

## Product Information

### Product Description:

IME.FP300 Synthetic Primer DTM (direct to metal) Grey is a 1K corrosion protection primer with excellent adhesion, air-dry and force-dry capabilities.

### Substrates:

All Iron, steel, cast iron, galvanized steel, aluminum.

Industrial OEM and solvent resistant surfaces, sanded, cleaned original and old cured coatings.

### Preparation:

Dry Sanding: P150 – P240.

Galvanized: Sweep Blasting recommended.

(More Detailed information go-to Preparation and Pre-treatment on Icris/CRS or website [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com))

**Surface Preparation:** Abrasive blast to EN ISO 12944, Part 4 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm.

Material Description	Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm
IME.FP300	Spray	25µm	60µm	30µm	80µm

\*Product can be brushed and rolled.

### Cleaning:

Surface must be dry and free from any contamination, e.g. oil, grease, release agents. Use IME.RS605/607/609 Universal Reducer, IME.AD690 Solvent Degreaser or Valspar Wax and Grease Remover.

(More Detailed information go-to cleaning processes on Icris/CRS or website [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com))





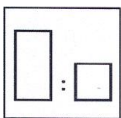



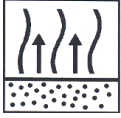
### Recoating:






Can be recoated with IME.TB300 Synthetic Topcoat and TB500/510/511/512/520 PU Topcoats (see TDS).

### Physical properties:

Chemical base	Synthetic
Density (kg/l)	1,456 kg/l
Volume solids (%)	51%
Weight Solids (%)	71%
Flash point	26.5°C
Pot life (+20°C)	Approx. 24 hours (as 1K product)
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m <sup>2</sup> )	Approx. 9.5 – 10.5m <sup>2</sup> 40µm (DFT)
Gloss	Matt
Color	Grey
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	(VOC: 2004/42/IIb(c)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

## Application Data

	<b>Cleaning:</b>	IME.RS605/607/609 Universal Reducer IME.AD690 Solvent Degreaser Valspar Wax and Grease Remover Surface must be dry and free from any contamination, e.g. oil, grease	
	<b>Preparation:</b>	<b>Sanded systems:</b> P150 – P240 <b>Galvanized:</b> Sweep blasting recommended <b>Abrasive blast:</b> AS 1627.4 Class 2.5 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm	
	<b>Before using:</b>	The product must be shaken before adding the Color Toners and thoroughly stirred directly after the Activator and Reducer have been added.	
	<b>Mix stick:</b>	Use the mixing stick <b>M2 4:1</b> (M2 - 74-202 = 3:1/4:1) <b>M6</b> (74-206 standard) / <b>M7</b> (74-207 large) Universal cm-stick	
	<b>Mixing ratio with Reducer:</b>  (By volume) <b>Higher chemical resistant</b>	IME.FP300 Synthetic Primer DTM Grey IME.RS300 Synthetic Reducer or IME.AS300 Synthetic Activator IME.RS300 Synthetic Reducer	100 parts 15-30 parts  25 parts + 0 – 10%
	<b>Viscosity:</b>	20 – 28 sec. (DIN4/20°C)	
	<b>Gravity or Suction Feed:</b>		
	Nozzle set Spray gun “High pressure” Spray gun “Reduce pressure” HVLP (Air cap pressure) Airless/Airmix Pressure Pot	1.4 – 1.7mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0,7 bar (10 psi) maximum See info manufacturer 1.0 – 1.5mm	
	<b>Application:</b>	<b>Option 1: wet on wet</b> 1 full closed coat or ½ + 1 full coat	<b>Option 2:</b> 1 full closed coat followed by 1 full closed coat
	<b>Film Thickness:</b> (Recommended 40-60µm)	25 – 40µm (DFT)	40 – 60µm (DFT)
	<b>Between coats at 20°C:</b>  <b>Before baking at 20°C:</b>	5 minutes  10 minutes	5 – 10 minutes  10 minutes

	<b>Air-dry at 20°C:</b>	<b>Dust Free:</b> 20 – 30 minutes <b>Dry:</b> 6 – 8 hours
	<b>Force-dry at 60°C – 70°C:</b>	10 – 20 minutes 60°C object temperature
	<b>IR-dry:</b>	8 – 12 minutes (The panel must not reach a temperature above 90°C)
	<b>Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).</b>	
	<b>Recoatable:</b>  Recoatable 1hr-24hrs at 20 °C	IME.TB300 Synthetic Topcoat and IME.TB5xx PU Topcoat (See Technical Data Sheet)  After 24 hours: Sanding required
	<b>Precautions:</b> During application all health and safety measures referring to the use and handling of coating materials are to be observed, e. g. existing regulations issued by the trade associations in the Chemical Industry. For Health and Safety information please refer the Material Safety Datasheet (MSDS). Information also available on our webpage: <a href="http://www.valsparindustrialmix.com">www.valsparindustrialmix.com</a>	
	<b>Note:</b> The products listed are intended only for the professional user and for professional use. All recommendations in words and writing given on the use of our products to customers or users are not binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from autonomously checking whether our products are suitable for the intend purpose. The durability of the coating system largely depends on the thorough preparation of the surface. Furthermore our uniform terms of delivery and payment are applicable.	
With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.		