

MONO93

27.08.2014

IMRON® FLEET LINE MONOPRIME 93

DESCRIPTION

Vinyl based zinc chromate-free two package wash primer-surfacer.
Composition based on polyvinyl butyral resin.

PRODUCTS

MONO93	Monoprime 93
TH93	Thinner 93

PROPERTIES

- Very good corrosion resistance.
- Very good overspray melting.
- Good filling properties. Used as etching primer-surfacer.
- Excellent etching properties on all ferrous metal and light alloys.
- Can be coated with Imron® Fleet Line 2K surfacers or Imron® Fleet Line 2K topcoats.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES

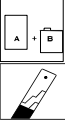






- Bare metals: steel, aluminium and galvanised steel.
 - OEM finishes*.
 - Cured repair finishes.
- * Not recommended for thermoplastic acrylic finishes or under polyester putties.

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PRODUCT PREPARATION

	Mixing ratio	MONO93 TH93	Standard/Pressure feed		Airmix/Airless	
			Volume 1 0.5	Weight 100 40	Volume 1 0-0.35	Weight 100 0-28
	VOC	400-770 g/l				
	Pot life at 20°C	5 days				
	Spray viscosity at 20°C	DIN 4 FORD 4	16-23 s 19-26 s		60-125 s 60-125 s	
	Spray equipment	Compliant guns	Fluid tip	Distance	Pressure	
		Gravity feed Suction feed Pressure feed	1.2-1.4 mm 1.4-1.6 mm 1.0-1.2 mm	15 cm 15 cm 15 cm	According to supplier's specifications	
		Conventional guns				
		Gravity feed Suction feed Pressure feed	1.2-1.5 mm 1.4-1.8 mm 1.0-1.2 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar	
	Number of coats	1-2				
	Flash time	Between coats till flat. 15 min before recoating - till 8 hr maximum.				
	DFT	15-25 µm/coat				
	Dry to sand at 20°C at 40°C at 60°C	1 hr 45 min 30 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 by blowing with 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, by blowing with 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

- Reduced material should not be returned to original can of unreduced material.
- Do not use polyester putty or epoxy primer-surfacer over MONO93. Hardening and adhesion of polyester and epoxy products will be affected.
- Adhesion and flow problems will occur with activated material older than 5 days.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity:	125 s DIN 4 at 20°C
Theoretical coverage:	9 m ² /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 770 g/l.

SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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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