

P702

IMRON® FLEET LINE HIGH SOLIDS SURFACER



PRODUCT DESCRIPTION

Imron Fleet Line High Solids Surfacers Off White P702 is a 2K high-solids surfacer with excellent filling properties, which provide very good isolation and defect rectification.

Excellent ValueShade



Developed by Cromax®, ValueShade® delivers the optimal undercoat for every topcoat colour.

FEATURES

- 01** Has low VOC content, very high solids technology that offers better filling.
- 02** Can be coated with all Imron Fleet Line topcoats.
- 03** Provides the same build with fewer coats, resulting in reduced consumption.
- 04** Offers excellence in mechanical and wet sanding.
- 05** Delivers superior topcoat hold-out.

TECHNICAL DATA SHEET



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Product preparation - application STANDARD SANDING



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Fleetline Wash Primer or Fleetline 2K Epoxy primer.

Coil coated, sanded and cleaned
 Glass fiber reinforced polyester substrates, free of release agents, sanded and cleaned.
 Old or original paintwork well sanded and cleaned.
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
 OEM Primer (e-coat), sanded and cleaned.



	Small surface		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
P702	7	100	7	100	7	100
ET645	1	10	-	-	-	-
ET650	-	-	1	10	-	-
ET655	-	-	-	-	1	10
ET745 / ET750	1	8	-	-	-	-
ET745 / ET750 / ET755	-	-	1	9	-	-
ET750 / ET755	-	-	-	-	1	4



Pot life at 20°C: 1 hr 30 min - 2 hr



Compliant	1.4 - 1.6	2 - 2.5 bar	atomisation pressure
HVLP	1.4 - 1.6	0.7 bar	inlet pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.2 - 0.3	90 - 120 bar	material pressure

see manufacturer's instructions



1 - 3 coats

intermediate flash-off until
 matt
 final flash-off: 10 min - 15 min



Dry			
20 °C	3 hr - 4 hr	3 hr - 4 hr	4 hr - 6 hr
60 - 65 °C	20 min	20 min - 30 min	30 min - 40 min



Guideline for short wave IR equipment
 Half power: 5 min



Imron Fleet Line 2K Topcoats
 Centari 600 or 6000 basecoats activated with 10% BK220 by volume.



P320 - P400

TECHNICAL DATA SHEET





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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.

 Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer
Coil coated, sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Old or original paintwork well sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.




	Volume	Weight
P702	4	100
ET655	1	18
LE2031	3	45


 Pot life at 20°C: 2-3 hr ET655.




	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	atomisation pressure
HVLP	1.4 - 1.6	0.7 bar	inlet pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.2 - 0.3	90 - 120 bar	material pressure

see manufacturer's instructions

 1 hr
(till 8hr maximum)
before recoating

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

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Centari 600 or 6000 basecoats activated with 10% BK220 by volume.

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SURFACE PREPARATION

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
Before applying sanding surfacer: mechanical with P280 - P320, wet with P360-P500.
4. Remove all traces of sanding dust, by blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

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.
5. Apply 1 coat of Imron® Fleet Line wash primer or Imron® Fleet Line epoxy primer.

Products

P702 Imron® Fleet Line High Solids Surfacers - VS2
ET645 Imron® Fleet Line Activator HS Fast
ET650 Imron® Fleet Line Activator HS
ET655 Imron® Fleet Line Activator HS Slow
ET745 Imron® Fleet Line Thinner Fast
ET750 Imron® Fleet Line Thinner
ET755 Imron® Fleet Line Thinner Slow

Product mix



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



DIN 4: 22 - 26 s at 20°C (sanding surfacer)
14 - 16 s at 20°C (non sanding surfacer)



60 - 80 µm per coat (sanding surfacer)
30 - 40 µm per coat (non sanding surfacer)

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Theoretical coverage

450 - 460 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.



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 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%.
- Sanding surfacer- for spot, panel and overall repair.
- Close can of Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Do not use activated P702 beyond the pot life nor reduce it further to get viscosity down again.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paper filling.
- For Semi-Flexible systems 10% 805R Flexible Additive can be added to the base material. Activator and Thinner ratios remain equal.

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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