



IMRON®

Primer-Filler Application Process

Step 1 | PPE

- Wear appropriate PPE for the task and area

Step 2 | Shake

- When new and when changing primer cans, shake 5 minutes and stir material prior to adding a mixing lid

Step 3 | Mix

- Determine amount needed. Verify the recommended undercoat
- Use appropriate components based on the temperature, humidity, air movement, and size of repair
- Stir thoroughly with a mixing stick after pouring components

Step 4 | Spray Gun

- Select the appropriate 1.4 -1.6 mm spray gun based on the TDS information and Spray Gun Setup SOP
- Check spray pattern on paper to ensure gun is functioning properly

Step 5 | First Coat

- Thoroughly clean surface as per the Surface Cleaning SOP
- Tack off using Sontara E-4586 primary tack cloth
- Apply one medium-wet coat of surfacer to the farthest point of the repair
- Allow proper flash according to the TDS

Step 6 | Second Coat

- Apply second medium-wet coat of surfacer inside of the first coat
- Allow proper flash according to the TDS

Step 7 | 5S (Sort, Straighten, Shine, Standardize, and Sustain)

- Clean spray gun
- Dispose of waste according to local environmental regulations
- Return all items to their proper place