



Effective 24 May, 2008

IMRON® ELITE HDC

HEAVY DUTY COATING

Description

High solids 2-component solid colour topcoat from the Imron® Fleet Line system specially developed to provide a robust performance when applied on complex structures like truck chassis, trailers, construction and agricultural vehicles.
Composition based on a unique, patented "star" polymer technology.

Products

PT	PowerTint®
EL560	HDC Binder
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET751	Special Application Thinner Standard
ET755	Thinner Slow
ET740	Accelerator

Properties

- Gives excellent appearance, very good hiding and low consumption.
- Gives a high gloss finish and has fast drying properties.
- Offers a large application window providing an extremely good sagging resistance through specific rheology control.
- Can easily be applied in 1 or 1.5 coat on various complex structures like chassis, trailers, construction and agricultural vehicles, etc.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.

Substrates

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


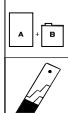









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PRODUCT PREPARATION

	DuPont Refinish colour tools	See colour formula.						
	Mixing ratio (1)		Fast	Standard	Slow	Airless/Airmix/ Electrostatic		
	Imron® Elite HDC		3	3	3	3		
	ET645		1	-	-	-		
	ET650		-	1	-	-		
	ET655		-	-	1	1		
	ET745		0.4-0.7	-	-	-		
	ET750		-	0.4-0.7	-	-		
	ET751		-	-	-	-		
	ET755		-	-	0.4-0.7	until 28-32 s DIN 4 -		
	VOC		420 g/l					
	Pot life at 20°C	ET645	3 hr	-	-	-		
		ET650	-	3 hr 30 min	-	-		
		ET655	-	-	4 hr	1 hr		
	Spray viscosity at 20°C	DIN 4 FORD 4	19-25 s 20-26 s					
	Spray equipment		Fluid tip	Distance	Pressure			
	Conventional guns							
	Gravity feed		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			
	Compliant guns (HVLP/HTE)							
	Gravity feed		1.3-1.6 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				
	High pressure guns		Fluid tip	Pump pressure	Atomisation pressure			
	Airless		0.23-0.28 mm	± 200 bar	-			
	Airmix		0.23 mm	± 100 bar	4 bar			
	Electrostatic		0.23-0.28 mm	± 100 bar	3.5 bar			
	Number of coats	Good hidrs: 1-1.5 Poor hidrs: 2						
	Flash time	Good hidrs: 0-5 min between coats when applying 1.5 coats. Poor hidrs: minimum 15 min between coats when applying 2 coats. 15 min before bake.						
	DFT	50-70 µm						
	Drying		ET645		ET650		ET655	
			20°C	30 min x 60°C	20°C	30 min x 60°C	20°C	40 min x 60°C
	Dust-free		40 min	imm.	40 min	imm.	1 h	imm.
	Dry to handle		5 hr	imm.	5 hr 30 min	imm.	6 hr 15 min	imm.
	Tape-free		5 hr	after cool down	6 hr	after cool down	6 hr 30 min	after cool down
	IR drying*	Flash time	10 min					
		Distance	80 cm					
		Half power	5 min					
		Full power	10-15 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.

(1) 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.


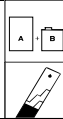









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PRODUCT PREPARATION - ACCELERATED - ET740

ACCELERATED SYSTEM FOR MULTI-TONING AND SMALL SURFACES - Imron® Elite HDC					
	DuPont Refinish colour tools	See colour formula.			
	Mixing ratio	Imron® Elite HDC ET645/ET650 ET740	Accelerated 3 1 0.4-0.7		
	VOC	420 g/l			
	Pot life at 20°C	ET645 ET650	30 min 45 min		
	Spray viscosity at 20°C	DIN 4 FORD 4	19-25 s 20-26 s		
	Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip 1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	Distance 15-20 cm 15-20 cm 15-20 cm	Pressure 3-4 bar 3-4 bar 3-4 bar
		Compliant guns (HVLP/HTE) Gravity feed Suction feed Pressure feed	1.3-1.6 mm 1.5-1.8 mm 1.0-1.2 mm	10-15 cm 10-15 cm 10-15 cm	According to supplier's specifications
	Number of coats	1-1.5			
	Flash time	0-5 min between coats when applying 1.5 coats. 10 min before bake.			
	DFT	30-45 µm			
	Drying	Dust-free Dry to handle Tape-free	ET645/ET650		
			20°C 25 min 45 min 1 hr	15 min x 60°C imm. imm. after cool down	
	IR drying*	Flash time Distance Half power Full power	10 min 80 cm 5 min 10-15 min	* Guideline for short/medium wave IR equipment.	
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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.



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RECOMMENDED USE

Surface preparation

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara® wipes.
3. Repair according to damage.
4. Sand surface:
 - a. mechanical P360 - P500;
 - b. wet P800 - P1000.
5. Remove all traces of sanding dust, blowing with clean oil-free compressed air.
6. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.
7. Tack rag.

Topcoat application

Apply 1 full coat or apply a light coat, immediately followed by a full coat with 0-5 min flash between coats. For poor hidlers, 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.

Chemical resistance

When fully cured, Imron® Elite HDC 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

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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RECOMMENDED USE (con'd)

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® Elite HDC 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: 7-9 m²/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.

Products	Packages (l)	Shelf life at 20°C (year)
PT1xx PowerTint®	1 - 3.5	3
EL560	3.5	2
ET645	1 - 5	2
ET650	5	2
ET655	5	2
ET745	5	2
ET750	1 - 5	2
ET751	5	2
ET755	5	2
ET740	1	1

Safety

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



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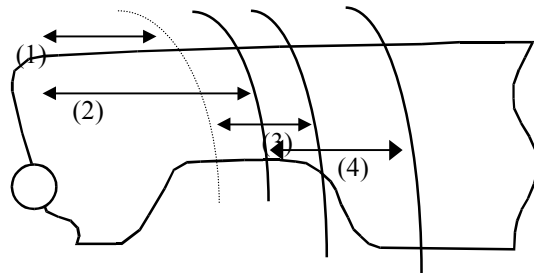
REPAIR SYSTEMS

Spot repair

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara® cloths.
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 DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® cloths.
8. Tack rag with a Sontara® tack cloth.
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 HDC.
Flash: 0-5 min.
- ② Extend 2nd coat Imron® Elite HDC
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.