



# Imron® AF740™ Polyurethane Clearcoat



## GENERAL

### DESCRIPTION

A compliant (VOC<420 g/L), 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 @21°C. (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**

2 hours at 21°C with 15 g of 389S™ per RTS litre.

**ADDITIVES**

**To improve dry time**

- Add up to 15 g 389S™ per RTS litre

**To improve striping/repair dry time**

- Add up to 8 g 8989S™ per RTS litre

**Anti-Crater**

- Add up to 8 g 13813S™ per RTS litre



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**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**

Substrate and ambient temperature must be between 10°C and 45°C. The substrate must be at least 3°C above the dew point. Relative humidity should be below 90%. Heating activated paint above 45°C may cause gelation. For optimum appearance spray Imron® AF740™ at 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
Gravity Feed	1.2 mm-1.6 mm

**HVLP**

Pressure Pot	1.0 mm-1.4 mm
Gravity Feed	1.2 mm-1.6 mm

**FLUID DELIVERY**

Conventional	240-300 mL./minute
HVLP	240-300 mL/minute

**AIR PRESSURE**

Conventional	3.4-4.1 bar atomizing air
HVLP	1.7-2.1 bar 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 50-65 µm, wet application should be between 100-125 µm wet.

**CLEANUP SOLVENT**

Duxone® Gun Wash Solvent



**DRY TIMES**

**AIR DRY**

At 21°C with 15 g 389S™ per ready-to-spray litre  
 Dry to Touch 4 hours  
 Dry to Tape 8 hours

**FORCE DRY**

At 55°C  
 Flash Before none required  
 Dry to Touch 2 hours  
 Dry to Tape 4 hours

**RECOAT**

Air Dry at 21°C Scuff Sand required after 36 hours.  
 Force Dry at 55°C Scuff Sand required after 12 hours

With 15 g 389S or 8989S per ready-to-spray litre. Scuff sand required after 12 hours.



**PHYSICAL PROPERTIES**

**VOC**

	<u>Less Exempts (LE)</u>	<u>As Packaged (AP)</u>
Imron® AF740™	456 g/L	432 g/L
Ready-to-Spray Imron® AF740™ with 13110S™ and 13930S™	396 g/L	360 g/L

**FACTORY-PACKAGED CLEARCOAT**

Colour Clear  
 Closed Cup Flash Point 7°C-23°C  
 Shelf Life 2 years (Unopened at 10°C-45°C)

**READY-TO-SPRAY**

Theoretical Coverage 7.3 m<sup>2</sup>/L at 65 µm dry film thickness  
 Weight Solids 55%  
 Volume Solids 49%  
 Specific Gravity 1.02 g/mL

**DRY FILM**

Gloss ≥90 measured at 60°  
 Recommended Film Thickness 45-65 µm

**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.



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## **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 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 an approved air purifying respirator with particulate filters complying with AS/NZS 1716:2012 and gloves.