

## TRAFFIC

27.08.2014

### IMRON® FLEET LINE TRAFFIC 2K POLYURETHANE

#### DESCRIPTION

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

Composition based on functional polyurethane.

#### PRODUCTS

|       |                   |
|-------|-------------------|
| PT    | PowerTint®        |
| TR530 | Traffic Binder    |
| ET645 | Activator HS Fast |
| ET650 | Activator HS      |
| ET655 | Activator HS Slow |
| ET745 | Thinner Fast      |
| ET750 | Thinner           |
| ET755 | Thinner Slow      |
| ET740 | Accelerator       |

#### PROPERTIES

- Gives a strong, high gloss finish with excellent appearance, very good hiding and low consumption.
- Provides ease of application and good flow.
- Can be used for spot, panel and overall repair.

#### SUBSTRATES


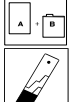







- All OEM finishes, Imron® Fleet Line primer-surfacers or Imron® Fleet Line surfacers.

## TRAFFIC

27.08.2014

### IMRON® FLEET LINE TRAFFIC 2K POLYURETHANE

#### PRODUCT PREPARATION

|  |                                |   |  |   |   |  |  |  |
|--|--------------------------------|---|--|---|---|--|--|--|
|    | <b>Cromax® colour tools</b>    | See colour formula.   |  |   |   |  |  |  |
|    | <b>Mixing ratio (1)</b>        | Imron® Traffic<br>ET645<br>ET650<br>ET655<br>ET745<br>ET750<br>ET755      | <b>Fast</b>                                |   | <b>Standard</b>                                 |  | <b>Slow</b>                                |  |
|  |                                |   | 4<br>1<br>-<br>-<br>1-1.5<br>-<br>-        | 4<br>-<br>1<br>-<br>-<br>1-1.5<br>-                 | 4<br>-<br>-<br>1<br>-<br>-<br>1-1.5             |  |  |  |
|  | <b>VOC</b>                     | 540 g/l   |  |   |   |  |  |  |
|   | <b>Pot life at 20°C</b>        | ET645<br>ET650<br>ET655   | 3 hr<br>4 hr<br>5 hr                       |   |   |  |  |  |
|  | <b>Spray viscosity at 20°C</b> | <b>DIN 4</b><br><b>FORD 4</b>   | 19-25 s<br>20-26 s<br>s                    |   |   |  |  |  |
|  | <b>Spray equipment</b>         | <b>Compliant guns</b><br>Gravity feed<br>Suction feed<br>Pressure feed    | <b>Fluid tip</b>                           |   | <b>Distance</b>                                 | <b>Pressure</b>                              |  |  |
|  |                                |   | 1.3-1.6 mm<br>1.5-1.8 mm<br>1.0-1.2 mm     | 10-15 cm<br>10-15 cm<br>10-15 cm                    | According to supplier's specifications          |  |  |  |
|  |                                | <b>Conventional guns</b><br>Gravity feed<br>Suction feed<br>Pressure feed | 1.4-1.6 mm<br>1.6-1.8 mm<br>1.0-1.2 mm     |   | 15-20 cm<br>15-20 cm<br>15-20 cm                |  | 3-4 bar<br>3-4 bar<br>3-4 bar              |  |
|  | <b>Number of coats</b>         | 2   |  |   |   |  |  |  |
|  | <b>Flash time</b>              | 15 min between coats.<br>15 min before bake.                              |  |   |   |  |  |  |
|  | <b>DFT</b>                     | 50-60 µm  |  |   |   |  |  |  |
|  | <b>Drying</b>                  | <b>Dust-free</b><br><b>Dry to handle</b><br><b>Tape-free</b>              | <b>ET645</b>                               |   | <b>ET650</b>                                    |  | <b>ET655</b>                               |  |
|  |                                |   | <b>20°C</b><br>1 hr<br>3 hr 30 min<br>O.N. | <b>30 min x 60°C</b><br>imm.<br>imm.<br>4 hr 30 min | <b>20°C</b><br>1 hr<br>3 hr 30 min<br>O.N.      | <b>30 min x 60°C</b><br>imm.<br>imm.<br>6 hr | <b>20°C</b><br>1 hr 30 min<br>5 hr<br>O.N. | <b>40 min x 60°C</b><br>imm.<br>imm.<br>6 hr |
|  | <b>IR drying*</b>              | Flash time<br>Distance<br>Half power<br>Full power                        | 10 min<br>80 cm<br>5 min<br>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.


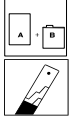







**Note:** The different activators and thinners can be intermixed to obtain the best possible system for the ambient temperature and the size of the surface to be painted.

## TRAFFIC

27.08.2014

### IMRON® FLEET LINE TRAFFIC 2K POLYURETHANE

#### PRODUCT PREPARATION - ACCELERATED - ET740

| ACCELERATED SYSTEM FOR MULTI-TONING AND SMALL SURFACES - Imron® Traffic  |  |  |  |  |
|--|--|--|--|--|
|    | <b>Cromax® colour tools</b>                      | See colour formula.  |  |  |
|    | <b>Mixing ratio</b>                              | Imron® Traffic<br>ET645/ET650<br>ET740   | <b>Accelerated</b>   |  |
|  |  |  | 4  | 1  |
|  |  |  | 1  | 1  |
|  | <b>VOC</b>                                       | 540 g/l  |  |  |
|    | <b>Pot life at 20°C</b>                          | ET645<br>ET650   | 30 min<br>45 min   |  |
|   | <b>Spray viscosity at 20°C</b>                   | <b>DIN 4<br/>FORD 4</b>  | 19-25 s<br>20-26 s<br>s                                    |  |
|    | <b>Spray equipment</b>                           | <b>Compliant guns</b><br>Gravity feed<br>Suction feed<br>Pressure feed   | <b>Fluid tip</b><br>1.3-1.6 mm<br>1.5-1.8 mm<br>1.0-1.2 mm | <b>Distance</b><br>10-15 cm<br>10-15 cm<br>10-15 cm  |
|  |  | <b>Conventional guns</b><br>Gravity feed<br>Suction feed<br>Pressure feed  | 1.4-1.6 mm<br>1.6-1.8 mm<br>1.0-1.2 mm                     | <b>Pressure</b><br>According to supplier's specifications<br>3-4 bar<br>3-4 bar<br>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.<br>5-10 min between coats when applying 2 coats.<br>10 min before bake. |  |  |
|  | <b>DFT</b>                                       | 30-45 µm   |  |  |
|    | <b>Drying</b>                                    |  | <b>ET645/ET650</b>   |  |
|  | <b>Dust-free<br/>Dry to handle<br/>Tape-free</b> |  | <b>20°C</b><br>35 min<br>1 hr<br>1 hr 30 min - 2 hr        | <b>15 min x 60°C</b><br>imm.<br>imm.<br>after cool down                                    |
|    | <b>IR drying*</b>                                | Flash time<br>Distance<br>Half power<br>Full power   | 10 min<br>80 cm<br>5 min<br>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. |  |  |  |  |

#### REMARKS FOR ACCELERATED SYSTEM

3/7 AUS TRAFFIC-0

This Technical Data Sheet supersedes all previous issues

## TRAFFIC

27.08.2014

### IMRON® FLEET LINE TRAFFIC 2K POLYURETHANE

- 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 mistcoat.

### TOPCOAT APPLICATION ACCELERATED WITH ET740

Apply a light coat immediately followed by a full coat with 0-5 min flash between coats or apply 2 full coats with 5-10 min flash between coats.

### CHEMICAL RESISTANCE

When fully cured, Imron® Traffic 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 |

## TRAFFIC

27.08.2014

### IMRON® FLEET LINE TRAFFIC 2K POLYURETHANE

#### 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® 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 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: 6-7 m<sup>2</sup>/l at recommended DFT - ready-to-spray

#### SAFETY

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

## TRAFFIC

27.08.2014

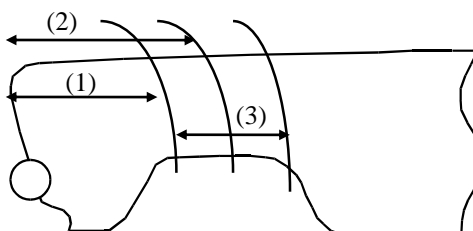
### IMRON® FLEET LINE TRAFFIC 2K POLYURETHANE

#### 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® Traffic.  
Flash: 3-5 min.
- (2) Extend 2<sup>nd</sup> coat Imron® Traffic  
beyond the previous one.
- (3)



Smoothen out the fade-out area with AK350.

OPTIONAL: dilute remaining part Imron® Traffic with 1 part AK350 after 2<sup>nd</sup> coat and apply 1 coat of this mixture extending in the blending area, before blending in the fade-out area with pure AK350.

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.

## TRAFFIC

27.08.2014

### IMRON® FLEET LINE TRAFFIC 2K POLYURETHANE

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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.