

MONO93

IMRON® FLEET LINE

MONOPRIMER 93



PRODUCT DESCRIPTION

Imron Fleet Line 1K Wash primer MONO93 is a wash primer-surfacer with anti-corrosion and good filling properties. It is chromate-free, environmentally responsible and user-friendly. Imron Fleet Line 1K Wash primer MONO93 promotes adhesion to various metals.

Filling wash primer-surfacer

FEATURES

- 01** No primer required.
- 02** Delivers good topcoat hold-out and good overspray melt-in on large surfaces.
- 03** Offers very good corrosion resistance over ferrous metal.
- 04** Provides good filling properties.
- 05** Suitable for overcoating with Imron Fleet Line 2K surfacers and topcoats.

TECHNICAL DATA SHEET



MONO93

IMRON® FLEET LINE MONOPRIMER 93

Product preparation - application STANDARD NON-SANDING



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanised steel or aluminium sanded and cleaned
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



	Standard		Airmix / airless	
	Volume	Weight	Volume	Weight
MONO93	1	100	1	100
TH93	0.5	40	0 - 0.35	0 - 28



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.3	90 - 120 bar	material pressure

see manufacturer's instructions



	Primer	Primer-surfacer
1 coat	flash-off until matt	2 - 3 coats with intermediate flash-off: 5 min - 10 min final flash-off: 15 min - 30 min 8 hr max before topcoat.



	Primer	Primer-surfacer
	Imron Fleet Line 2K Surfacer	Imron Fleet Line 2K Topcoats

VOC compliant

2004/42/IIB(c)(780) 780: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 780 g/l.

TECHNICAL DATA SHEET



MONO93

IMRON® FLEET LINE MONOPRIMER 93



Drying temperature	Dry to sand
20 °C	1 hr
40 °C	45 min
60 °C	30 min

Surface Preparation

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

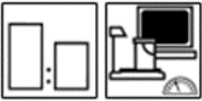
1. Clean surface with a preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust by blowing with oil-free compressed air.
4. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

Products

MONO93 Imron® Fleet Line Monoprimer 93

TH93 Imron® Fleet Line Thinner 93

Product mix



Mixing ratios with special agents are available in the product mix table on ChromaWeb and in the specific TDS.



DIN 4: 20 - 30 s at 20°C



15 - 20 µm primer
25 - 30 µm primer-surfacer

Theoretical coverage

290 - 300 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.

TECHNICAL DATA SHEET



MONO93

IMRON® FLEET LINE MONOPRIMER 93



Clean after use with Duxone® 1K Multi Acrylic Thinner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Do not use polyester putty or Epoxy Primer-Surfacer over this product. Hardening and adhesion of polyester and epoxy products will be affected.
- Adhesion and flow problems will occur with activated material older than 5 days.

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.

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-date and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant 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.