

# IMRON® ELITE HDC

# IMRON® FLEET LINE ELITE HEAVY DUTY COATING



## PRODUCT DESCRIPTION

Imron Fleet Line Elite Heavy Duty Coating is a VOC-compliant, two-component topcoat from Imron Fleet Line. Developed to provide a robust finish when applied on complex structures like truck chassis, trailers, and construction and agricultural vehicles, it works in combination with EL560 HDC binder. Imron Fleet Line Elite Heavy Duty Coating is suitable for both VOC-regulated and non-VOC-regulated markets, delivering excellent results and productivity.

**The answer to commercial vehicle  
refinishing, robust topcoat for complex  
surface applications**

## FEATURES

- 01** Extremely good sagging resistance through specific rheology control.
- 02** Gives excellent appearance, very good hiding and low consumption.
- 03** Can easily be applied in 1 or 1.5 coats.
- 04** Provides a high-gloss finish with fast drying.
- 05** Offers a large application window.

# TECHNICAL DATA SHEET

## IMRON® ELITE HDC

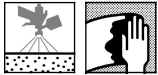


## IMRON® FLEET LINE ELITE HEAVY DUTY COATING

### 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

Primer, Primer-surfacer or Surfacer, sanded and cleaned

Old or original paintwork well sanded and cleaned.

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	Airless / Airmix / Electrostatic	Mixing Ratio for 2K Mixing Machine
Imron Elite HDC	3	3	3	3	2
ET620					1
ET645*	1	-	-	-	-
ET650	-	1	-	-	-
ET655	-	-	1	1	-
ET745	0.4 - 0.7	-	-	-	-
ET750	-	0.4 - 0.7	-	-	0 - 0.1
ET751	-	-	-	until 28 - 32 s DIN4	-
ET755	-	-	0.4 - 0.7	-	-

\*ET740 can be used for multi-toning

Matt colours 5:1 and 0.4 - 0.5 Thinner



Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	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

before bake: 5 min - 15 min

2 coats

with intermediate flash-off: 10 min - 15 min

before bake: 5 min - 15 min



	ET620/ET645/ET650/ET655
20 °C	12 hr - 16 hr
60 - 65 °C	30 min - 45 min

VOC compliant

2004/42/II(B)(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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### Products

EL560 Imron® Fleet Line Elite HDC Binder  
PTxxx Imron® Fleet Line PowerTint®

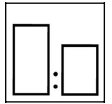
ET645 Imron® Fleet Line Activator HS Fast  
ET650 Imron® Fleet Line Activator HS  
ET655 Imron® Fleet Line Activator HS Slow

ET740 Imron® Fleet Line Accelerator

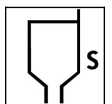
ET745 Imron® Fleet Line Thinner Fast  
ET750 Imron® Fleet Line Thinner  
ET755 Imron® Fleet Line Thinner Slow

805R Flexible Additive

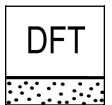
### Product mix



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



DIN 4: 20 - 25 s at 20°C



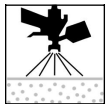
40 - 80 µm

#### Theoretical coverage

590 - 600 m<sup>2</sup>/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 Heavy Duty Coating can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

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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.
- Application for RAL9006: Apply 1 full coat, flash 15 minutes. Apply 1 full coat, immediately followed by a light coat with 0-5 minutes flash between coats.
- For optimum result, recoat within a working day.
- Fleet Thinner can be replaced 1:1 by Imron Fleet Line Accelerator ET740 (add 5 to max 15%) for multitonning.
- 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.
- 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.
- 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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