



Imron® AF700™ Polyurethane Basecoat (ES Quality)



GENERAL

DESCRIPTION

A 3.5 VOC compliant, high solids, high-performance polyurethane basecoat designed for aviation/aerospace applications. It is formulated to deliver excellent appearance and durability and is available in solid, metallic-effect, and pearl-effect mixed colors.

RECOMMENDED USES

Imron AF700 is a versatile system recommended for aviation/aerospace applications where premium color is essential in achieving designs—whether simple or complex; conservative or bold, from account stripes, split bases, overalls, rotary wing, jets or single engines, AF700 covers them all. Imron AF700 must be clearcoated to provide proper appearance and coating performance. Imron AF700 is recommended for use with:

| | |
|--------------------|---------------------------------|
| Primers/ Surfacers | Corlar® 13550S™, Corlar 13580S™ |
| Basecoat/Clearcoat | Imron AF700, Imron AF740™ |
| Topcoats | Imron AF400™, Imron AF3500™ |

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



MIXING

COMPONENTS

Imron AF700 Basecoat (ES Quality)
13100S™ Urethane Activator
13765S™ Fast Reducer
13775S™ Medium Reducer

Refer to Imron AF740 product data sheets for clearcoat information.

MIX RATIO

Thoroughly mix Imron AF700 prior to activation. Filter activated material prior to spraying.

Components

Imron AF700 Basecoat (ES Quality)
13100S Urethane Activator
13765S or 13775S Reducers

Parts by Volume

3
1
up to 20%*

*Add Reducer to achieve recommended viscosity

VISCOSITY

10-18 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 either 13801S or 13803S™).
45 minutes at 75°F (24°C) with 13808S™



ADDITIVES (OPTIONAL)

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

For fast dry, limited area work

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

Anti-crater (solid colors)

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

Adding 2 oz. of 13801S or 13803S per RTS gallon is recommended for most all applications in order to provide longer pot life.



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 240-grit or finer for best appearance. Substrate should always be thoroughly wiped and 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 AF700 at 75°F (24°C) or warmer.

GUN SETUP

Imron AF700 can be applied with conventional, HVLP, air-assisted airless and electrostatic spray equipment using pressure or gravity fluid delivery.

Conventional Fluid Tip

| | |
|--------------|-----------------------------|
| Pressure Pot | 1.0mm-1.6mm (.039"-.063") |
| 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

- Accelerator aids in dry to tape.
- Solid colors – apply either a cross coat or two medium coats.
- Effect – medium first coat. If complete hiding is not achieved, follow with a second medium coat. Apply 45° orientation coat as necessary.



CLEANUP SOLVENTS

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



DRY TIMES

AIR DRY

70°F (21°C) with 2 oz 13803S per ready-to-spray gallon
 Dry to Touch 3-4 hours
 Dry to Tape 6-7 hours

FORCE DRY

130°F (54°C) with 2 oz 13803S per ready-to-spray gallon
 Flash Before Force Dry 15 minutes
 Dry to Touch 1-2 hours
 Dry to Tape 3-4 hours

RECOAT

Air Dry at 70°F (21°C) Scuff Sand required after 48 hours.
 Force Dry at 130°F (54°C) Scuff Sand required after 20 hours

With 2 oz. 13808S accelerator, Scuff sand required after 12 hours.



PHYSICAL PROPERTIES

| VOC | Less Exempts (LE) | As Packaged (AP) |
|---------------------------------------|-------------------|------------------|
| Imron AF700 | 3.8 lbs./gal | 3.6 lbs./gal |
| RTS Imron AF700 Mixed 3:1 with 13100S | 3.4 lbs./gal | 3.2 lbs./gal |

MIXED COLORS

Color Solid and metallic colors
 Closed Cup Flash Point 20°F-73°F
 Shelf Life 1 year mixed colors (Unopened at 50°-110°F)

READY-TO-SPRAY*

Theoretical Coverage 850 ft²/gal. average at 1 mil dry film thickness (820-870 ft²/gal.)
 Weight Solids 63% average (58-68%)
 Volume Solids 53% average (51-56%)
 Gallon Weight 9.2 lbs./gal average (8.3-10.8 lbs./gal)

DRY FILM

Gloss ≥90 measured at 60°
 Recommended Film Thickness 1.0-1.5 mils

COATING PERFORMANCE

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.

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