



Imron® AF3500™ Polyurethane Topcoat (EJ Quality)



GENERAL

DESCRIPTION

A 3.5 VOC compliant polyurethane topcoat intended for use on jet aircraft. This high-performance topcoat is designed to deliver premium appearance and durability. It is available in factory packaged whites and mixed solid colors.

RECOMMENDED USES

Imron® AF3500™ is recommended for jet aircraft and similar general aviation applications where exceptional appearance, long-term fluid resistance, and outstanding durability are required. Imron® AF3500™ is recommended for use with:

Epoxy Primer/Surfacer
 Basecoat/Clearcoat

Corlar® 13550S™, Corlar® 13580S™
 Imron® AF700™, Imron® AF740™

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



MIXING

COMPONENTS

- Imron® AF3500™ mixed color (EJ Quality)
- Imron® AF3503™ Snow White Factory Package
- Imron® AF3504™ Matterhorn White Factory Package
- Imron® AF3523™ Matterhorn White High Rheology Factory Package
- 13110S™ Activator
- 13100S™ Activator (Small Parts/Repair)
- Imron® 13865S™ Fast Pot-Life Extender
- Imron® 13875S™ Medium Pot-Life Extender
- Imron® 13885S™ Slow Pot-Life Extender
- Imron® 13895S™ Very Slow Pot-Life Extender
- 13765S™ Fast VOC-Exempt Reducer
- 13775S™ Medium VOC-Exempt Reducer
- 13785S™ Slow VOC-Exempt Reducer
- 13821S™ Fast Reducer with Rheology Control

Imron pot-life extenders and VOC-exempt reducers are available for a range of application conditions. Suggested usage ranges are dependent on the air flow and relative humidity.

	70°F	80°F	90°F	100°F
Riveted Aircraft	13865S	13875S	13885S	13895S
	13821S	13821S	13821S	13821S
Flush-Surface Aircraft	13865S	13875S	13885S	13895S
	13765S	13765S	13775S	13785S

MIX RATIO

Thoroughly mix Imron AF3500 color prior to activation. Filter activated material prior to spray application.

Components (Riveted)	Regular	Small Parts/Repair
	Parts by Volume	Parts by Volume
Imron® AF3500™ Color (EJ Quality)	2	2
13110S / 13100S Activator	1 (13110S)	1 (13100S)
Imron 138X5S Pot-Life Extender	0.25	0.25
13821S Rheology Reducer	0.25	0.25



Components (Flush-Surface)	Regular Parts by Volume	Small Parts/Repair Parts by Volume
Imron® AF3500™ Color (EJ Quality)	2	2
13110S / 13100S Activator	1 (13110S)	1 (13100S)
Imron 138X5S Pot-Life Extender	0.25	0.25
137X5S VOC-Exempt Reducer	0.25	0.25

VISCOSITY

15-20 seconds in a Zahn #2 cup.

Listed ranges were established using GARDCO EZ Zahn (ASTM) Cup. measuring with other Zahn type cups may provide different results.

INDUCTION TIME

No induction time is required prior to application.

POT LIFE

8 hours at 70°F (21°C)

ADDITIVES

Accelerator

- Add up to 2 oz. 13803S™ per RTS gallon
- Add up to 1 oz. 13808S™ per RTS gallon for spot work only

Anti-Crater

- Add up to 1 oz. 13813S™ per RTS gallon
- Do not use FEE



APPLICATION

SUBSTRATES AND SURFACE PREPARATION

Surface preparation is critical to topcoat appearance. Primer and surfacer should be properly applied and cured per product recommendations. Surfaced substrate should be DA sanded with 320-grit or finer paper for best appearance. Substrate should always be thoroughly wiped/tacked immediately prior to topcoat application.

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 material above 110°F (43°C) may cause gelation. For optimum appearance spray Imron® AF3500™ at 75°F (24°C) or warmer.

GUN SETUP

Imron® AF3500™ can be applied with conventional, HVLP, air-assisted airless and electrostatic spray equipment using pressure or gravity fluid delivery.

Conventional Fluid Tip

Pressure Pot	1.2 mm-1.6 mm (.047"-.063")
Gravity Feed	1.4 mm-1.6 mm (.055"-.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	10-12 oz./minute
HVLP	10-12 oz./minute



AIR PRESSURE

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

APPLICATION

Spray a medium-wet first coat. Allow first coat to flash for 30-45 minutes and tack-up prior to second coat. Apply second coat as a wet cross-coat to achieve 2.0-2.5 mils dry film build.

CLEANUP SOLVENTS

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



DRY TIMES

AIR DRY

At 70°F (21°C)	
Dry to Touch	12 hours
Dry to Tape	24 hours

FORCE DRY

At 130°F (54°C)	
Flash Before Force Dry	3 hours
Dry to Touch	6 hours
Dry to Tape	10 hours

RECOAT

When recoating Imron® AF3500™ with itself, Imron® AF700™, Imron® AF740™ clearcoat for stripes, or Imron® AF400™ topcoat for stripes, scuff sanding is required if the topcoat has air dried for more than 36 hours or if the topcoat has been force dried.



PHYSICAL PROPERTIES

VOC

	Less Exempts (LE)	As Packaged (AP)
Imron AF3500	3.6 lbs./gal	3.6 lbs./gal
RTS Imron AF3500	3.5 lbs./gal	3.2 lbs./gal

FACTORY-PACKAGED AND MIXED COLORS

Color	Whites and solid colors
Closed Cup Flash Point	20°F-73°F
Shelf Life	Factory Package – 2 yrs. (Unopened at 50°-110°F)
	Mixed Color – 1 yr.

READY-TO-SPRAY* (WILL VARY WITH COLOR)

Theoretical Coverage	780 ft ² /gal average at 1 mil dry film thickness (775-790 ft ² /gal)
Weight Solids	60% average (55-64%)
Volume Solids	49% average (48-50%)
Gallon Weight	9.4 lbs./gal average (8.4-10.3 lbs./gal)

*Using Imron 13875S Pot-Life Extender and 13765S VOC-Exempt Reducer

DRY FILM

Gloss	≥ 90 measured at 60°
Recommended Film Thickness	2.0-2.5 mils



COATING PERFORMANCE

SKYDROL Resistance	Excellent
Chemical and Solvent Resistance	Excellent
Weathering	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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