

# 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. Ideally suited for large surface application.
- 04** Offers excellent corrosion, humidity and chemical resistance.
- 05** Part of the ValueShade concept.
- 06** No filling primer needed.
- 07** Suitable for use over a wide range of substrates.

# TECHNICAL DATA SHEET

**P7 - P7W**



## 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 fiber 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	-	-
P7W	100	-	-	-	-	-	-
PT105	-	-	-	-	1.5	-	-

	Standard		Large surface	
	Volume	Weight	Volume	Weight
P7 / P7W	5	100	5	100
P72	1	11	1	11
THP710	1	11	-	-
THP711	-	-	1	11

Spray Viscosity DIN4: 20-26 seconds

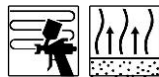


at 20°C:  
P72: 8 hr



	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



Drying temperature	P72
20 °C	1 day - 1 day 6 hr
60 - 65 °C	45 min



P320 - P400



Imron Fleet Line 2K Topcoats or 2K 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 - P7W**



## 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 fiber 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	-	-
P7W	100	-	-	-	-	-	-
PT105	-	-	-	-	1.5	-	-

	Standard		Large surface	
	Volume	Weight	Volume	Weight
P7 / P7W	5	100	5	100
P72	1	11	1	11
THP710	2	21	-	-
THP711	-	-	2	21

Spray Viscosity DIN4: 18-20 seconds



at 20°C:  
P72: 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

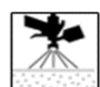
see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	Minimum final flash-off: 15 - 20 minutes.	1 - 2 coats	with intermediate flash-off: 5 min - 10 min final flash-off: 30 min - 1 hr
			2K surfacers 30 minutes - 3 days
			IFL topcoats 1 hr - 3 days



	P72
20 °C	45 min - 3 days



Primer	Primer-surfacer
Imron Fleet Line 2K Surfacers	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.

Sensitivity: Business Internal

SYSTEMS BRAND

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This Technical Data Sheet supersedes all previous issues

# TECHNICAL DATA SHEET

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## 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

P72 Imron® Fleet Line Epoxy Activator

THP710 Imron® Fleet Line Thinner Standard

THP711 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.



15-25 µm/coat wet on wet

30-40 µm/coat as a sanding primer

### Theoretical coverage

370 - 380 m<sup>2</sup>/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

**P7 - P7W**



## IMRON® FLEET LINE PRIMEPOX



Clean after use with AXT350 Axalta 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%.
- Cannot 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.
- 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.

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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