



Effective 14 September, 2007

P7

PRIMEPOX P7

Description

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

Products

P7	Primepox P7
P72	Activator P72
THP710	Thinner P710
THP711	Thinner Slow P711

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.
- 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.
- DuPont Refinish polyester putties.

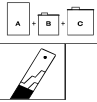









Effective 14 September, 2007

P7

PRIMEPOX P7

PRODUCT PREPARATION

	Mixing ratio	Standard		Large surface/High temp.		
		Volume	Weight	Volume	Weight	
	P7	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 FORD 4	5:1:1	5:1:1.5	5:1:2	
			27-33 s 31-38 s	20-24 s 24-26 s	18-20 s 20-22 s	
	Spray equipment	Conventional guns	Fluid tip	Distance	Pressure	
			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	
		Compliant guns (HVLP/HTE)				
		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				
	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 µm/coat				
	Dry to sand at 20°C	5 hr				
	at 40°C	1 hr				
	at 60°C	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.



Effective 14 September, 2007

P7

PRIMEPOX P7

RECOMMENDED USE

Surface preparation

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

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 a clean Sontara® wipe.

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. mechanical with P280 - P320;
 - b. wet with P600.
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.

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



Effective 14 September, 2007

P7

PRIMEPOX P7

RECOMMENDED USE (con'd)

Remarks

- For optimum surface preparation gritblast to Sa 2 ½.
- Activated material should not be returned to original can of non-activated material.
- P7 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.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.
- ValueShade® 2 (VS2) is equal to 100 % of P7.
- 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.

Product data

Package viscosity: 340 cp
 Theoretical coverage: 5:1:1 7.5 m²/l at 50µm DFT - ready-to-spray
 5:1:1.5 7 m²/l at 50µm 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)
P7	4	2
P72	5	2
THP710	5	2
THP711	5	2

Safety

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