SOLVENTS

- DuPont 3602S™ Thinner
- DuPont 7285S™ Reducer

# IMRON® ELITE SS™ LOW VOC 3.5

## ACTIVATION (MIX RATIO)

Add 3 parts Imron® Elite SS™ with 1 part DuPont 194S™ and mix thoroughly. Filter material prior to spray application. To the activated gallon, add up to 2 oz. MasterTint® 389S™ Accelerator or 1 oz. MasterTint® 8989S™ Accelerator. (Note: MasterTint® 8989S™ will shorten pot life.) 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

- 2 hours at 70°F (21°C)
- 2-4 hours at 70°F (21°C) with 2 oz MasterTint® 389S™ per activated gallon
- 45 minutes at 70°F (21°C) with 1 oz MasterTint® 8989S™ per activated gallon

## ADDITIONAL COMMENTS

- Heating activated material above 110°F (43°C) will cause gelation.
- When recoating Imron® Elite SS™ with itself, sanding is required if the enamel has air dried more than 16 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 SS™ 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 SS™ 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.
- Do not spray Imron® Elite SS™ if the paint temperature is less than 75°F (24°C). Use warm water or paint

# POLYURETHANE ENAMEL

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 In Imron® Elite SS™ 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 7285S™ 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	.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

Product may be force dried 30 min at 140-160°F (60-71°C) after a flash time of 15 minutes following application of final coat.

## 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 SS™ EA	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 and using. These products are for industrial use by trained professional painters only.

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