

Technical Data Sheet.



Priomat® 1K Wash Primer 4085.

Priomat® 1K Wash Primer 4085 is a zinc chromate-free one-pack product for all commonly found metallic substrates.

- VOC-compliant
- good corrosion protection
- easy to use (one-pack product)
- available in light and dark grey
- welding certificate available

For professional use only!
VR Technical Data Sheet No. EN / 4085 / 01

Substrate.

Suitable substrates:

1. Steel
2. Electroplated / roller galvanised steel panels or soft aluminium, cleaned and sanded.
3. Lightly sanded factory primer
4. Well sanded original or old paintwork (except thermoplastic paintwork)
5. Surfaces treated with Raderal® putty and then finely sanded.

Important note:

Owing to the wide variety of metal alloys and manufacturing processes, it is essential to carry out a preliminary test on the respective substrate to ensure that the pretreatment is sufficient to guarantee perfect adhesion.

Substrate pretreatment:



Clean all substrates carefully with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.



Original or old paintwork – clean and sand lightly, remove all traces of rust and sand the areas around the former rust spots to create a smooth transition to the old paintwork.









Before further treatment carefully clean substrate with a suitable cleaning agent to remove dust and residues.

Application.

Reducer:

- Permacron® Reducer 3364
- Permacron® Reducer 3380
- Permacron® Reducer 3365 slow
(for large objects and high temperatures)
- Permacron® Reducer 3385 slow
(for large objects and high temperatures)
- Permacron® MS Duraplus 8580

<p>Method of application:</p> <p>Application viscosity 4 mm, +20°C, DIN 53211:</p> <p>Reducer at +20°C material temperature:</p> <p>Spray nozzle*:</p> <p>Spray pressure*:</p> <p>Atomising pressure*:</p> <p>Number of coats:</p> <p>Special note:</p> <p>Drying.</p> <p>Air drying:</p> <p>Recoating.</p> <p>Application as wash primer:</p>		Compliant	HVLP
		mixing viscosity	
		50%	
		1.3 - 1.5 mm	1.3 - 1.5 mm
		2.0 - 2.5 bar	-
		-	0.7 bar
		When used as a wash primer: 1 coat = 10 - 15 µm dry film thickness	
		<p><u>Isolating small sanded-through spots:</u> Permahyd® base coat/Permasolid® HS top coat may only be applied wet-on-wet or with intermediate sanding on top of Priomat® 1K Wash Primer 4085 if the sanded-through spot is not bigger than Ø 5.0 cm.</p> <p>1 - 2 coats = 15 - 30 µm dry film thickness</p>	
		<p><u>At +20°C ambient temperature recoatable with:</u></p> <ul style="list-style-type: none"> ▪ Permasolid® HS surfacers 10 - 15 min ▪ Permasolid® HS Automotive Top Coat 275 10 - 15 min (for small sanded-through spots only!) ▪ Permahyd® Base Coat 280/285/286 20 - 30 min (for small sanded-through spots only!) <p><u>Dry for sanding:</u> 45 - 60 min</p>	
		<p><u>Recoat with:</u> Permasolid® HS surfacers</p>	

* See manufacturer's instructions!

Application as wash primer with intermediate sanding:



wet with P800 – 1000

Recoat with:

- Permasolid® HS Automotive Top Coat 275 (for small sanded-through spots only!)
- Permahyd® Base Coat 280/285/286 and Permasolid® HS clear coat (for small sanded-through spots only!)

Special notes.

1. Do not recoat with polyester products, epoxy products or waterborne products.
2. Not suitable for application on thermoplastic paintwork.
3. Cannot be dry sanded.

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

Data.

Flash point:

above +23°C

VOC content:

2004/42/IIB(c)(780)760

The EU limit value for this product (product category IIB.c) in ready to use form is max. 780 g/litre of VOC.

The VOC content of this product in ready to use form is max. 760 g/l.

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