

EL500

IMRON® FLEET LINE CLEAR HS



PRODUCT DESCRIPTION

Imron Fleet Line Clear HS EL500 is a low-emission, VOC-compliant 2K clearcoat that can be applied over Imron Elite and Imron Traffic topcoats in 1.5 or 2 coats. It is suitable for spot, panel and overall repairs, delivering a smooth, high-build finish.

Versatile clearcoat for commercial vehicles applications

FEATURES

- 01** Combines very easy application with reduced sagging risks.
- 02** Has a wide application window.
- 03** Can be used over Imron Elite and Imron Traffic topcoats.
- 04** Offers smooth, high-build finish.
- 05** Based on innovative resin technology.
- 06** Delivers high gloss retention durability coupled with excellent mar, chemical and weather resistance.
- 07** Suitable for use in multi-layer applications.

TECHNICAL DATA SHEET

EL500



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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.



Imron Fleet Line 2K Topcoats: Surfaces must be sanded and degreased before application. Centari 600 or 6000 basecoats activated with 10% BK220 by volume.



	Spot & panel repair		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
EL500	3	100	3	100	3	100
ET645	1	37	-	-	-	-
ET650	-	-	1	37	-	-
ET655	-	-	-	-	1	37

* Matt gloss levels 4:1



Pot life at 20°C: ET645 = 3 hr; ET650 = 3 hr; ET655 = 5 hr.



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2.2 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

see manufacturer's instructions



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

with intermediate flash-off: 0 min - 2 min
final flash-off: 5 min - 10 min

2 coats

with intermediate flash-off: 15 min - 45 min
final flash-off: 10 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	1 hr	immediately	1 hr 30 min	immediately	1 hr 30 min	immediately
Dry to handle	6 hr	immediately	O.N.	immediately	O.N.	30 min
Tape free	O.N.	1 hr	O.N.	1 hr 30 min	O.N.	3 hr



Guideline for short wave IR equipment Half power: 5 min
Full power: 15 - 20 min

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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EL500



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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.

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 %	

Products

EL500 Imron® Fleet Line Clear HS
ET645 Imron® Fleet Line Activator HS Fast
ET650 Imron® Fleet Line Activator HS
ET655 Imron® Fleet Line Activator HS Slow
EL555 Imron® Fleet Line Flattening Binder
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.



ISO 4: 45 - 53 s at 20°C
DIN 4: 18 - 20 s at 20°C



50 - 60 µm

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EL500



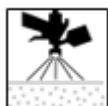
IMRON® FLEET LINE CLEAR HS

Theoretical coverage

505 - 510 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.



EL500 Imron® Fleet Line Clear HS can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with AXT350 Axalta Multi Acrylic Thinner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Close can of Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- 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.
- Imron Fleet Line 2K Topcoats: Surfaces must be sanded and degreased before application, also non-sanding application possible after 30 minutes flash-off.
- For Semi-Flexible systems 10% 805R Flexible Additive can be added to the base material.
- Different gloss levels can be created by using EL555 Flattening Binder. Mixing ratios see colour tools.
- Do not apply if material, substrate or ambient temperature is less than 10°C or above 45°C. The substrate must be at least 3°C above the dew point. Relative humidity should be below 90%.

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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