

## ELITE

### IMRON® FLEET LINE ELITE 3.5 VOC P.U. TOPCOAT

#### DESCRIPTION

High solids 2-component topcoat system of the Imron® Fleet Line for solid colours for use on buses and trucks.

Composition based on a unique, patented "star" polymer technology.

#### PRODUCTS

PT	PowerTint®
EL-S4343	Permanent White
EL580	Elite Binder HS
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow
ET740	Accelerator

#### PROPERTIES

- Gives superior appearance, very good hiding and low consumption.
- Gives a high gloss finish and has fast drying properties.
- Offers a large application window through specific rheology control agent.
- Can be applied easily in 1.5 coats.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.

#### SUBSTRATES


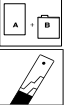







- All OEM finishes, Imron® Fleet Line primer-surfacers or Imron® Fleet Line surfacers.

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#### PRODUCT PREPARATION

	<b>Cromax® colour tools</b>	See colour formula.						
	<b>Mixing ratio (1)</b>	Imron® Elite ET645 ET650 ET655 ET745 ET750 ET755	<b>Fast</b>	<b>Standard</b>	<b>Slow</b>			
			3	3	3			
			1	-	-			
			-	1	1			
			-	-	-			
			0.4-0.7	-	-			
		-	0.4-0.7	-				
		-	-	0.4-0.7				
	<b>VOC</b>	420 g/l						
	<b>Pot life at 20°C</b>	ET645 ET650 ET655	2 hr 2 hr 3 hr					
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	18-22 s 19-23 s					
	<b>Spray equipment</b>	<b>Compliant guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>			
		Gravity feed Suction feed Pressure feed	1.3-1.6 mm 1.5-1.8 mm 1.0-1.2 mm	10-15 cm 10-15 cm 10-15 cm	According to supplier's specifications			
		<b>Conventional guns</b>						
		Gravity feed Suction feed Pressure feed	1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	15-20 cm 15-20 cm 15-20 cm	3-4 bar 3-4 bar 3-4 bar			
	<b>Number of coats</b>	1.5-2						
	<b>Flash time</b>	0-5 min between coats when applying 1.5 coats. Minimum 15 min between coats when applying 2 coats. 15 min before bake.						
	<b>DFT</b>	50-70 µm						
	<b>Drying</b>		<b>ET645</b>		<b>ET650</b>		<b>ET655</b>	
			<b>20°C</b>	<b>30 min x 60°C</b>	<b>20°C</b>	<b>30 min x 60°C</b>	<b>20°C</b>	<b>40 min x 60°C</b>
	<b>Dust-free</b>		25 min	imm.	35 min	imm.	45 min	imm.
	<b>Dry to handle</b>		4 hr	imm.	4 hr 30 min	imm.	5 hr 30 min	imm.
	<b>Tape-free</b>		O.N.	1 hr	O.N.	4 hr	O.N.	4 hr
	<b>IR drying*</b>	Flash time Distance Half power Full power	10 min 80 cm 5 min 10-15 min	* Guideline for short/medium wave IR equipment.				
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.								













**Note:** The different activators and thinners can be intermixed to obtain the best possible system for the ambient temperature and the size of the surface to be painted.

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PRODUCT PREPARATION - ACCELERATED - ET740

ACCELERATED SYSTEM FOR MULTI-TONING AND SMALL SURFACES - Imron® Elite					
	<b>Cromax® colour tools</b>	See colour formula.			
	<b>Mixing ratio</b>	Imron® Elite ET645/ET650 ET740	<b>Accelerated</b>		
			3 1 0.4-0.7		
	<b>VOC</b>	420 g/l			
	<b>Pot life at 20°C</b>	ET645 ET650	30 min 45 min		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	18-22 s 19-23 s s		
	<b>Spray equipment</b>	<b>Compliant guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b> According to supplier's specifications
		Gravity feed Suction feed Pressure feed	1.3-1.6 mm 1.5-1.8 mm 1.0-1.2 mm	10-15 cm 10-15 cm 10-15 cm	
		<b>Conventional guns</b>			
		Gravity feed Suction feed Pressure feed	1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	15-20 cm 15-20 cm 15-20 cm	3-4 bar 3-4 bar 3-4 bar
	<b>Number of coats</b>	1-1.5			
	<b>Flash time</b>	0-5 min between coats when applying 1.5 coats. 10 min before bake.			
	<b>DFT</b>	30-45 µ			
	<b>Drying</b>	<b>Dust-free</b> <b>Dry to handle</b> <b>Tape-free</b>	<b>ET645/ET650</b>		
			<b>20°C</b> 25 min 45 min 1 hr	<b>15 min x 60°C</b> imm. imm. after cool down	
	<b>IR drying*</b>	Flash time Distance Half power Full power	10 min 80 cm 5 min 10-15 min		
* Guideline for short/medium wave IR equipment.					
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#### REMARKS FOR ACCELERATED SYSTEM

- Do not apply on large surfaces (e.g. entire buses, trailers, etc.).
- For optimum result, recoat within a working day.
- Scuff sanding is required:
  - when a topcoat layer, accelerated with ET740, has been force dried and kept overnight;
  - when a topcoat layer, accelerated with ET740, has been force dried more than once.

#### SURFACE PREPARATION

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Sand surface:
  - a. mechanical P360 - P500;
  - b. wet P800 - P1000.
5. Remove all traces of sanding dust by blowing with oil-free compressed air.
6. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
7. Tack rag.

#### TOPCOAT APPLICATION

Apply a light coat, immediately followed by a full coat with 0-5 min flash between coats or apply 2 full coats, with minimum 15 min flash between coats.

#### TOPCOAT APPLICATION ACCELERATED WITH ET740

Apply 1 full coat or apply a light coat, immediately followed by a full coat with 0-5 min flash between coats.

#### TOPCOAT APPLICATION FOR FAC PAC ALUMINIUM COLOURS

Apply 1 full coat, flash 15 min. Apply 1 full coat, immediately followed by a light coat with 0-5 min flash between coats.

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#### CHEMICAL RESISTANCE

When fully cured, Imron® Elite is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

#### RECOATABILITY

At any time after tape-free time. After 24 hr, scuff sanding is required.

#### REMARKS

- PowerTints® have to be thoroughly mixed before weigh-out and the Imron® Elite colour has to be mixed immediately after weigh-out.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For structured and/or flat colours, see specific TDS.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

#### PRODUCT DATA

Theoretical coverage:	7-9 m <sup>2</sup> /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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#### SAFETY

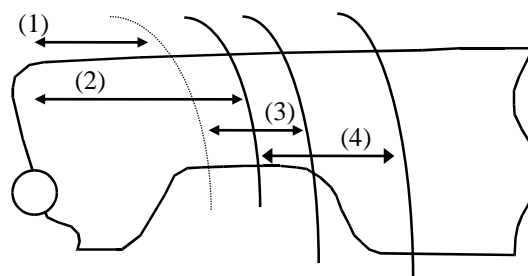
Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

#### SPOT REPAIR

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended.
5. Prepare complete fade-out area with a non silicone containing rubbing compound or sand wet with P1200.
6. Rinse with water and dry.
7. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
8. Tack rag.
9. The following spot repair method can be used:
  - AK350 Fade-out Thinner method.

#### AK350 FADE-OUT THINNER METHOD

- (1) Apply 1<sup>st</sup> coat Imron® Elite.  
Flash: 0-5 min.
- (2) Extend 2<sup>nd</sup> coat Imron® Elite  
beyond the previous one.
- (3) Smoothen out the fade-out area  
with AK350 within 5 min maximum.
- (4) Optionally extend the fade-out area  
with AK350 within 5 min maximum.



If necessary, balance out the gloss level by polishing with a non silicone containing polishing compound or a non silicone containing final glaze, after complete hardening of the repair.

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All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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