

P702 - P706

IMRON® FLEET LINE HIGH SOLIDS SURFACER



PRODUCT DESCRIPTION

Imron Fleet Line High Solids Surfacers Off White P702 / Dark Grey P706 is a 2K high-solids surfacer with excellent filling properties, which provide very good isolation and defect rectification.

Excellent ValueShade



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

FEATURES

- 01** Has low VOC content, very high solids technology that offers better filling.
- 02** Can be coated with all Imron Fleet Line topcoats.
- 03** Provides the same build with fewer coats, resulting in reduced consumption.
- 04** Offers excellence in mechanical and wet sanding.
- 05** Delivers superior topcoat hold-out.

TECHNICAL DATA SHEET

P702 - P706

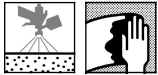


IMRON® FLEET LINE HIGH SOLIDS SURFACER

Product preparation - application STANDARD SANDING



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer
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.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.



M-6155

	VS2	VS3	VS4	VS5	VS6
P702	100	50	65	-	-
P704	-	50	-	50	-
P706	-	-	35	50	100

	Small surface		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
P702 / P704 / P706	7	100	7	100	7	100
ET645	1	10	-	-	-	-
ET650	-	-	1	10	-	-
ET655	-	-	-	-	1	10
ET745 / ET750	1	8	-	-	-	-
ET745 / ET750 / ET755	-	-	1	9	-	-
ET750 / ET755	-	-	-	-	1	4



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	atomisation pressure
HVLP	1.4 - 1.6	0.7 bar	inlet pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.2 - 0.3	90 - 120 bar	material pressure

see manufacturer's instructions



1 - 3 coats

intermediate flash-off until matt
final flash-off: 10 min - 15 min



	ET645	ET650	ET655
20 °C	3 hr - 4 hr	3 hr - 4 hr	4 hr - 6 hr
60 - 65 °C	20 min	20 min - 30 min	30 min - 40 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 15 - 20 min



Imron Fleet Line 2K Topcoats

VOC compliant

2004/42/IIB(c)(540) 515: 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 515 g/l.

TECHNICAL DATA SHEET

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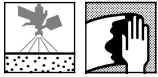


IMRON® FLEET LINE HIGH SOLIDS SURFACER

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.



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer
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.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.



	VS2	VS3	VS4	VS5	VS6
P702	100	50	65	-	-
P704	-	50	-	50	-
P706	-	-	35	50	100

	Spot & panel repair		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
P702 / P704 / P706	4	100	4	100	4	100
ET645 **/ ET650 *	1	18	-	-	-	-
ET650	-	-	1	18	-	-
ET655	-	-	-	-	1	18
LE2031 / LE2035	3	46	-	-	-	-
LE2035	-	-	3	45	3	46

* NS WITH CONVERTOR FOR CENTARI

** NS FOR SPOT AND PANEL REPAIR



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	atomisation pressure
HVLP	1.4 - 1.6	0.7 bar	inlet pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.2 - 0.3	90 - 120 bar	material pressure

see manufacturer's instructions



1 - 3 coats

intermediate flash-off until matt
final flash-off: 30 min - 1 hr



Guideline for short wave IR equipment
Half power: 5 min
Full power: 15 - 20 min



Imron Fleet Line 2K Topcoats

VOC compliant

2004/42/IIB(c)(540) 515: 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 515 g/l.

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IMRON® FLEET LINE HIGH SOLIDS SURFACER

Products

IMRON FLEET LINE HS SURFACER - VS4
P702 Imron® Fleet Line High Solids Surfacers - VS2
P706 Imron® Fleet Line High Solids Surfacers - VS6

805R Flexible Additive

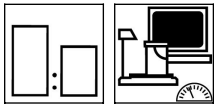
CROMAX NON-SANDING CONVERTOR
ET645 Imron® Fleet Line Activator HS Fast
ET650 Imron® Fleet Line Activator HS
ET655 Imron® Fleet Line Activator HS Slow
LE2035 Non-Sanding Convertor Large Surface

805R Flexible Additive

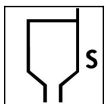
ET645 Imron® Fleet Line Activator HS Fast
ET650 Imron® Fleet Line Activator HS
ET655 Imron® Fleet Line Activator HS Slow

CROMAX NON-SANDING CONVERTOR
ET745 Imron® Fleet Line Thinner Fast
ET750 Imron® Fleet Line Thinner
ET755 Imron® Fleet Line Thinner Slow
LE2031 Centari® Non-Sanding Convertor
LE2035 Non-Sanding Convertor Large Surface
NON-SANDING CONVERTOR

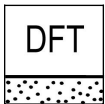
Product mix



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



DIN 4: 22 - 26 s at 20°C



60 - 80 µm per coat

Theoretical coverage

450 - 460 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 guncleaner.

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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.
- Mix thoroughly by hand before placing the can on mixing machine.
- Close can of Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- 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.

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.