



Effective 15 March, 2010

# P400

## CHROMATE FREE HIGH BUILD PRIMER SURFACER

### Description

2-component chromate-free primer surfacer.  
Colour: grey.  
Composition based on polyacrylic resins.

### Products

P400	Chromate Free High Build Primer Surfacer
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow

### Properties

- Easy application.
- Excellent sagging resistance.
- Airless and electrostatic application.
- Can be coated with all Imron® Fleet Line 2K topcoats.
- VOC compliant, conform with directive 2004/42/EC.

### Substrates

- Bare metals: sanded steel, gritblasted steel and sendzimir galvanised steel.
- OEM or cured repair finishes.
- E-coats.
- Glass fibre reinforced plastic (UP-GF).
- Sanded DuPont Refinish polyester putties.

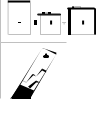









Effective 15 March, 2010

# P400

## CHROMATE FREE HIGH BUILD PRIMER SURFACER

### PRODUCT PREPARATION

	<b>Mixing ratio (1)</b>	P400 ET645/ET650/ET655 ET745/ET750/ET755	<b>Volume</b>		<b>Weight</b>
			10	1	100 7.5 12.5-17.5
	<b>VOC</b>	540 g/l			
	<b>Pot life at 20°C</b>	8-12 hr			
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	20-25 s 21-27 s 23-31 s		
	<b>Spray equipment</b>	<b>Conventional guns</b> Gravity feed Suction feed Pressure feed	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
			1.5-1.8 mm	20-25 cm	3-4 bar
			1.6-1.8 mm	20-25 cm	3-4 bar
		<b>Compliant guns (HVLPHTE)</b> Gravity feed Suction feed Pressure feed	1.1-1.2 mm	20-25 cm	3-4 bar
			1.5-1.7 mm	15 cm	According to supplier's specifications
			1.8-2.0 mm	15 cm	
1.1 mm	15 cm				
	<b>Number of coats</b>	1-3			
	<b>Flash time</b>	1-3 hr before recoating.			
	<b>DFT</b>	40-80 μ			
	<b>Dry to sand</b>	Not applicable.			
	<b>IR drying*</b>	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.

(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.



# P400

## CHROMATE FREE HIGH BUILD PRIMER SURFACER

### RECOMMENDED USE

#### Surface preparation

##### Bare metals

1. Clean surface with a DuPont Refinish 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 DuPont Refinish 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 DuPont Refinish 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 DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.

#### Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



Effective 15 March, 2010

# P400

## CHROMATE FREE HIGH BUILD PRIMER SURFACER

### RECOMMENDED USE (con'd)

#### Remarks

- Do not use activated P400 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.
- Material has to be at room temperature (18-25°C) before use.

#### Product data

Package viscosity: 2000-3000 cp  
Theoretical coverage: 9.8 m<sup>2</sup>/l at 25 μ 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	Content (l)	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
P400	10	11.5	2	1.439
ET645	1 - 5	1 - 5	3	1.062
ET650	5	5	3	1.076
ET655	5	5	3	1.081
ET745	5	5	4	0.823
ET750	5	5	4	0.905
ET755	5	5	4	0.918

#### Safety

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