



# 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.



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## 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**

	Less Exempts (LE)	As Packaged (AP)
VOC		
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 ft<sup>2</sup>/gal. average at 1 mil dry film thickness (820-870 ft<sup>2</sup>/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.



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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 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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**In the United States:**  
**1.855.6.AXALTA**  
**axalta.us**

**In Canada:**  
**1.800.668.6945**  
**axalta.ca**

