

Technical Data Sheet.



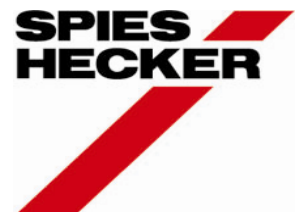
Priomat® 1K Wash Primer 3255 red brown.

Priomat® 1K Wash Primer 3255 red brown is a zinc chromate-free one-pack product based on polyvinyl butyral, and is used in passenger car refinishing.

The special combination of pigments and binders provides good corrosion protection and adhesion. Moreover, this wash primer is certified suitable for application on welded joints.

We recommend coating any rust spots, corners and edges, as well as areas which have been sanded through, first with Priomat® 1K Wash Primer 3255 red brown and then with a Permasolid® HS surfacer.

For professional use only!
VR Technical Data Sheet No. EN / 3255 / 02



Substrate.

Suitable substrates:

Electroplated / roller galvanised steel panels or soft aluminium, cleaned and sanded.

Lightly sanded factory primer

Fully cured, solvent resistant, well preserved and lightly sanded original or old paintwork (except thermoplastic paintwork)

Surfaces treated with Raderal® 2K polyester products and then finely sanded.

Substrate pretreatment:



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



Sand dry with random orbital sander and dust extraction, P400 – 500 grade

or



wet with P800 - 1000 grade.

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 suitable cleaning agent to remove dust and residues.

Application.

Application with a paint-brush:



Apply 1 - 2 coats with a flat paint-brush
Viscosity as supplied = application viscosity

Reducer:

Permacron® MS Dura Plus 8580

Permacron® Reducer 3364

Permacron® Reducer 3380

Method of application:

Application viscosity
4 mm, +20°C, DIN 53211:

Reducer at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

Number of coats:

Prescribed
film thickness:






Flash-off time:

Recoating.

After flash-off
recoat with:

Special notes:

Note on safety:

| | | |
|--|--|--------------|
|  | Compliant | HVLP |
|  | 18 - 20 seconds | |
|  | 40% | |
| | 1.3 - 1.4 mm | 1.3 - 1.4 mm |
| | 1.5 - 3.0 bar | - |
| | - | 0.7 bar |
|  | 2 coats | |
| | 15 – 20 µm dry film thickness | |
|  | 15 - 25 minutes at +20°C ambient temperature | |

Permasolid® HS surfacer
(see Technical Data Sheet)

1. Do not recoat with polyester products.
2. Do not recoat with epoxy products.
3. Do not recoat directly with Permahyd® Base Coat 280/285 or Permahyd® Hi-TEC Base Coat 480.
4. Not suitable for application on thermoplastic paintwork.
5. We recommend the following 3-stage system:
 - a) Prime with Priomat® 1K Wash Primer 3255 red brown
 - b) Isolate with Permasolid® HS surfacer
 - c) Top coat
6. The three-stage system must be used for galvanized substrates.



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)780

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. 780 g/litre.

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