



P60 (Passenger Car use)

PAGE 2

P60 (Commercial Vehicle use)

PAGE 6

P60 (Passenger Car)

27.08.2014

ADHESION PROMOTOR

DESCRIPTION

2K Low Emission polyurethane non-sanding adhesion promotor for solvent based basecoats and 2K Topcoats.
Composition based on hydroxylated acrylic copolymers.

PRODUCTS

P60	Adhesion Promotor
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
XB383	Standard Thinner
XB387	HI-Temp Thinner
431R	Varispeed Ultra

PROPERTIES

Can be used as:

- adhesion promotor for solvent based basecoats and 2K Topcoats;
- multi-toning promotor for 2K topcoats.

VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES

- OEM finishes, including thermoplastic acrylic finishes.
- Cured repair finishes.
- Undercoats.

TECHNICAL DATA SHEET



P60

27.08.2014

ADHESION PROMOTOR

PRODUCT PREPARATION

	Mixing ratio	Multi-toning			
		P60 XK203/XK205/XK206 431R	Volume	Weight	
		Adhesion Promotor / Sealer	P60 XK203/XK205/XK206 431R/XB383/XB387	Volume	Weight
				4 1 1.75	100 19 28
	VOC	540 g/l			
	Pot life at 20°C	430R/431R	1 hr 30 min		
		XB383/XB387	3-4 hr		
	Spray viscosity at 20°C	DIN 4 FORD 4	16-18 s 16-18 s		
	Spray equipment	Compliant guns	Fluid tip	Distance	Pressure
			Gravity feed	1.2-1.4 mm	
		Suction feed	1.4-1.6 mm	15 cm	
		Pressure feed	1.0-1.2 mm	15 cm	
Conventional guns	Gravity feed	1.2-1.5 mm	20-25 cm	2-2.5 bar	
	Suction feed	1.4-1.8 mm	20-25 cm	2-2.5bar	
	Pressure feed	1.0-1.2 mm	20-25 cm	2-2.5 bar	
	Number of coats	1-2			
	Flash time	5-10 min between coats. 30-60 min before recoating with solvent based basecoats and 2K Topcoats.			
	DFT	15-20 µm/coat			

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.

P60

27.08.2014

ADHESION PROMOTOR

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:
 - a. mechanical with P280 - P320
 - b. wet with P600 - P800.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.
5717S is not recommended if polyester putty is required.
- Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
- Apply 1 coat of wash primer.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

P60

27.08.2014

ADHESION PROMOTOR

REMARKS

- P60 is tintable with the AM Centari® MasterTints® up to maximum 5 %.
- Do not use activated P60 beyond the pot life nor reduce it further to get viscosity down again.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity:	1000 cp
Theoretical coverage:	15-30 m ² /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	2004/42/IIIB(c)(540)540: The EU limit value for this product (product category: IIIB(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.

SAFETY

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

All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, 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.

P60 (Commercial Vehicle)

7.05.2015

ADHESION PROMOTOR

DESCRIPTION

2K Low Emission polyurethane non-sanding adhesion promotor for Imron® Fleet Line 2K topcoats. Composition based on hydroxylated acrylic copolymers

PRODUCTS

P60	Adhesion Promotor
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET740	Accelerator
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow

PROPERTIES

Can be used as:

- adhesion promotor and sealer for Imron® Fleet Line 2K topcoats;
- multi-toning promotor for Imron® Fleet Line 2K topcoats.

VOC compliant, conforms to directive 2004/42/EC.

SUBSTRATES

- OEM finishes, including thermoplastic acrylic finishes.
- Cured repair finishes.
- Imron® Fleet Line undercoats

TECHNICAL DATA SHEET



P60

7.05.2015

ADHESION PROMOTOR

PRODUCT PREPARATION

	Mixing ratio	Multi-toning	Volume		Weight
		P60	4	100	
		ET645/ET650/ET655	1	19	
		ET740	1.75	28	
		Adhesion Promotor / Sealer	Volume		Weight
		P60	4	100	
		ET645/ET650/ET655	1	19	
		ET740/ET745/ET750/ET755	1.75	28	
	VOC	540 g/l			
	Pot life at 20°C	430R/431R XB383/XB387	1 hr 30 min 3-4 hr		
	Spray viscosity at 20°C	DIN 4 FORD 4	16-18 s 16-18 s		
	Spray equipment	Compliant guns	Fluid tip	Distance	Pressure
		Gravity feed	1.2-1.4 mm	15 cm	According to supplier's specifications
		Suction feed	1.4-1.6 mm	15 cm	
		Pressure feed	1.0-1.2 mm	15 cm	
		Conventional guns			
		Gravity feed	1.2-1.5 mm	20-25 cm	2-2.5 bar
Suction feed	1.4-1.8 mm	20-25 cm	2-2.5bar		
Pressure feed	1.0-1.2 mm	20-25 cm	2-2.5 bar		
	Number of coats	1-2			
	Flash time	5-10 min between coats. 30-60 min before recoating with Imron® Fleet Line 2K topcoats			
	DFT	15-20 µm/coat			
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P60

7.05.2015

ADHESION PROMOTOR

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:
 - a. mechanical with P280 - P320
 - b. wet with P600 - P800.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.
5717S is not recommended if polyester putty is required.
- Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
- Apply 1 coat of Imron[®] Fleet Line wash primer

EQUIPMENT CLEANING

Use Duxone[®] 1K Multi Acrylic Thinner

REMARKS

- P60 is tintable with the PT Imron[®] PowerTints[®] up to maximum 5 %
- Do not use activated P60 beyond the pot life nor reduce it further to get viscosity down again.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity:	1000 cp
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P60

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ADHESION PROMOTOR

SAFETY

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