

P702 / P706

27.08.2014

IMRON® FLEET LINE HIGH SOLIDS FILLER

DESCRIPTION

2-component Low Emission sanding surfacer.
Colour: off white, dark grey.
Composition based on a special hydroxy functional acrylic.

PRODUCTS

P702	High Solids Surfacer - off white
P706	High Solids Surfacer - dark grey
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow

PROPERTIES

- Very high solids - low VOC technology: better filling, same build with fewer coats, resulting in less consumption.
- Excellent in mechanical and wet sanding.
- Superior topcoat hold-out.
- Can be coated with all Imron® Fleet Line topcoats.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES

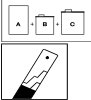







- OEM or cured repair finishes.
- E-coats.
- Sanded polyester putties.
- Imron® Fleet Line wash primers.
- Imron® Fleet Line epoxy primers.

P702 / P706

27.08.2014

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PRODUCT PREPARATION

	Mixing ratio ValueShade®		P702		P706		
	ValueShade® 2 ValueShade® 3 ValueShade® 4 ValueShade® 5 ValueShade® 6		100 85 65 30 0		0 15 35 70 100		
Mixing ratio (1)	P702/P706 ET645 ET650 ET655 ET745 ET750 ET755	Fast		Standard		Slow	
		Volume	Weight	Volume	Weight	Volume	Weight
		7	100	7	100	7	100
		1	10	-	-	-	-
		-	-	1	10	-	-
		-	-	-	-	1	10
		0.5-1	4-8	-	-	-	-
		-	-	0.5-1	4-8	-	-
		-	-	-	-	0.5-1	4-8
VOC		486-507 g/l					
	Pot life at 20°C ET645 ET650 ET655	1 hr - 1 hr 30 min-		- 1 hr 30 min - 2 hr		3-4 hr	
	Spray viscosity at 20°C DIN 4 FORD 4	20-25 s 22-27 s s		20-25 s 22-27 s s		20-25 s 22-27 s s	
	Spray equipment	Fluid tip		Distance		Pressure	
	Compliant guns						
	Gravity feed	1.4-1.6 mm		15 cm		According to supplier's specifications	
	Suction feed	1.6-2.0 mm		15 cm			
	Pressure feed	1.0-1.2 mm		15 cm			
	Conventional guns						
	Gravity feed	1.4-1.8 mm		20-25 cm		3-4 bar	
Suction feed	1.6-2.0 mm		20-25 cm		3-4 bar		
Pressure feed	1.0-1.2 mm		20-25 cm		3-4 bar		
	Number of coats	1-3					
	Flash time	Between coats till flat. 10-15 min before bake.					
DFT		60-80 µm/coat					
	Dry to sand at 20°C at 60°C	ET645		ET650		ET655	
		3-4 hr 20 min		3-4 hr 20-30 min		4-6 hr 30-40 min	
	IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min				
		* Guideline for short/medium wave IR equipment.					

P702 / P706

27.08.2014

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SURFACE PREPARATION

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:
before applying sanding surfacer: mechanical with P220 - P280, wet with P360 - P500
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.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.
5717S is not recommended if polyester putty is required.
- Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
- Apply 1 coat of Imron® Fleet Line wash primer or Imron® Fleet Line epoxy primer.

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

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.
5. Apply 1 coat of Imron® Fleet Line wash primer or Imron® Fleet Line epoxy primer.

APPLICATION SELECTION

Sanding surfacer

For spot, panel and overall repair.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

P702 / P706

27.08.2014

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REMARKS

- Do not use activated P702/P706 beyond the pot life nor reduce it further to get viscosity down again.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity: 2500-3000 cp
Theoretical coverage: 6.1-7 m²/l at recommended DFT - ready-to-spray
Directive 2004/42/EC: 2004/42/II B(c)(540)540 The EU limit value for this product (product category: II B(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 515g/l.

SAFETY

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

P702 / P706

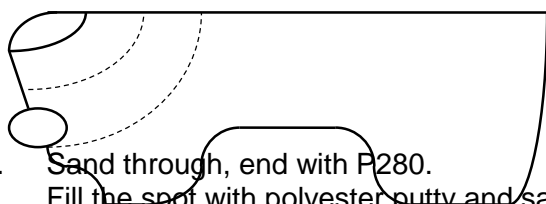
27.08.2014

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PREPARATION METHOD FOR SPOT REPAIR

P280 P320 P360

PE



1. Sand through, end with P280.
2. Fill the spot with polyester putty and sand with P280.
3. Sand the surrounding area with P320 and finish on the OEM finish with P360.
4. Apply 1 coat of Imron® Fleet Line wash primer or Imron® Fleet Line epoxy primer over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1st coat of surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of surfacer, staying inside the 1st coat area. Flash till flat.

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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