



Imron® Elite 8460S™ Clearcoat



GENERAL

DESCRIPTION

A low VOC, two-component, versatile, easy-to-apply clearcoat with added sag control designed for panel and overall applications and repairs. It delivers premium appearance and productivity with excellent durability and chemical resistance. The multiple temperature range activators provide added application latitude and flexibility.

SUGGESTED USES

Recommended for accounts with air dry or force dry capabilities.

RECOMMENDED FOR USE OVER

Imron Elite Express Basecoat (EG quality)
Imron Elite Productive Basecoat (EW quality)
ChromaBase® Basecoat (K quality)
ChromaPremier® Basecoat (F quality)
ChromaPremier Low Haps Basecoat (FL quality)
Imron® 6600 CT Basecoat (CT Quality)
Axalta Sports Equipment Basecoat (SE quality)

NOT RECOMMENDED FOR

Immersion service or over lacquer, alkyd enamel or acrylic enamel 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

COMPONENTS

Imron Elite 8460S Clearcoat
15301S™ Productive Activator
15303S™ Low Temp Activator
15305S™ Mid Temp Activator
15307S™ High Temp Activator
15308S™ Very High Temp Activator

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 8460S Clearcoat	2
15301S/15303S/15305S/15307S/15308S Activator	1



ADDITIVES

Extend pot life and improve dry time:

Add up to 2 oz. of 389S™ Accelerator to activated gal.
Use of accelerator with 15301S is not recommended.

INITIAL APPLICATION VISCOSITY

10-12 seconds with #3 Zahn Cup.

INDUCTION TIME

No induction time is required.

POT LIFE - 70°F (21°C)

2 hours as activated.
1.5 hours with 2 oz 389S accelerator per activated gallon
1.5 hours as activated with 15301S Activator.



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

APPLICATION

- Allow Axalta basecoat to dry 30 minutes prior to application of clearcoat.
- Apply 2 medium-wet coats to 1.8-2.5 mils dry film build. Flash 8-10 minutes between coats.
- For pressure pot application fluid delivery should be set for 10-12 fluid oz/min.
- Allowing air flow to continue in the booth for at least one hour following application of the clearcoat in air-dry situations is recommended.
- Optimum polishing time: 2-48 hours after cool down if force dried, or 16-48 hours if air-dried at 70°F (21°C).
- When recoating 8460S™ with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.

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

130™ Acetone
105™ 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

With 15305S	Without 389S	With 389S
Dry to touch	45-60 min	30-45 min
Tack free	1-2 hours	30-45 min
Tape free	12-24 hours	4-6 hours
Dry to assemble	24 hours	6 hours

With 15301S

Dry to touch	20-30 min
Tack free	30-45 min
Tape free	3-4 hours
Dry to assemble	5-6 hours

FORCE DRY

20-30 minutes at 140-160°F (60-71°C). Purge time before force dry is 10-15 minutes.
With 15301: 15 minutes at 140-160°F (60-71°C). Purge time before force dry is 10-15 minutes.



PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	7.99 lbs./gallon
Weight Per Liter (component only)	956 grams
Suggested Dry Film Thickness	1.8 – 2.5 mils
Gloss	High
Color	Clear
Flash Point (Closed Cup)	See SDS
Shelf Life	12 months minimum

RTS mixed 2:1 with:

Includes 389S as recommended

15301S (activator only)

	15303S
	15305S
	15307S
	15308S
Gallon Weight pounds per gallon - Average	8.28
Gallon Weight grams per liter - Average	992
VOC AP pounds per gallon - Maximum	3.2
VOC AP grams per liter - Maximum	387
VOC LE pounds. per gallon - Maximum	3.5
VOC LE grams per liter - Maximum	415
Weight Solids - Average	54.6%
Volume Solids - Average	47.1%
Weight Volatiles - Average	45.4%
Weight Water - Average	0.0%
Volume Water - Average	0.0%
Weight Exempt Solvents - Average	8.1%
Volume Exempt Solvents - Average	9.4%
Theoretical Coverage per RTS Gallon at 1 mil DFT	754 ft ² (70.0 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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In the United States:
1.855.6.AXALTA
axalta.us

In Canada:
1.800.668.6945
axalta.ca

