



Imron® AF740™ Polyurethane Clearcoat



GENERAL

DESCRIPTION

A 3.5 VOC compliant, high solids, polyurethane clearcoat designed to deliver high performance, excellent appearance, durability and application as part of the Imron AF700 Basecoat/Clearcoat system. It is formulated to provide balanced performance including smooth appearance, sag resistance and productive dry times.

RECOMMENDED USES

Imron AF740 is recommended for use with Imron AF700 Basecoat in applications where either Skydrol resistance or the smoothest possible appearance (minimal orange peel) is required. Imron AF740 is ideal for accent stripes on business jets and single-engine aircraft. Imron AF740 is recommended for use as part of the Imron AF700 Basecoat/Clearcoat system.

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



MIXING

COMPONENTS

Imron AF740 Polyurethane Clearcoat
13110S™ Activator
13100S™ Activator (repairs)
13930S™ Reducer
13765S™ Fast Reducer
13775S™ Medium Reducer

See Imron AF700 product data sheet for basecoat information.

MIX RATIO

Thoroughly mix Imron AF740 prior to activation. Filter activated material prior to spray application.

<u>Components</u>	<u>Overall Parts by Volume</u>	<u>Small Parts/Repair Parts by Volume</u>
Imron AF740 Clearcoat	3	3
13110S / 13100S Activator	2 (13110S)	2 (13100S)
13930S / 13765S / 13775S Reducer	up to 1	up to 1

VISCOSITY

10-13 seconds in a Zahn #3 cup. (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

2 hours at 70°F (21°C) with 2 oz. of 13803S™ per RTS gallon.



ADDITIVES

To improve pot life

- Add up to 2 oz. 13801S™ per RTS gallon

To improve dry time

- Add up to 2 oz. 13803S per RTS gallon

To improve striping/repair dry time

- Add up to 1 oz. 13808S™ per RTS gallon

Anti-Crater

- Add up to 1 oz. 13813S™ per RTS gallon



APPLICATION

SUBSTRATES AND SURFACE PREPARATION

Surface preparation is critical to basecoat/clearcoat appearance. Follow basecoat or topcoat recoat-window guidelines to ensure proper adhesion. Substrate should always be thoroughly wiped and tacked immediately prior to clearcoat application.

ENVIRONMENTAL CONDITIONS

Subs 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 Imron AF740 at 75°F (24°C) or warmer.

GUN SETUP

Imron AF740 can be applied with conventional, HVLP, airless, air-assisted airless, and electrostatic spray equipment using pressure or gravity fluid delivery.

Conventional Fluid Tip

Pressure Pot	1.0 mm-1.4 mm (.039”-.055”)
Gravity Feed	1.2 mm-1.6 mm (.047”-.063”)

HVLP

Pressure Pot	1.0 mm-1.4 mm (.039”-.055”)
Gravity Feed	1.2 mm-1.6 mm (.047”-.063”)

FLUID DELIVERY

Conventional	8-10 oz./minute
HVLP	8-10 oz./minute

AIR PRESSURE

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

APPLICATION

Method 1: Apply first coat medium wet with a 65% overlap. Allow to flash minimum 5 minutes followed by a second medium wet coat with a 65% overlap.

Method 2: Apply first coat as a cross-coat beginning from top to bottom then side to side. Allow to flash minimum of 5 minutes followed by a second coat in a side to side motion with a 65% overlap.

To achieve DFT goal of 2.0-2.5 mils, wet application should be between 4.0 – 5.0 mils wet.

CLEANUP SOLVENTS

- Axalta 107™ Low-VOC Gun & Equipment Cleaner
- Axalta 13920S™ Low-VOC Cleaner



DRY TIMES

AIR DRY

At 70°F (21°C) with 2 oz 13803S per ready-to-spray gallon
 Dry to Touch 4 hours
 Dry to Tape 8 hours

FORCE DRY

At 130°F (54°C)
 Flash Before none required
 Dry to Touch 2 hours
 Dry to Tape 4 hours

RECOAT

Air Dry at 70°F (21°C) Scuff Sand required after 36 hours.
 Force Dry at 130°F (54°C) Scuff Sand required after 12 hours

With 2 oz. 13803S or 13808S. Scuff Sand required after 12 hours.



PHYSICAL PROPERTIES

VOC

	<u>Less Exempts (LE)</u>	<u>As Packaged (AP)</u>
Imron AF740	3.8 lbs./gal	3.6 lbs./gal
Ready-to-Spray Imron AF740		
With 13110S and 13930S	3.3 lbs./gal	3.0 lbs./gal
With 13110S and 13895S	3.6 lbs./gal	3.5 lbs./gal

FACTORY-PACKAGED CLEARCOAT

Color Clear
 Closed Cup Flash Point 20°F-73°F
 Shelf Life 2 years (Unopened at 50°-110°F)

READY-TO-SPRAY

Theoretical Coverage 792 ft²/gal at 1 mil dry film thickness
 Weight Solids 55%
 Volume Solids 49%
 Gallon Weight 8.5 lbs./gal.

DRY FILM

Gloss ≥90 measured at 60°
 Recommended Film Thickness 1.8-2.5 mils

COATING PERFORMANCE

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

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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In Canada:
1.800.668.6945
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