TUC2099
Imron™ Industrial PU High Gloss T/C

Date: February 29, 2020 (supersedes all previous revisions)

GENERAL INFORMATION

Axalta's Imron™ Polyurethane High Gloss Topcoat is a premium 2 component coating formulated specifically for wood to provide exceptional finishing properties including, extremely high gloss. chemical and moisture resistance when used with its companion topcoat. For Wood Substrates Only.

1. PRODUCTS

- TUC2099 – High Gloss

2. MIXING RATIO

- Catalyze with CXC1400 at 100% weight or volume. Reduce 20-30% weight or volume with YYT0040, use YYT0050 in warmer conditions.

3. SHELF LIFE / POT LIFE @ 77°F (25°C)

- 12 months un-catalyzed @77°F, 4 hour pot-life once catalyzed

4. CLEAN UP

- Dispose of dirty solvent and cleaning rags in a safe and compliant manner. Solvent or lacquer soaked rags should be stored in water-filled, closed containers prior to disposal.

5. ADDITIVES

- None recommended. YYT0050 can be used to slow down dry time.

6. SURFACE PREPARATION

- Surface must be clean and dust free with a moisture content of 6-8% prior to finishing. Remove all dust, dirt, wax and wood marks. Proper sanding and preparation of the wood is critical to achieving consistent results.
- On new wood, finish sand surface with 150-180 grit sandpaper
- On previously finished wood, remove all old paint or varnish and follow new wood procedure.

7. COMPANION PRODUCTS

- TUS2010 Sealer
- TUS202 High Build Sealer
- Approved stain systems

8. TECH NOTES

- All products should be stirred well before use and, for best results, continuously agitated while in use.

9. SUBSTRATES

- Commonly used furniture and cabinetry woods
- MDF/HDF

NOTE: Not to be used on exterior applications

10. APPLICATION

- Ready to spray once catalyzed and reduced
- Maximum film thickness of the total coating system must not exceed 12 dry mils.

11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	2 Hours
Flash between coats	1-4 Hours
To Stack	24 Hours

12. FORCE DRY (full system times / temperatures will vary)

Flash	15 Minutes
Bake	10 Minutes @ 150°F
Cool Down	1-2 Hours
Stack	16 Hours

13. GUN SET UP

Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.6 mm - 1.8 mm
Airless	10 – 15 thousandths
Air-Assisted Airless	11 – 15 thousandths

AIR PRESSURES

Gravity Feed	30-35 psi (2.0-2.4 bar)
Siphon Feed	35-40 psi (2.4-2.8 bar)
Air-Assisted Airless	5-10 psi (0.3-0.7 bar)
See spray gun manufacturer data for more information	

14. PHYSICAL DATA

Viscosity	25-45" Ford 4
Weight Solids %	49%
Volume Solids %	46.7%
Actual VOC	4.1 lbs/gal of Product
VOC Ratio (lb.voc/lb.solids)	1.0 lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	462 g/l
Weight Per Gallon	8.1 1bs/gal
Flash Point	73.4ºF Closed Cup
VHAP (lb.HAP/lb.solids)	1.8 lb VHAP/lb solid
Photochemically Reactive	Yes
Coating Category	Clear

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Application Notes:

Tinting:
Tinting this product is not recommended.

Apply by spray only, using Conventional Air, HVLP, Airless, or Air Assisted Airless equipment. Apply at a rate of 3-5 wet mils per coat. Sand between coats with 240-320 grit, no fill type sandpaper. Remove sanding dust before applying the next coat. Maximum film thickness of the total coating system MUST NOT EXCEED 12 dry mils.

Pot-Life: 4 hours @77° F

Drying Time:
Dry to touch: 2 hours

Dry to sand and recoat: 1-4 hours (depending on ambient conditions).

Do not apply if the material or substrate temperature is below 55ºF.

This product is best applied when surface and air temperatures are between 55º-90º F (~12-32°C) and when relative humidity is below 50% during application and drying time.

Clean Up:

Refer to your local regulations for compliance requirements for cleaning solvents. Dispose of dirty solvent and cleaning rags in a safe and compliant manner. Solvent or lacquer-soaked rags should be stored in water-filled, closed containers prior to disposal.

Storage:
Store in a cool, dry place. Close all containers after use. Do not store near heat or sparks. Spills should be cleaned up with non-sparking tools. See the product MSDS for complete safety information

Precautions:
These products are recommended for professional application and are designed for interior use only. Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and to avoid potential need for costly refinishing. Axalta Industrial Wood Coatings are designed to protect and enhance the natural beauty of wood, but cannot eliminate natural discoloration or deterioration of wood as it ages.

Additional notes:
Do not mix with other finishing systems or deviate from these finishing recommendations. Axalta will not be held liable for finish failures resulting from the mixing of products or deviations from finishing recommendations.

For best performance and build allow sealer to dry 8 hours before sanding. Allow final coats to dry 3-4 days before mechanically polishing.

Warning:
Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and avoid potential need for costly refinishing. All dry times listed are as tested under ideal indoor environmental conditions of 78°F (26°C) with relative humidity not exceeding 50%. These products are recommended for use under temperature conditions of 60-100°F (16-38°C) and when relative humidity is below 50% during application and drying time. Low temperatures, poor air circulation or high humidity will extend dry times. **Axalta strongly recommends against use of these products if temperatures of air, material, or surface to be coated are below 60°F (16°C) or below the dew point. Abnormal conditions of temperature or humidity may adversely affect product performance.** Please contact your authorized Axalta Industrial Wood Coatings distributor for additional product use recommendations and finishing guidance.