



Effective 15 March, 2010

P300

HIGH BUILD PRIMER SURFACER

Description

2-component zinc chromate containing primer surfacer.

Colour: green.

Composition based on polyacrylic resins.

Products

P300	High Build Primer Surfacers
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow

Properties

- Offers optimal corrosion protection for all metal substrates, except for stainless steel and aluminium profiles.
- 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.

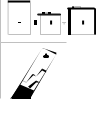









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PRODUCT PREPARATION

	Mixing ratio (1)	P300 ET645/ET650/ET655 ET745/ET750/ET755	Volume		Weight
			10	1	100
			2-2.75		7.5 12.5-17.5
	VOC	540 g/l			
	Pot life at 20°C	8-12 hr			
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	20-25 s 21-27 s 23-31 s		
	Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure
			1.5-1.8 mm	20-25 cm	3-4 bar
			1.6-1.8 mm	20-25 cm	3-4 bar
		1.1-1.2 mm	20-25 cm	3-4 bar	
		Compliant guns (HVLPHTE) Gravity feed Suction feed Pressure feed	1.5-1.7 mm 1.8-2.0 mm 1.1 mm	15 cm 15 cm 15 cm	According to supplier's specifications
	Number of coats	1-3			
	Flash time	1-3 hr before recoating.			
	DFT	40-80 μ			
	Dry to sand	Not applicable.			
	IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min	* Guideline for short/medium wave IR equipment.	
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.



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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.



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RECOMMENDED USE (con'd)

Remarks

- Do not use activated P300 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: 5000-6000 cp
Theoretical coverage: 9.6 m²/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)
P300	10	11.5	2	1.413
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.



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Health hazard information

Apart from the sensitising and irritating effects particularly of zinc chromates, which follow dermal and mucosal contact, zinc chromate is listed in the MAC list as a clearly carcinogenic hazardous substance.

If humans inhale these substances for a long time, the bronchial tubes will be the main organ affected by cancer. The risk of bronchial cancer has been established to be significantly higher in the industry producing zinc chromate pigments and for users spraying anti-corrosive agents containing zinc chromates.

Protective measures

- Use low-overspray spraying processes.
- Install local dust extraction.
- Ensure sufficient ventilation.
- Only apply in dedicated areas.
- Use respiratory equipment.
- Reduce formation of dust when sanding, e.g. dust extraction or wet sanding.
- Extract welding emissions where necessary.

In addition, below mentioned organisational and personal safety measures are required.

- Instruct people prior to using these materials and refresh instructions annually.
- Write and display operating instructions.
- Use personal safety equipment (protective clothing, respiratory equipment and eye protection).
- Take hygienic precautions, e.g. separate storage of protective equipment and other clothing.