

P7

IMRON® FLEET LINE PRIMEPOX



PRODUCT DESCRIPTION

Imron Fleet Line Primepox Off White P7 is a 2K epoxy primer-surfacer. It is chromate-free and offers very good resistance to corrosion, humidity and chemicals. Imron Fleet Line Primepox is suitable for use over many different substrates.

Excellent ValueShade

FEATURES

- 01 Good filling properties, excellent over-spray melt-in and good topcoat hold-out.
- 02 Extremely versatile.
- 03 Helps to increase productivity.
- 04 Ideally suited for large surface application.
- 05 Offers excellent corrosion, humidity and chemical resistance.
- 06 Part of the ValueShade concept.
- 07 No filling primer needed.
- 08 Suitable for use over a wide range of substrates.

TECHNICAL DATA SHEET



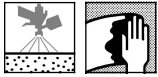
P7

IMRON® FLEET LINE PRIMEPOX

Product preparation - application STANDARD 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
Stainless steel, sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Coil coated, sanded and cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Sandblasted steel (SA 2.5)



| | VS1 | VS2 | VS3 | VS4 | VS5 | VS6 | VS7 |
|--------------|-----|-----|-----|-----|-----|-----|-----|
| P7 | - | 100 | 100 | - | 100 | - | - |
| P7W | 100 | - | - | - | - | - | - |
| PT105 | - | - | 1.5 | 6.5 | 10 | - | - |

| | Standard | | | | Large surface | | | |
|-----------------|----------|--------|--------|--------|---------------|--------|--------|--------|
| | Volume | Weight | Volume | Weight | Volume | Weight | Volume | Weight |
| P7 / P7W | 5 | 100 | 5 | 100 | 5 | 100 | 5 | 100 |
| P73* | - | - | 1 | 11 | - | - | 1 | 11 |
| P72* | 1 | 11 | - | - | 1 | 11 | - | - |
| THP710 | 1 | 11 | 1,4 | 14 | - | - | - | - |
| THP711 | - | - | - | - | 1 | 11 | 1,4 | 14 |

* Spray Viscosity DIN4: 20-26 seconds



at 20°C: 4 hr - 8 hr



| | Spray nozzle | Spray pressure | |
|----------------------|--------------|----------------|----------------------|
| Compliant | 1.4 - 1.8 | 2 - 2.5 bar | inlet pressure |
| HVLP | 1.4 - 1.8 | 0.7 bar | atomisation pressure |
| Membrane pump | 1.1 | 2.5 - 3 bar | atomisation pressure |
| Membrane pump | 1.1 | 0.8 - 1.8 bar | material pressure |
| Airmix | 0.28 - 0.33 | 50 - 120 bar | material pressure |

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 10 min - 15 min
before bake: 1 hr



| | P73 | P72 |
|-------------------|---------------|--------------------|
| 20 °C | 12 hr - 16 hr | 1 day - 1 day 6 hr |
| 60 - 65 °C | 35 min | 45 min |



P360 - P400



Imron Fleet Line 2K Topcoats or Surfacer

VOC compliant

2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

TECHNICAL DATA SHEET



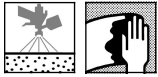
P7

IMRON® FLEET LINE PRIMEPOX

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
Stainless steel, sanded and cleaned
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.
Coil coated, sanded and cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



| | VS1 | VS2 | VS3 | VS4 | VS5 | VS6 | VS7 |
|-------|-----|-----|-----|-----|-----|-----|-----|
| P7 | - | 100 | 100 | - | 100 | - | - |
| P7W | 100 | - | - | - | - | - | - |
| PT105 | - | - | 1.5 | - | 6.5 | 10 | - |

| | Standard | | | | Large surface | | | |
|----------|----------|--------|--------|--------|---------------|--------|--------|--------|
| | Volume | Weight | Volume | Weight | Volume | Weight | Volume | Weight |
| P7 / P7W | 5 | 100 | 5 | 100 | 5 | 100 | 5 | 100 |
| P73* | | | 1 | 11 | - | - | 1 | 11 |
| P72* | 1 | 11 | - | - | 1 | 11 | - | - |
| THP710 | 1,6 | 16 | 1,8 | 19 | - | - | - | - |
| THP711 | - | - | - | - | 1,6 | 16 | 1,8 | 19 |

* Spray Viscosity DIN4: 18-20 seconds



at 20°C: 4 hr - 8 hr



| | Spray nozzle | Spray pressure | |
|---------------|--------------|----------------|----------------------|
| Compliant | 1.4 - 1.8 | 2 - 2.5 bar | inlet pressure |
| HVLP | 1.4 - 1.8 | 0.7 bar | atomisation pressure |
| Membrane pump | 1.1 | 2.5 - 3 bar | atomisation pressure |
| Membrane pump | 1.1 | 0.8 - 1.8 bar | material pressure |
| Airmix | 0.28 - 0.33 | 50 - 120 bar | material pressure |

see manufacturer's instructions



| | Primer | Primer-surfacer |
|---------|----------------------------------|---|
| 1 coats | final flash-off: 15 min - 20 min | 1 - 2 coats with intermediate flash-off: 5 min - 10 min final flash-off: 30 min - 1 hr |
| | | 2K Surfacer 30 min - 3 days |
| | | IFL Topcoats 1hr - 3 days |



| 20 °C | P72 / P73 |
|-------|-----------------|
| | 45 min - 3 days |



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

VOC compliant

2004/42/IIB(C)(540) 540: The EU limit value for this product (product category: IIB(C)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

P7

IMRON® FLEET LINE PRIMEPOX

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.

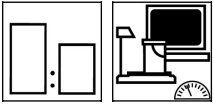
Products

P7 Imron® Fleet Line Primepox - VS2
P7W Imron® Fleet Line Primepox - VS1
PT105 Imron® Fleet Line PowerTint® Jet Black

P72 Imron® Fleet Line Epoxy Activator
P73 Imron® Fleet Line Epoxy Activator Fast

THP710 Imron® Fleet Line Thinner Standard
THP711 Imron® Fleet Line Thinner Slow

Product mix



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



50 - 80 µm

Theoretical coverage

370 - 380 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 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.
- Can not be applied over acid containing primers.
- Polyester putties can be applied over cured and sanded epoxy primer-surfacers.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- Mix thoroughly by hand before placing the can on mixing machine.
- P7 can be re-coated within 72 hours, without intermediate sanding.
- P7 can be re-coated with Centari 600 or 6000 basecoats activated with 10% BK220 by volume.

TECHNICAL DATA SHEET



P7

IMRON® FLEET LINE PRIMEPOX

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