

P742 - P746

IMRON® FLEET LINE HS SANDING SURFACER



PRODUCT DESCRIPTION

Imron Fleet Line Sanding Surfacers P742 VS2 / P746 VS6 is the ideal 2K undercoat for Imron Fleet Line topcoats. It delivers a smooth and durable surface and can be mixed for a wide range of ambient temperatures and application windows.



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

FEATURES

- 01 Excellent filling power.
- 02 Very good sanding.
- 03 Ideally suited for heavy-duty truck and trailer repairs.
- 04 Delivers superior topcoat hold-out.
- 05 Suitable for tinting with Imron Fleet Line PowerTints, up to maximum 10 % by weight.

TECHNICAL DATA SHEET



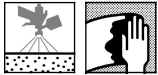
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Product preparation - application STANDARD SANDING



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.



	VS2	VS3	VS4	VS5	VS6
P742	100	93	75	50	-
P746	-	7	25	50	100

	Small surface		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight
P742 / P746	8	100	8	100	8	100
ET645	1	9	-	-	-	-
ET650	-	-	1	9	-	-
ET655	-	-	-	-	1	9
ET745 / ET750	1	8	-	-	-	-
ET745 / ET750 / ET755	-	-	1	8	-	-
ET750 / ET755	-	-	-	-	1	8



at 20°C: 1 hr - 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	2 - 2.5 bar	inlet pressure
HVLP	1.5 - 1.9	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min
before bake: 10 min - 15 min



	ET645 / ET650 / 655
20 °C	12 hr - 16 hr
60 - 65 °C	45 min - 1 hr



P360 - P500



Imron Fleet Line 2K Topcoats
Basecoat

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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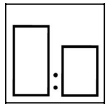
Products

P742 Imron® Fleet Line HS Sanding Surfacers VS2
P746 Imron® Fleet Line HS Sanding Surfacers VS6

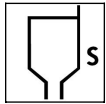
ET645 Imron® Fleet Line Activator HS Fast
ET650 Imron® Fleet Line Activator HS
ET655 Imron® Fleet Line Activator HS Slow

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: 22 - 26 s at 20°C



100 - 120 µm

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 cleaning thinner.

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.
- Surfacers are 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.

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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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