

## EL500

27.08.2014

### IMRON® FLEET LINE CLEAR HS

#### DESCRIPTION

2-component Low Emission clear, to be used in clear over Imron® Fleet Line topcoat system. Composition based on acrylic copolymer and a unique, patented “star” polymer technology.

#### PRODUCTS

|       |                   |
|-------|-------------------|
| EL500 | Clear HS          |
| ET645 | Activator HS Fast |
| ET650 | Activator HS      |
| ET655 | Activator HS Slow |

#### PROPERTIES

- Can be applied in one full coat.
- Can be used over Imron® Elite and Imron® Traffic\* topcoats.
- Combines very easy application with little sagging risks.
- Gives a smooth, high build finish.
- Has excellent mar, chemical and weather resistance.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.

#### SUBSTRATES

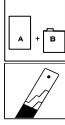






- Imron® Fleet Line topcoat system.
- Basecoats

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#### PRODUCT PREPARATION

|  |                                |  |                  |                      |                 |             |  |        |                      |
|--|--------------------------------|--|------------------|----------------------|-----------------|-------------|--|--------|----------------------|
|    | <b>Mixing ratio</b>            |  | <b>Fast</b>      |                      | <b>Standard</b> |             | <b>Slow</b>                            |        |                      |
|  |                                | EL500  | Volume           | Weight               | Volume          | Weight      | Volume                                 | Weight |                      |
|  |                                | ET645  | 3                | 100                  | 3               | 100         | 3                                      | 100    |                      |
|  |                                | ET650  | 1                | 37                   | -               | -           | -                                      | -      |                      |
|  |                                | ET655  | -                | -                    | 1               | 37          | -                                      | -      |                      |
|  |                                | -  | -                | -                    | -               | 1           | 37                                     |        |                      |
|  | <b>VOC</b>                     | 420 g/l  |                  |                      |                 |             |  |        |                      |
|    | <b>Pot life at 20°C</b>        | ET645  | 3 hr             |                      |                 |             |  |        |                      |
|  |                                | ET650  | 3 hr             |                      |                 |             |  |        |                      |
|  |                                | ET655  | 5 hr             |                      |                 |             |  |        |                      |
|    | <b>Spray viscosity at 20°C</b> | <b>DIN 4</b>   | 18-20 s          |                      |                 |             |  |        |                      |
|  |                                | <b>FORD 4</b>  | 19-21 s          |                      |                 |             |  |        |                      |
|   | <b>Spray equipment</b>         | <b>Compliant guns</b>  | <b>Fluid tip</b> |                      | <b>Distance</b> |             | <b>Pressure</b>                        |        |                      |
|  |                                | Gravity feed   | 1.3-1.5 mm       |                      | 10-15 cm        |             | According to supplier's specifications |        |                      |
|  | Suction feed                   | 1.5-1.8 mm   |                  | 10-15 cm             |                 |             |  |        |                      |
|  | Pressure feed                  | 1.0-1.2 mm   |                  | 10-15 cm             |                 |             |  |        |                      |
|  |                                | <b>Conventional guns</b>   | 1.4-1.6 mm       |                      | 15-20 cm        |             | 3-4 bar                                |        |                      |
|  |                                | Suction feed   | 1.6-1.8 mm       |                      | 15-20 cm        |             | 3-4 bar                                |        |                      |
|  | Pressure feed                  | 1.0-1.2 mm   |                  | 15-20 cm             |                 | 3-4 bar     |  |        |                      |
|  | <b>Number of coats</b>         | 1-2  |                  |                      |                 |             |  |        |                      |
|  | <b>Flash time</b>              | 0-5 min between coats when applying 1.5 coats.<br>15-45 min between coats when applying 2 full coats.<br>10 min before bake. |                  |                      |                 |             |  |        |                      |
|  | <b>DFT</b>                     | 30-65 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>40 min x 60°C</b> |
|  |                                | <b>Dust-free</b>   | 1 hr             | imm.                 |                 | 1 hr 30 min | imm.                                   |        | imm.                 |
|  |                                | <b>Dry to handle</b>   | 6 hr             | imm.                 |                 | O.N.        | imm.                                   |        | 30 min               |
|  | <b>Tape-free</b>               | O.N.   | 1 hr             |                      | O.N.            | 1 hr 30 min |  | 3 hr   |                      |
|  | <b>IR drying*</b>              | Flash time   | 5 min            |                      |                 |             |  |        |                      |
|  |                                | Distance   | 80 cm            |                      |                 |             |  |        |                      |
|  |                                | Half power   | 5 min            |                      |                 |             |  |        |                      |
|  |                                | Full power   | 15-20 min        |                      |                 |             |  |        |                      |

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.

## EL500

27.08.2014

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#### 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.
8. Apply Imron® Fleet Line topcoats.
  - For wet-on-wet application, ET655 must be used in the Imron® Fleet Line topcoat. Flash maximum 2 hr between topcoat and clearcoat, to obtain best possible results.
  - If the topcoat is baked or air dried overnight before application of the clearcoat, ET645 or ET650 may also be used instead of ET655, in the colour coat.

#### CLEARCOAT APPLICATION

Apply 1 full coat or apply a light coat immediately followed by a full coat with 0-5 min flash between coats. Can also be applied in 2 full coats with 15-45 min flash between coats.

#### CHEMICAL RESISTANCE

When fully cured, EL500 is resistant to short exposures of the chemicals as listed:

|                   |      |                     |
|-------------------|------|---------------------|
| sodium hydroxide  | 10 % | xylene              |
| sulphuric acid    | 20 % | lead free fuel      |
| hydrochloric acid | 5 %  | methyl ethyl ketone |
| nitric acid       | 10 % |                     |

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

## EL500

27.08.2014

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### RECOATABILITY

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

### REMARKS

- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Activated material should not be returned to original can of non-activated material.
- Dry spray spots in the clear can be worked off with AK350 at very low spray pressure. This should be done at the latest 5 min after clear application and should be avoided on horizontal parts.
- For structured and/or flat clears, 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

Package viscosity: 47 cp  
Theoretical coverage: 6-11 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.

### SAFETY

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

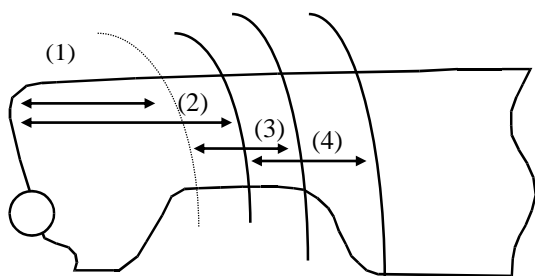
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#### SPOT REPAIR: AK350 FADE-OUT THINNER METHOD

- (1) Apply 1 coat of EL500 over the topcoat, extending into the area surrounding the spot.
  - (2) Apply a 2<sup>nd</sup> coat of EL500, extending further into the area surrounding the spot.
  - (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.
- ! Surface should be carefully and correctly prepared before the topcoat application. See recommended use, paragraph surface preparation.
- ! Stay within the application of AK350 within the prepared area.



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.

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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