

IMRON® TRAFFIC

IMRON® FLEET LINE

TRAFFIC 2K PU TOPCOAT



PRODUCT DESCRIPTION

Imron Fleet Line Traffic 2K PU Topcoat is a non-VOC compliant two-component topcoat from Imron Fleet Line. Imron Traffic TR530, is a medium solids, two-component, polyurethane topcoat binder, ideal for large surface applications. Imron Fleet Line Traffic Topcoat is suitable for non-VOC-regulated markets, delivering excellent results and productivity.

The answer to commercial vehicle refinishing, medium solids topcoat for large surface applications

FEATURES

- 01** Gives a strong, high-gloss finish with excellent appearance, very good hiding and low consumption.
- 02** Provides ease of application and good flow.

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Product preparation - application Standard



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Surfaces must be prepared and cleaned correctly before application
Fleet Line Primer, Primer-surfacer or Surfacer, sanded and cleaned.
Old or original paintwork well sanded and cleaned.
Fleet Line Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process.
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned.



	Spot & Panel repair	Standard	Large surface	Multitoning	
Imron Traffic	4	4	4	4	4
ET645	1	-	-	-	-
ET650	-	1	-	1	-
ET655	-	-	1	-	1
ET740*	-	-	-	1	1
ET745	1 - 1.5	-	-	-	-
ET750	-	1 - 1.5	-	-	-
ET755/ET755A	-	-	1 - 1.5	-	-

*ET740 can be used for multi-toning
Matt colours 5:1 and 0.4 - 0.5 Thinner



Pot life at 20°C: ET645 = 3 hr; ET650 = 4 hr; ET655 = 5 hr.



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	2 - 2.5 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Airmix	0.23 - 0.28	2 - 2.5 bar	atomisation pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



2 coats

with intermediate flash-off: 10 min - 15 min



	ET645		ET650		ET655	
	20 °C	30 min x 60 °C	20 °C	30 min x 60 °C	20 °C	30 min x 60 °C
Dust free	1hr	immediately	1hr	3 hr 30 min	1 hr 30 min	immediately
Dry to handle	3 hr 30 min	immediately	3 hr 30 min	immediately	Minimum 5 hr	immediately
Tape free	Minimum O.N.	4 hr 30 min	Minimum O.N.	6 hr	O.N.	6 hr

VOC compliant

This product mix is not VOC compliant.

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	ET645/ET650/ET740	
	20 °C	15 min x 60 °C
Dust free	35 min	immediately
Dry to handle	1 hr	immediately
Tape free	1 hr 30 min – 2hr	After cool down

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

On well prepared surface, apply 2 full coats with minimum 15 min flash between coats.
For metallic colours, immediately apply an additional mist coat.

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.

RecoatabilityTopcoat

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

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Chemical Resistance

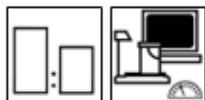
When fully cured, Imron® Elite is resistant to short exposures of the chemicals as listed:

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

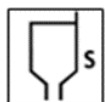
Products

TR530 Imron® Fleet Line Traffic Binder
PTxxx Imron® Fleet Line PowerTint®
ET645 Imron® Fleet Line Activator HS Fast
ET650 Imron® Fleet Line Activator HS
ET655 Imron® Fleet Line Activator HS Slow
ET740 Imron® Fleet Line Accelerator
ET745 Imron® Fleet Line Thinner Fast
ET750 Imron® Fleet Line Thinner
ET755 Imron® Fleet Line Thinner Slow
ET755A Imron® Fleet Line Thinner Slow
805R Flexible Additive
AK350 Fade-out Thinner

Product mix



Mixing ratios with special agents are available in the product mix table on ChromaWeb and in the specific TDS.



DIN 4: 18 - 24 s at 20°C



40 - 60 µm

Theoretical coverage

410 - 420 m²/l at 1 micron dry film thickness

Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.

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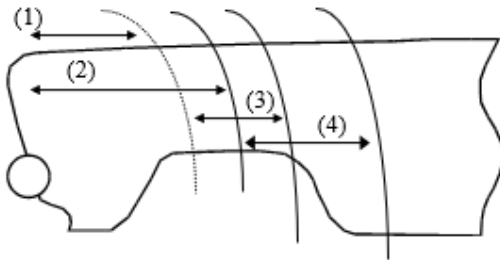
Imron® Fleet Line Traffic 2K PU Topcoat can be overcoated with itself within 8 hours, with scuff sanding



Clean after use with Duxone® 1K Multi Acrylic Thinner.

AK350 Fade-out Thinner method

- (1) Apply 1st coat Imron® Traffic.
Flash: 0-5 min.



- (2) Extend 2nd coat Imron® Traffic
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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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- PowerTints have to be thoroughly mixed before weigh-out and the Imron Fleet Line Traffic 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 Semi-Flexible systems 10% 805R Flexible Additive can be added to the base material. Activator and Thinner ratios remain equal.
- Different gloss levels can be created by using EL555 Flattening Binder. Mixing ratios see colour tools..

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

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

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