



Effective 14 September, 2007

# P504

## FLEET SURFACER

### Description

2-component surfacer, specially developed for non-sanding application. Can also be applied as a sanding surfacer.

Colour: light grey.

Composition based on a special hydroxy functional acrylic.

### Products

P504	Fleet Surfacers
805R	Flexible Additive
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow

### Properties

- Combines a non-sanding and sanding surfacer.
- Provides good filling.
- No convertor is needed for non-sanding application.
- Superior topcoat hold-out.
- Can be coated with all Imron<sup>®</sup> Fleet Line 2K topcoats.
- VOC compliant, conform with directive 2004/42/EC.

### Substrates

- OEM or cured repair finishes.
- E-coats.
- Sanded DuPont Refinish polyester putties.
- Imron<sup>®</sup> Fleet Line wash primers.
- Imron<sup>®</sup> Fleet Line epoxy primers.



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### PRODUCT PREPARATION

	Mixing ratio (1)	Non-sanding surfacer			Sanding surfacer			
		Volume	Weight	Volume	Weight			
	P504 P805 ET645/ET650/ET655 ET745/ET750/ET755	4.5 0.5 1 2.5	93 7 15 31	6 - 1 1.5-2	100 - 12 15-20			
	VOC	540 g/l			490-530 g/l			
	Pot life at 20°C	3 hr			2 hr 30 min - 3 hr			
	Spray viscosity at 20°C	DIN 4 FORD 4			19-24 s 20-25 s			
	Spray equipment	<b>Conventional guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
		Gravity feed Suction feed Pressure feed	1.5-1.6 mm 1.6-1.8 mm 1.1-1.2 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar	1.6-1.8 mm 1.8-2.0 mm 1.2 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar
	Spray equipment	<b>Compliant guns (HVLPH/TE)</b>						
		Gravity feed Suction feed Pressure feed	1.5-1.7 mm 1.6-1.8 mm 1.1 mm	15 cm 15 cm 15 cm	According to supplier's specifications	1.6-1.8 mm 1.8-2.0 mm 1.1-1.2 mm	15 cm 15 cm 15 cm	According to supplier's specifications
	Number of coats	1			2			
	Flash time	30 min (till 8 hr maximum) before recoating.			Between coats till flat. 10-15 min before bake.			
	DFT	20-30 µm			40-55 µm/coat			
	Dry to sand at 20°C at 60°C	Not applicable.			<b>ET645</b>	<b>ET650</b>	<b>ET655</b>	
					4-5 hr 20 min	5-6 hr 20-30 min	O.N. 30-40 min	
	IR drying*	Distance	Not applicable.			80 cm		* Guideline for short/medium wave IR equipment.
		Half power Full power				5 min 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.

(1) The different activators and thinners can be intermixed to obtain the best possible system for the ambient temperature and the size of the surface to be painted. ET645 should only be used for spot and/or panel repair.



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### RECOMMENDED USE

#### Surface preparation

##### OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara® wipes.
3. Sand surface:
  - a. before applying non-sanding surfacer: mechanical with P220 - P320, wet with P600;
  - b. before applying sanding surfacer: mechanical with P220 - P280, wet with P360 - P500.
4. Remove all traces of sanding dust, blowing with clean oil-free compressed air.
5. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.

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 DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.
- 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 DuPont Refinish preparatory cleaner for bare metals. Wipe dry with clean Sontara® wipes.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing with clean oil-free compressed air.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.
5. Apply 1 coat of Imron® Fleet Line wash primer or Imron® Fleet Line epoxy primer.

#### Application selection

##### Non-sanding surfacer

To reduce sanding work and increase output of spray booth.

##### Sanding surfacer

For spot, panel and overall repair.

#### Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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### RECOMMENDED USE (con'd)

#### Remarks

- Do not use activated P504 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.
- Can only be coated with Imron® Fleet Line 2K topcoats. NOT developed to be coated with basecoat/clearcoat systems.
- 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.
- Recommended activator/thinner is ET650/ET750.

#### Product data

Package viscosity: 1885 cp  
 Theoretical coverage: Non-sanding surfacer 13.5 m<sup>2</sup>/l at 25µm DFT - ready-to-spray  
 Sanding surfacer 4-4.5 m<sup>2</sup>/l at 100µm 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 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Products	Packages (l)	Shelf life at 20°C (year)
P504	4	2
805R	1	2
ET645	1 - 5	2
ET650	5	2
ET655	5	2
ET745	5	2
ET750	1 - 5	2
ET755	5	2

#### Safety

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



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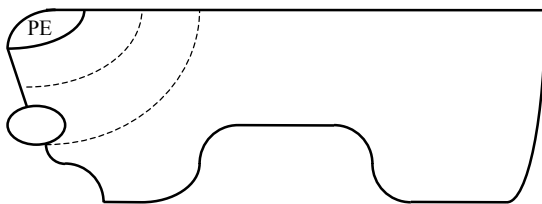
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## FLEET SURFACER

### REPAIR SYSTEMS

#### Preparation method for spot repair

P280 P320 P360



1. Sand through, end with P280.
2. Fill the spot with DuPont Refinish 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<sup>®</sup> Fleet Line wash primer or Imron<sup>®</sup> Fleet Line epoxy primer over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1<sup>st</sup> coat of surfacer over the entire prepared area. Flash till completely flat.  
Apply 2<sup>nd</sup> coat of surfacer, staying inside the 1<sup>st</sup> coat area. Flash till flat.