



Effective 5 October, 2011

# IMRON® 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®
TR-46373	Imron® Traffic RAL9006 White Aluminium
TR-46411	Imron® Traffic RAL9007 Grey Aluminium
TR530	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.



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## PRODUCT PREPARATION

	<b>DuPont Refinish colour tools</b>	See colour formula.						
	<b>Mixing ratio (1)</b>	Imron® Traffic ET645 ET650 ET655 ET745 ET750 ET755	<b>Fast</b>		<b>Standard</b>		<b>Slow</b>	
			4	4	4			
			1	-	-	-	-	
			-	1	-	-	1	
			-	-	-	-	-	
			1-1.5	-	-	-	-	
		-	1-1.5	-	-	-		
		-	-	-	-	1-1.5		
	<b>VOC</b>	540 g/l						
	<b>Pot life at 20°C</b>	ET645	3 hr					
		ET650	4 hr					
		ET655	5 hr					
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>						
			19-25 s		20-26 s		23-29 s	
	<b>Spray equipment</b>	<b>Fluid tip</b>		<b>Distance</b>		<b>Pressure</b>		
	<b>Conventional guns</b>							
	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		
	<b>Compliant guns (HVLP/HTE)</b>							
	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				
	<b>Number of coats</b>	2						
	<b>Flash time</b>	15 min between coats. 15 min before bake.						
	<b>DFT</b>	50-60 µ						
	<b>Drying</b>	<b>Dust-free</b> <b>Dry to handle</b> <b>Tape-free</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>20°C</b>	<b>40 min x 60°C</b>
			1 hr	imm.	1 hr	imm.	1 hr 30 min	imm.
			3 hr 30 min	imm.	3 hr 30 min	imm.	5 hr	imm.
		O.N.	4 hr 30 min	O.N.	6 hr	O.N.	6 hr	
	<b>IR drying*</b>	Flash time	10 min					
		Distance	80 cm					
		Half power	5 min					
		Full power	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.

(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.


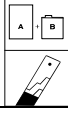









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## PRODUCT PREPARATION - ACCELERATED - ET740

ACCELERATED SYSTEM FOR MULTI-TONING AND SMALL SURFACES - Imron® Traffic					
	<b>DuPont Refinish colour tools</b>	See colour formula.			
	<b>Mixing ratio</b>	Imron® Traffic ET645/ET650 ET740	<b>Accelerated</b>		
			4 1 1		
	<b>VOC</b>	540 g/l			
	<b>Pot life at 20°C</b>	ET645 ET650	30 min 45 min		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	19-25 s 20-26 s 23-29 s		
	<b>Spray equipment</b>	<b>Conventional guns</b> Gravity feed Suction feed Pressure feed	<b>Fluid tip</b> 1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	<b>Distance</b> 15-20 cm 15-20 cm 15-20 cm	<b>Pressure</b> 3-4 bar 3-4 bar 3-4 bar
		<b>Compliant guns (HVL P/HTE)</b> 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
	<b>Number of coats</b>	1.5-2			
	<b>Flash time</b>	0-5 min between coats when applying 1.5 coats. 5-10 min between coats when applying 2 coats. 10 min before bake.			
	<b>DFT</b>	30-45 µ			
	<b>Drying</b>		<b>ET645/ET650</b>		
	<b>Dust-free</b> <b>Dry to handle</b> <b>Tape-free</b>		20°C 35 min 1 hr 1 hr 30 min - 2 hr	15 min x 60°C imm. imm. after cool down	
	<b>IR drying*</b>	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 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, blowing oil-free compressed air.
6. Degrease with a correct DuPont Refinish 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

### 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® 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

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
PT1xx PowerTint®	1 - 3.5	3	-
TR-46373	3.5	2	1.003
TR-46411	3.5	2	0.999
TR530	3.5	3	0.996
ET645	1 - 5	3	1.062
ET650	5	3	1.076
ET655	5	3	1.081
ET745	5	5	0.823
ET750	5	5	0.905
ET755	5	5	0.918
ET740	1	2	0.882

### Safety

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



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## REPAIR SYSTEMS

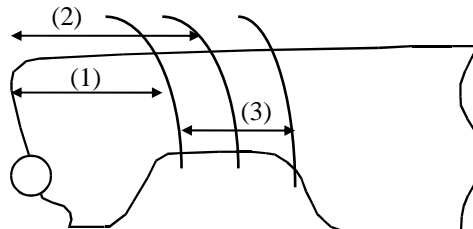
### Spot repair

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with 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 DuPont Refinish 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
- (3) beyond the previous one.

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.

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