Axalta 13325S™
Polyurethane Clearcoat | Cabin Finishes

GENERAL

DESCRIPTION
A high-productivity polyurethane clearcoat that provides excellent appearance and durability for interior cabin surfaces. It delivers exceptional clarity, dry times, sandability, UV-protection, and low overspray.

RECOMMENDED USES
13325S is recommended for use with 13225S™ as part of a wood cabinetry finishing system. This system is designed to provide excellent appearance while reducing overall material usage and labor cost in the production of high-build, mirror-finish wood surfaces. Flame retardant is typically added at the level required to pass completed part flammability testing.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS
13325S Polyurethane Clearcoat
13125S™ Urethane Activator

See 13225S product data sheet for basecoat information.

MIX RATIO
Thoroughly mix 13325S prior to activation. Filter activated material prior to spray application.

Components	Parts by Volume
13325S Polyurethane Clearcoat	4
13125S Urethane Activator	1

ADDITIVES
Flame retardant additive is typically added at 4-7% by volume. Burn testing of actual part/surface is required to determine appropriate flame retardant amount.

VISCOSITY
15-17 seconds in a Zahn EZ-#2 cup, without additive. (Listed ranges were established using GARDCO EZ Zahn (AS) Cups, measurements using other Zahn type cups may provide different results.)

INDUCTION TIME
No induction time is required prior to application.

POT LIFE
Pot life is 2 hours at 70°F (21°C).

APPLICATION

SUBSTRATES AND SURFACE PREPARATION
Surface preparation is critical to final appearance of clearcoat. All substrate should be sanded, using 400 grit or higher sandpaper. For wood surfaces, see preparation recommendations provided in the 13225S product data sheet.

GUN SETUP
13325S can be applied with conventional, HVLP and electrostatic spray equipment using pressure or gravity fluid delivery.

Conventional Fluid Tip

Pressure Pot	1.2mm-1.6mm (.047”-.063”)
Gravity Feed	1.2mm-1.6mm (.047”-.063”)

HVLP

Pressure Pot	1.2mm-1.6mm (.047”-.063”)
Gravity Feed	1.2mm-1.6mm (.047”-.063”)

FLUID DELIVERY

Conventional	10-12 oz./min
HVLP	10-12 oz./min

AIR PRESSURE

Conventional	50-60 psi atomizing air
HVLP	25-30 psi atomizing air

ENVIRONMENTAL CONDITIONS
Substrate and ambient temperature must be between 50°F (10°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated paint above 110°F (43°C) may cause gelation. For optimum appearance spray 13325S at 75°F (24°C) or warmer.

APPLICATION
- A 3-coat process is recommended for 13325S application. Spray the first coat medium wet, with a wet film build of no more than 1.0 mil. Allow the coat to flash 3-5 minutes before the next coat. Repeat with a second and then third coat. Once the 3-coat process is completed, allow the coating to dry for 3 hours at 70°F (or 30 minutes at 120°F).
- Repeat the 3-coat process (additional 3 coats with 3-5 minute flash in between each coat).
- After the second 3-coat process is completed, allow the coating to dry for at least 8 hours at 70°F. The coating should be sanded smooth, finishing with 1500 grit or higher. A mirror finish can be obtained using a variable speed buffer (1200-1800 rpm) with foam pad and finishing polish. Prior to final buffing/polishing, the 13325S application processes may be repeated increase depth of finish.

CLEANUP SOLVENTS
Axalta 107™ Low-VOC Gun & Equipment Cleaner
Axalta 105™ Gun & Equipment Cleaner

DRY TIMES

AIR DRY AT 70°F (21°C)

Flash Between Coats	3-5 minutes
Dust Free	10 minutes
Dry to Sand/Polish	3 hours

FORCE DRY AT 120°F (49°C)

Flash Before Force Dry	None required
Dry to Touch	10 minutes (after cool down)
Dry to Sand/Polish	30 minutes

*Note that addition of flame retardant will increase dry times. Infrared drying is not recommended.

RECOAT
13325S may be recoated with itself after 1 hour if force dried and 2 hours if air dried. If 13325S is being recoated after 24 hours, scuff sand with 1200-1500 grit paper.

PHYSICAL PROPERTIES

VOC	Less Exempts (LE)	As Packaged (AP)
13325S	4.2 lbs./gal	2.9 lbs./gal
Ready-to-Spray 13325S with 13125S	4.2 lbs./gal	3.2 lbs./gal

FACTORY-PACKAGED CLEARCOAT	
Color	Clear
Closed Cup Flash Point	20°F-73°F
Shelf Life	3 years (Unopened at 50°-110°F)

READY-TO-SPRAY	
Theoretical Coverage	490 ft²/gal at 1 mil dry film thickness
Weight Solids	38%
Volume Solids	31%
Gallon Weight	7.7 lbs./gal

DRY FILM	
Gloss	≥ 90 measured at 60°

COATING PERFORMANCE	
Chemical and Solvent Resistance	Very Good
Humidity Resistance	Excellent
Acid and Alkali Resistance	Very Good
Abrasion Resistance	Very Good
Weatherability	Excellent
Flexibility	Very Good

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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