

# P400

## IMRON® FLEET LINE CHROMATE FREE HB PRIMER-SURFACER



### PRODUCT DESCRIPTION

Imron Fleet Line Chromate-Free HB Primer-Surfacer P400 Grey has been formulated to provide anti-corrosion properties as well as promoting adhesion to various metals. It is a 2K, chromate-free, environmentally-responsible and user-friendly primer-surfacer that can be applied airless or electrostatically.

### FEATURES

- 01 Offers easy application and excellent sagging resistance.
- 02 Can be coated with all Imron Fleet Line 2K topcoats.
- 03 Suitable for airless and electrostatic application.

# TECHNICAL DATA SHEET

## P400



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#### 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  
Coil coated, sanded and cleaned  
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.  
Old or original paintwork well sanded and cleaned.  
Sandblasted steel (SA 2.5)



	Small surface		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
<b>P400</b>	10	100	10	100	10	100
<b>ET645</b>	1	7	-	-	-	-
<b>ET650</b>	-	-	1	7	-	-
<b>ET655</b>	-	-	-	-	1	7
<b>ET745</b>	2	16	-	-	-	-
<b>ET750</b>	-	-	2	17	-	-
<b>ET755</b>	-	-	-	-	2	17



Pot life at 20°C: 8 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.5 - 1.8	2 - 2.5 bar	atomisation pressure
<b>HVLP</b>	1.3 - 1.5	0.7 bar	inlet pressure
<b>Membrane pump</b>	1.1	2.5 - 3 bar	atomisation pressure
<b>Membrane pump</b>	1.1	0.8 - 1.2 bar	material pressure
<b>Airmix</b>	0.28 - 0.33	90 - 120 bar	material pressure

see manufacturer's instructions



1 - 3 coats

final flash-off: 1 hr - 3 hr



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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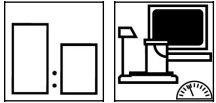
### Products

P400 Imron® Fleet Line Chromate Free HB Primer-Surfacer

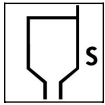
ET645 Imron® Fleet Line Activator HS Fast  
ET650 Imron® Fleet Line Activator HS  
ET655 Imron® Fleet Line Activator HS Slow

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: 20 - 30 s at 20°C



40 - 120 µm

#### Theoretical coverage

390 - 400 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.



Clean after use with a suitable solventbased guncleaner.

### 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.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- 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.
- Do not overcoat Imron Fleet Line Chromate Free HB Primer-Surfacer with Cromax Basecoat or Cromax Pro Basecoat

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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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