

P601 - P602 - P607

IMRON® FLEET LINE

DTM PRIMER-SURFACER



PRODUCT DESCRIPTION

Imron Fleet Line DTM Non-Sanding Primer-Surfacer P60x is an extremely versatile non-sanding primer-surfacer that eliminates the need for a two-stage build-up, which helps to boost productivity within the commercial vehicle refinish process. It can be applied directly over a wide range of metal. It is suitable for all topcoats from Imron Fleet Line and Cromax basecoats.

Universal CV primer surfacer that boosts productivity.

FEATURES

- 01** Helps to boost productivity.
- 02** Can be applied directly to metal.
- 03** Offers a wide application window.
- 04** Can be used on common plastics without adhesion promoter.
- 05** Part of the ValueShade concept.
- 06** VOC compliant



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

TECHNICAL DATA SHEET

P601 - P602 - P607

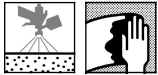


IMRON® FLEET LINE DTM PRIMER-SURFACER

Product preparation - application STANDARD SANDING



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



Galvanised steel or aluminium, sanded and cleaned
Bare steel sanded and cleaned
Stainless steel, sanded and cleaned
Aluminium profiles, sanded, cleaned and coated with Wash Primer.
Different Plastic Types: ABS, PC and GRP sanded and cleaned.
Sandblasted steel (SA 2.5)
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



| | VS1 | VS2 | VS3 | VS4 | VS5 | VS6 | VS7 |
|------|-----|-----|-----|-----|-----|-----|-----|
| P601 | 100 | - | - | - | - | - | - |
| P602 | - | 100 | 90 | 75 | 45 | 20 | - |
| P607 | - | - | 10 | 25 | 55 | 80 | 100 |

| | 2k mixing machine | | Small surface | | Standard | | Large surface | |
|-----------------------|-------------------|--------|---------------|--------|----------|--------|---------------|--------|
| | Volume | Weight | Volume | Weight | Volume | Weight | Volume | Weight |
| P601 / P602 / P607 | 3 | 100 | 5 | 100 | 5 | 100 | 5 | 100 |
| ET620 * | 1 | 22 | - | - | - | - | - | - |
| ET645 | - | - | 1 | 14 | - | - | - | - |
| ET650 | - | - | - | - | 1 | 14 | - | - |
| ET655 | - | - | - | - | - | - | 1 | 14 |
| ET745 / ET750 | - | - | 0 - 0.6 | 0 - 7 | - | - | - | - |
| ET745 / ET750 / ET755 | - | - | - | - | 0 - 0.6 | 0 - 6 | - | - |
| ET750 / ET755 | - | - | - | - | - | - | 0 - 0.6 | 0 - 7 |

* 20 - 25 sec with ET620

** 25 - 35 sec



Pot life at 20°C: 2 hr - 3 hr



| | Spray nozzle | Spray pressure | |
|---------------|--------------|----------------|----------------------|
| Compliant | 1.4 - 1.6 | 2 - 2.5 bar | inlet pressure |
| HVLP | 1.4 - 1.6 | 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



2 - 3 closed coats.

with intermediate flash-off: 15 min - 30 min
before bake: 15 min - 30 min



| 20 - 25 °C | 12 hr - 16 hr | - |
|------------|-----------------|---|
| 50 - 60 °C | 30 min - 45 min | - |



P360 - P500



Imron Fleet Line 2K Topcoats
Cromax Pro Basecoat / Cromax Basecoat + Clearcoat

VOC compliant

2004/42/IB(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

P601 - P602 - P607

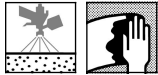


IMRON® FLEET LINE DTM PRIMER-SURFACER

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.



Galvanised steel or aluminium, sanded and cleaned
Bare steel sanded and cleaned
Stainless steel, sanded and cleaned
Aluminium profiles, sanded, cleaned and coated with Wash Primer.
Different Plastic Types: ABS, PC and GRP sanded and cleaned.
Sandblasted steel (SA 2.5)
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



| | VS1 | VS2 | VS3 | VS4 | VS5 | VS6 | VS7 |
|------|-----|-----|-----|-----|-----|-----|-----|
| P601 | 100 | - | - | - | - | - | - |
| P602 | - | 100 | 90 | 75 | 45 | 20 | - |
| P607 | - | - | 10 | 25 | 55 | 80 | 100 |

| | 2k mixing machine | | Small surface | | Standard | | Large surface | |
|-----------------------|-------------------|--------|---------------|--------|-----------|--------|---------------|--------|
| | Volume | Weight | Volume | Weight | Volume | Weight | Volume | Weight |
| P601 / P602 / P607 | 3 | 100 | 5 | 100 | 5 | 100 | 5 | 100 |
| ET620 * | 1 | 22 | - | - | - | - | - | - |
| ET645 | - | - | 1 | 14 | - | - | - | - |
| ET650 | - | - | - | - | 1 | 14 | - | - |
| ET655 | - | - | - | - | - | - | 1 | 14 |
| ET745 / ET750 | - | - | 0.6 - 0.9 | 7 - 11 | - | - | - | - |
| ET745 / ET750 / ET755 | 0 - 0.2 | 0 - 4 | - | - | 0.6 - 0.9 | 7 - 11 | - | - |
| ET750 / ET755 | - | - | - | - | - | - | 0.6 - 0.9 | 7 - 11 |

* 19 - 23 sec



Pot life at 20°C: 2 hr - 3 hr



| | Spray nozzle | Spray pressure | |
|---------------|--------------|----------------|----------------------|
| Compliant | 1.4 - 1.6 | 2 - 2.5 bar | inlet pressure |
| HVLP | 1.4 - 1.6 | 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: 15 min - 30 min
final flash-off: 30 min - 1 hr



Imron Fleet Line 2K Topcoats
Cromax Pro Basecoat / Cromax Basecoat + Clearcoat

VOC compliant

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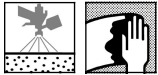


IMRON® FLEET LINE DTM PRIMER-SURFACER

Product preparation - application STANDARD PLASTIC



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



Repairs to exterior common plastic car parts, sanded and cleaned.
New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in 3930SA Multi-Purpose Degreaser / final cleaning use a cloth moistened with 3930SA Multi-Purpose Degreaser.
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth.
Change cloths often, never use dirty cloths.



| | VS1 | VS2 | VS3 | VS4 | VS5 | VS6 | VS7 |
|------|-----|-----|-----|-----|-----|-----|-----|
| P601 | 100 | - | - | - | - | - | - |
| P602 | - | 100 | 90 | 75 | 45 | 20 | - |
| P607 | - | - | 10 | 25 | 55 | 80 | 100 |

| | Small surface | | Standard | | Large surface | | Standard | |
|--------------------|---------------|--------|----------|--------|---------------|--------|----------|--------|
| | Volume | Weight | Volume | Weight | Volume | Weight | Volume | Weight |
| P601 / P602 / P607 | 5 | 100 | 5 | 100 | 5 | 100 | - | - |
| P602 / P607 | - | - | - | - | - | - | 5 | 100 |
| ET645 * | 1 | 14 | - | - | - | - | - | - |
| ET650 | - | - | 1 | 14 | - | - | 1 | 14 |
| ET655 | - | - | - | - | 1 | 14 | - | - |
| AZ9700 | 1.8 | 21 | 1.8 | 21 | 1.8 | 21 | 1.8 | 21 |

* 20 - 23 sec



Pot life at 20°C: 2 hr - 3 hr



| | Spray nozzle | Spray pressure | |
|---------------|--------------|----------------|----------------------|
| Compliant | 1.3 - 1.4 | 2 - 2.5 bar | inlet pressure |
| HVLP | 1.3 - 1.4 | 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 |

see manufacturer's instructions



1 - 2 closed coats.

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



Elastified 2K Topcoat
Cromax Pro Basecoat / Cromax Basecoat + Elastified Clearcoat

VOC compliant

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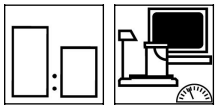
Products

P601 Imron® Fleet Line DTM Primer-Surfacer - VS1
P602 Imron® Fleet Line DTM Primer-Surfacer - VS2
P607 Imron® Fleet Line DTM Primer-Surfacer - VS7

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

AZ9700 Ultra Performance Plastic Additive
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.



60 - 150 µm

Theoretical coverage

496 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.

Remarks

- Mix thoroughly by hand before placing the can on mixing machine.
- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- A wet on wet application with Epoxy topcoat is not possible.
- The Primer Surfacer can be overcoated with 2K topcoat within 1 month without sanding, only cleaning of the surface is necessary.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- In countries without VOC legislation Centari 6000 Basecoat can be used as well.

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IMRON® FLEET LINE DTM PRIMER-SURFACER

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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