

P500

IMRON® FLEET LINE

2K VERY HIGH BUILD PRIMER-SURFACER



PRODUCT DESCRIPTION

Imron Fleet Line 2K Very High Build Primer-Surfacer P500 is a 2K Primer based on polyacrylic that is very high in solids and has been specially developed for the commercial vehicles sector, the ACE segment and general industry.

FEATURES

- 01 Features fast drying times.
- 02 Can be used as Primer-Surfacer or Surfacer.
- 03 Low in VOCs and high in solids.

TECHNICAL DATA SHEET

P500

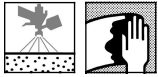


IMRON® FLEET LINE 2K VERY HIGH BUILD PRIMER-SURFACER

Product preparation - application STANDARD SANDING



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



Old or original paintwork well sanded and cleaned.
Bare steel sanded and cleaned
Sandblasted steel (SA 2.5)
Stainless steel and Aluminium profiles, sanded, cleaned and coated with Wash Primer.
Surfaces must be prepared and cleaned correctly before application
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



	2K Mixing Machine		
P500	5		
ET620	1		
ET745/ET750/ET755	0,3-0,6		
	Small surface	Standard	Large surface
P500	8	8	8
ET645	1	-	-
ET650	-	1	-
ET655	-	-	1
ET745/ET750/ET755	1-2	1-2	1-2



Activated: 2 hr - 3 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 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

with intermediate flash-off: 10 min - 15 min
before bake: 15 min - 20 min



	ET620/ET645/ET650/ET655
20 - 25 °C	12 hr - 16 hr
50 - 60 °C	30 min - 45 min



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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.

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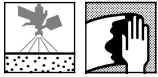


IMRON® FLEET LINE 2K VERY HIGH BUILD PRIMER-SURFACER

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.



Old or original paintwork well sanded and cleaned.
Bare steel sanded and cleaned
Sandblasted steel (SA 2.5)
Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer
Surfaces must be prepared and cleaned correctly before application
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



	2K Mixing Machine		
P500	5		
ET620	1		
ET745/ET750/ET755	0,3-0,6		
	Small surface	Standard	Large surface
P500	8	8	8
ET645	1	-	-
ET650	-	1	-
ET655	-	-	1
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Activated: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
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HVLP	1.4 - 1.8	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

with intermediate flash-off: 10 min - 15 min
final flash-off: 30 min - 1 hr



	ET620/ET645/ET650/ET655
20 - 25 °C	30 min - 45 min



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IMRON® FLEET LINE 2K VERY HIGH BUILD PRIMER-SURFACER

Products

P500 Imron® Fleet Line 2K Very High Build Primer-Surfacer

ET620 Imron® Fleet Line Activator

ET645 Imron® Fleet Line Activator HS Fast

ET650 Imron® Fleet Line Activator HS

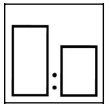
ET655 Imron® Fleet Line Activator HS Slow

ET745 Imron® Fleet Line Thinner Fast

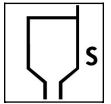
ET750 Imron® Fleet Line Thinner

ET755 Imron® Fleet Line Thinner Slow

Product mix



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



DIN 4: 24 - 35 s at 20°C



40 - 80 µm

Theoretical coverage

320 - 330 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 a suitable solventbased cleaning thinner.

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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.
- The Primer Surfacer can be overcoated within 1 month without sanding, only cleaning of the surface is necessary.
- A wet on wet application with Epoxy topcoat is not possible.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- Dry film thickness up to 300µm can be achieved. Extended flash-off time is required between coats.
- Mix thoroughly by hand before placing the can on mixing machine.
- Surfacer is tintable up to 10% with Imron Fleet Line mixing tints or up to 20% with Imron Fleet Line Topcoat. Drying and sanding can be affected.
- 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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