

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

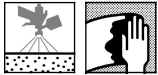


IMRON® FLEET LINE DTM PRIMER-SURFACER

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

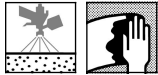


IMRON® FLEET LINE DTM PRIMER-SURFACER

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

2004/42/IIIB(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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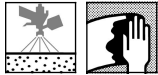


IMRON® FLEET LINE DTM PRIMER-SURFACER

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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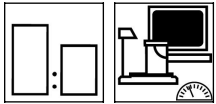
Products

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 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.

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.