**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:

- Primers: Corlar® 13550S™, Corlar 13580S™
- Surfacers: Corlar 13580S
- Basecoat/Clearcoat: 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 factory packaged or mixed color (EJ Quality)
- 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

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

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<tr>
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<th>70°F</th>
<th>80°F</th>
<th>90°F</th>
<th>100°F</th>
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<tr>
<td>Riveted Aircraft</td>
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<td>Flush-Surface Aircraft</td>
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**MIX RATIO**
Thoroughly mix Imron AF3500 color prior to activation. Filter activated material prior to spray application.

<table>
<thead>
<tr>
<th>Components</th>
<th>Regular Parts by Volume</th>
<th>Small Parts/Repair Parts by Volume</th>
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<tbody>
<tr>
<td>Imron AF3500 Color (EJ Quality)</td>
<td>2</td>
<td>2</td>
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<tr>
<td>13110S / 13100S Activator</td>
<td>1 (13110S)</td>
<td>1 (13100S)</td>
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<tr>
<td>Imron 138X5S Pot-Life Extender</td>
<td>0.25</td>
<td>0.25</td>
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<tr>
<td>137X5S Reducer</td>
<td>0.25</td>
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VISCOSITY
15-20 seconds in a Zahn #2 cup.

Listed ranges were established using GARDCO EZ Zahn (ASTM) Cups, measurements using 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. Primers and surfacers should be properly applied and cured according to product recommendations. Surfaced substrate should be DA sanded with 320-grit or finer 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 basecoat/ 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
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  Fac Pacs - 2 years (Unopened at 50°-110°F)
Mixed Colors – 1 year

READY-TO-SPRAY* (WILL VARY WITH COLOR)
Theoretical Coverage  780 ft²/gal average at 1 mil dry film thickness
(775-790 ft²/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
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.

Revised: January 2015