

IMRON® ELITE

IMRON® FLEET LINE ELITE

3.5 VOC 2K PU TOPCOAT



PRODUCT DESCRIPTION

Imron Fleet Line Elite 3.5 VOC 2K PU Topcoat is a VOC compliant two-component topcoat from Imron Fleet Line. It has been designed to work with EL580 HS standard binder for high gloss on large flat surfaces. Imron Fleet Line Elite Topcoat is suitable for VOC-regulated markets, delivering excellent results and productivity.

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

FEATURES

- 01** Gives superior appearance, very good hiding and low consumption.
- 02** Provides a high-gloss finish with fast drying.
- 03** Can be applied easily in 1.5 coats.
- 04** Offers a large application window thanks to specific rheology control agent.

TECHNICAL DATA SHEET



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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 Fleet line Elite Topcoat	3	3	3	3	3
ET645	1	-	-	1	-
ET650	-	1	-	-	1
ET655	-	-	1	-	-
ET740*	-	-	-	0.4 - 0.7	0.4 - 0.7
ET745	0.4 - 0.7	-	-	-	-
ET750	-	0.4 - 0.7	-	-	-
ET755/ET755A	-	-	0.4 - 0.7	-	-

Matt colours 5:1 and 0.4 - 0.5 Thinner

*ET740 can be used for multi-toning



Pot life at 20°C: ET645 = 2 hr; ET650 = 2 hr; ET655 = 3 hr.
Pot life at 20°C with ET740 : ET645 = 30 min; ET650 = 45 min.



	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
Membrane pump	1.1	0.8 - 1.3 bar	material 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



0.5 + 1
1 operation
1st: thin and closed
2nd: normal

final flash-off: 5 min - 15 min

2 coats

with intermediate flash-off: 10 min - 15 min
final flash-off: 5 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	25 min	immediately	35 min	immediately	45 min	immediately
Dry to handle	4 hr	immediately	4 hr 30 min	immediately	4 hr 30 min	immediately
Tape free	O.N.	1 hr	O.N.	4 hr	O.N.	4 hr

VOC compliant 2004/42/IIB(d)(420) 420: 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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	ET645/ET650/ET740	
	20 °C	15 min x 60 °C
Dust free	25 min	immediately
Dry to handle	45 min	immediately
Tape free	1 hr	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

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.

RecoatabilityTopcoat

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

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

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Products

EL580 Imron® Fleet Line Elite Binder HS
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: 20 - 25 s at 20°C



40 - 80 µm

Theoretical coverage

590 - 600 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.



Imron® Fleet Line Elite 3.5 VOC 2K PU Topcoat can be overcoated with itself within 24 hours, without intermediate sanding. After 24 hours, scuff sanding is required.



Use Duxone® 1K Multi Acrylic Thinner

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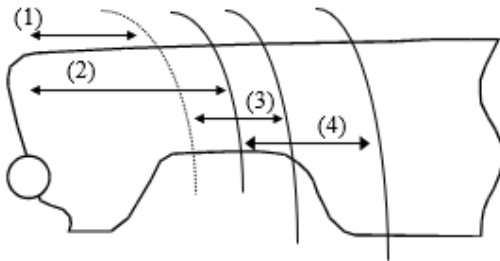
IMRON® FLEET LINE ELITE 3.5 VOC 2K PU TOPCOAT

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 1st coat Imron® Elite.
Flash: 0-5 min.



- (2) Extend 2nd 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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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 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 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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