IMRON® ELITE 8840S™ CLEARCOAT

GENERAL

DESCRIPTION
A 3.5 lb. /gal (420 g/l) VOC, two-component, high-performance, easy-to-use clearcoat designed for panel and overall applications. It delivers a premium appearance with excellent durability and chemical resistance. Highly recommended for accounts with force dry capabilities.

SUGGESTED USES
It is highly recommended for accounts with force dry capabilities.

RECOMMENDED FOR USE OVER
Imron® Elite Basecoat (EB Quality)
Imron® Elite Productive Basecoat (EW Quality)
Imron® Elite Express Basecoat (EG Quality)
Imron® Elite Single Stage Topcoat (EA Quality)
Imron® Elite Productive Single Stage Topcoat (EX Quality)
Imron® Elite Express Single Stage Topcoat (EF Quality)

NOT RECOMMENDED FOR
Immersion service or lacquer finishes.

DRY FILM CHARACTERISTICS

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

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

MIXING

MIX RATIO
Stir clearcoat thoroughly prior to activation. Combine components and mix thoroughly. Filter material prior to spray application.

Components	Parts by Volume
Imron® Elite™ 8840S™ Clearcoat	3
194S™ Activator	1

ADDITIVES
Extend pot life and improve dry time:
Add up to 2 oz. of 389S™ Accelerator to activated gal.

INITIAL APPLICATION VISCOSITY
12-14 seconds with #3 Zahn Cup.

INDUCTION TIME
No induction time is required.

POT LIFE - 70ºF (21°C)
2 hours as activated
2-4 hours with 389S™ Accelerator
1 hour with 8989S™ Accelerator

APPLICATION

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 EQUIPMENT
Refer to spray equipment documentation for setting recommendations.
Pressure Pot (recommended)
Gravity Feed
Suction Spray
Air-Assisted Airless

APPLICATION
- Apply using a cross-coat technique - a wet coat using a top-to-bottom motion and a medium-wet second coat using a side-to-side motion. Flash 30 seconds to 5 minutes between coats. In general, the shorter the flash the smoother the appearance.
- Imron® Elite 8840S™ can be applied wet-on-wet over Imron® Elite EB basecoat solid and metallic colors, Imron® Elite EA topcoat solid colors with minimal flash times.
- Imron® Elite EG and EW basecoat qualities should flash for 30 minutes prior to clearcoat application
- Imron® Elite EF and EX topcoat solid colors should flash for 30 minutes prior to clearcoat application
- Allowing Imron® Elite EA / EF / EX topcoat metallic colors to cure overnight prior to application of clearcoat is recommended to avoid mottling of the metallic flake.
- Imron® Elite basecoat and topcoat should be lightly scuff-sanded if allowed to dry for more than 16 hours or has been force dried prior to application of Imron® Elite 8840S™.
- When recoating 8840S™ with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.
- For pressure pot application fluid delivery should be set for 10-12 fluid oz/min.

APPLICATION SOLVENTS
No reduction necessary; product is ready-to-spray at less than 3.5 lbs. /gal VOC upon activation. Further reduction may result in greater than 3.5 VOC.

CLEANUP SOLVENTS
3602S™ Lacquer Thinner
106™ Lacquer Thinner
107™ Low VOC Gun Cleaner
108™ Low HAPS Cleaning Solvent

ADDITIONAL COMMENTS
Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.

DRY TIMES

AIR DRY

77°F (25°C) & 50% RH at recommended film thickness.

	Without 389S™	With 389S™
Dry to touch	4-6 hours	1-2 hours
Tack free	10-12 hours	2-4 hours
Tape free	12-24 hours	4-6 hours
Dry to assemble	72 hours	72 hours

FORCE DRY

30 minutes at 140-160°F (60-71°C).

PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	8.02 lbs.
Weight Per Liter (component only)	961 grams
Suggested Dry Film Thickness	1.8 – 2.2 mils
Gloss	High
Color	Clear
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

RTS mixed 3:1 with: **Includes 389S**	**194S**
Gallon Weight pounds per gallon	8.28
Gallon Weight grams per liter	992
VOC AP pounds per gallon	3.3
VOC AP grams per liter	390
VOC LE pounds. per gallon	3.4
VOC LE grams per liter	408
Weight Solids	57.2%
Volume Solids	49.9%
Weight Volatiles	42.8%
Weight Water	0.0%
Volume Water	0.0%
Weight Exempt Solvents	3.5%
Volume Exempt Solvents	4.4%
Theoretical Coverage per RTS Gallon at 1 mil DFT	800 ft^2 (74.3 m^2)

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/SDS 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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