

Technical Data Sheet.

Priomat® Elastic Primer 3304 transparent

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Priomat®Elastic Primer 3304 transparent is a versatile one-pack adhesion promoter for all plastic parts commonly found on vehicle exteriors.

This primer is characterised by excellent adhesion, high elasticity and easy application.

For professional use only!



Substrate



Suitable substrates:

All plastic parts commonly found on vehicle exteriors (PP, EPDM, ABS, PC, PPO, PA, R-TPU, PBTP, PVC, PUR, PUR flexible foam, UP-GF)

Substrate pretreatment:

The substrate must be free of release agents.

Heat plastic parts for 60 minutes at +60°C before cleaning to let the release agents exude.



Clean with Priomat®Reducer 8581 or with the milder Permanent Silicone Remover 7010. The extent of the cleaning required depends on the type and quantity of release agents present. To facilitate the cleaning process, we recommend the use of a sanding pad (3M 7448). Allow the reducer to evaporate completely (e.g. air dry overnight at ambient temperature or low bake for 30-40 minutes at +60°C).



Before applying the primer, clean lightly once more with Priomat®Plastic Reducer 8581 or Permanent Silicone Remover 7010 (antistatic effect).

Special note:









After this special cleaning process, Priomat®Elastic Surfacer 3305 white can be applied as a primer surfacer on top of PUR flexible foam.
See VR Technical Data Sheet No. 201.1.

Application



Reducer:

Do not add reducer!

Method of application		High pressure spraying		HVLP	
		gravity feed	suction feed	gravity feed	suction feed
					
	Application viscosity 4 mm, +20°C, DIN 53211	11 seconds			
	Reducer at +20°C material temperature	no reducer required viscosity as supplied = application viscosity			
	Spray nozzle	1.3–1.4 mm	1.5–1.7 mm	1.3–1.5 mm	1.6–1.8 mm
	Spray pressure	3–4 bar	3–4 bar	—	—
	Internal nozzle pressure	—	—	0.7 bar	0.7 bar
	Number of coats	1 full coat = 1–2 µm			
	Flash-off time	at +20°C ambient temperature 15 minutes			

Further treatment



Surfacer: Permacron®/ Permasolid® 2K Acryl Surfacer elastified with Permasolid® Elastic Additiv 9050

Recoat with: Permacron®Automotive Top Coat Series 257
Permasolid®HS Automotive Top Coat Series 270
Permacron®Base Coat Series 293/295 and
Permacron®/Permasolid®2K clear coat
Permahyd®Base Coat Series 280/285 and
Permacron®/Permasolid®2K clear coat

For elastification of the products:
see System Data Sheet No. 901.1 "The Paint System for Plastic Parts".

Data



Viscosity as supplied: 11 seconds

Flash point: above +23°C

Solids content:
(without reducer) 4.9% by weight
3.9% by volume

Specific weight: 0.87 g/cm³

Coverage*: 19.5 m²/l
at 2 µm
dry film thickness

VOC value: 834 g/l
(without reducer)

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume (without reducer). No allowance was made for wastage during application.

Storage



Guaranteed shelf life: 6 months in sealed original containers

Storage conditions: Storage temperature +20°C



(not below +5°C)

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