

P7W/P7/P7B

01.11.2014

IMRON® FLEET LINE PRIMEPOX

DESCRIPTION

2-component chromate-free epoxy primer-surfacer.
Colour: white, off white, black
Composition based on epoxy/polyamide resin.

PRODUCTS

P7W	Primepox – white
P7	Primepox – off white
P7B	Primepox - black
P72	Epoxy Activator
THP710	Thinner Standard
THP711	Thinner Slow

PROPERTIES

- Very good corrosion and chemical resistance.
- Excellent adhesion on properly treated metal substrates.
- Recommended as a 1st coat over new metal constructions e.g. buses, trucks and vehicles.
- Very good filling properties. Suitable for use over rough substrates e.g. gritblasted metals.
- Compliant with RVI specifications.
- High humidity resistance and good flexibility.
- Shop primer.
- Part of ValueShade® concept.
- P7 can be tinted with PT PowerTints® (up to max.10 % by weight).
- Can be coated with all Imron® Fleet Line 2K surfacers or Imron® Fleet Line topcoats.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES

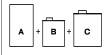









- Bare metals: steel, aluminium and galvanised steel.
- OEM finishes.
- Cured repair finishes.
- Polyester putties.

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PRODUCT PREPARATION

  M-6154 Mixing ratio	Mixing ratio ValueShade®	P7W	P7B	P7	P7B
	ValueShade® 1	100	0	-	-
	ValueShade® 2	95	5	100	0
	ValueShade® 3	85	15	90	10
	ValueShade® 4	60	40	60	40
	ValueShade® 5	25	75	30	70
	ValueShade® 6	5	95	10	90
	ValueShade® 7	0	100	0	100
		Standard		Large surface/High temp.	
		Volume	Weight	Volume	Weight
P7W/P7/P7B		5	100	5	100
P72		1	11	1	11
THP710		1-2	10-20	-	-
THP711		-	-	1-2	10-20
VOC	504-540 g/l				
 Pot life at 20°C	8 hr				
 Spray viscosity at 20°C	DIN 4	5:1:1	5:1:1.5	5:1:2	
	FORD 4	27-33 s	22-24 s	18-20 s	
	AFNOR 4	31-38 s	24-26 s	20-22 s	
		34-42 s	26-28 s	22-24 s	
	It is strongly recommended to use appropriate personal protection equipment during application.				
 Spray equipment	Compliant guns	Fluid tip	Distance	Pressure	
	Gravity feed	1.4-1.6 mm	15 cm	According to supplier's specifications	
	Suction feed	1.5-1.7 mm	15 cm		
	Pressure feed	1.1-1.4 mm	15 cm		
	Conventional guns				
	Gravity feed	1.5-1.7 mm	20-25 cm	3-4 bar	
	Suction feed	1.6-1.8 mm	20-25 cm	3-4 bar	
	Pressure feed	1.1-1.4 mm	20-25 cm	3-4 bar	
 Number of coats	1-2				
 Flash time	Between coats till flat. Before recoating:	minimum	maximum		
	2K surfacers	30 min	3 days		
	topcoats	1 hr	3 days		
DFT	25-30 µ/coat				
 Dry to sand at 20°C at 40°C at 60°C	5 hr 1 hr 45 min				
 IR drying*	Distance	80 cm	* Guideline for short/medium wave IR equipment.		
	Half power	5 min			
	Full power	15-20 min			

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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SURFACE PREPARATION

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
 - a. mechanical with P280 - P320;
 - b. wet with P600.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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REMARKS

- For optimum surface preparation gritblast to Sa 2 ½.
- Activated material should not be returned to original can of non-activated material.
- P7W/P7/P7B can be applied by brush if no reducer is added to the activated material.
- Material has to be stirred well before use.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- A limited number of ValueShades® can also be achieved by mixing P7 with PT105:
ValueShade® 3 (VS3) can be obtained by adding 1.5 g of PT105 to 100 g of P7.
ValueShade® 4 (VS4) can be obtained by adding 6.5 g of PT105 to 100 g of P7.
ValueShade® 5 (VS5) can be obtained by adding 10 g of PT105 to 100 g of P7.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity:	3500-5500 mPas
	White 5:1:1 8,3 m ² /l at 50 µ DFT - ready to spray
	White 5:1:2 7,2 m ² /l at 50 µ DFT - ready to spray
Theoretical coverage:	Off white 5:1:1 8,2 m ² /l at 50 µ DFT - ready to spray
	Off white 5:1:2 7,2 m ² /l at 50 µ DFT - ready to spray
	Black 5:1:1 8,2 m ² /l at 50 µ DFT - ready to spray
	Black 5:1:2 7,2 m ² /l at 50 µ DFT - ready to spray
Directive 2004/42/EC:	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.

SAFETY

This product is classified according to regulation (EC) 1272/2008 (CLP). Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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