

Technical Data Sheet.

Permacron® 1:1 Elastic Primer Surfacer 3300

Permacron® 1:1 Elastic Primer Surfacer 3300 is a high-grade 2K primer surfacer for plastic parts.

Substrate

- Good adhesion on all plastics commonly used in passenger cars

Application

- Non-sanding application possible

Drying

- Efficient painting system

- Easy to use

- Very long pot life

Further steps

Data

Storage

For professional use only!



Substrate



Suitable substrates:

All plastic parts commonly found on vehicle exteriors (PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, 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 to let the release agents exude.



Clean with Priomat® Reducer 8581 or 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 Minuten at +60°C).



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

Application



Mixing ratio:









1:1 by volume with



Permacron® Elastic Hardener 3301

Pot life:

Ready for use 7–9 hours at +20°C.

Method of application	High pressure spraying/Compliant		HVLP	
	Gravity feed	Suction feed	Gravity feed	Suction feed
				
 Application viscosity at +20°C material temperature	DIN 4 mm = 16–18 sec. ISO 4 mm = 37–45 sec.			
 Reducer at +20°C material temperature	none (ready for use after hardener has been added)			
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 application = 1 tack coat followed by 1 full coat without flash-off between coats.			
Recommended film thickness	25–30 µm dry film thickness			
 Flash-off time	At +20°C ambient temperature 15–20 minutes			

Drying



Air drying:

At +20°C ambient temperature



Can be recoated wet-on-wet after 15–20 minutes (max. 24 hours) with a suitable top coat.

Special note:

If required, Permacron® 1:1 Elastic Primer Surfacer 3300 can be sanded lightly with wet sanding paper P 800–1000 after low baking for 30 minutes at +60°C metal temperature or air drying for 2 hours at +20°C ambient temperature.

Further steps



- Special notes:** Any defects in the substrate can be treated with Raderal® Fine Putty 0911 or Permacron® Fine Putty 7715 after 1:1 Elastic Primer Surfacer 3300 has dried. Putty spots must be isolated with 1:1 Elastic Primer Surfacer 3300 before the top coat can be applied.
- Recoat with:** Permacron® Automotive Top Coat Series 257
Permasolid® HS Automotive Top Coat Series 270
Permahyd® Base Coat Series 280/285 and Permacron®/Permasolid® 2K clear coat
Permacron® Base Coat Series 293/295 and Permacron®/Permasolid® 2K clear coat
- For elastification of Automotive Top Coat Series 257, Serie 270 and clear coats see System Data Sheet "The Paint System for Plastic Parts" (VR Technica Data Sheet No. 903.1) or "The Permahyd® / Permasolid® Paint System for Plastic Parts" (VR Technical Data Sheet No. 902.1).
- Important note:** Coated plastic parts should not be washed with a high-pressure jet cleaner within the first 6 weeks. After this period the nozzle must be held at a distance of no less than 30 cm from the object.

Data



- Viscosity as supplied:** Elastic Hardener 3301 = approx. 11 sec.
1:1 Elastic Primer Surfacer 3300 = approx. 100 sec.
- Flash point:** above +23°C
- | | 1:1 Elastic Primer Surfacer 3300 | Primer Surfacer and Hardener mixed |
|---|--|--|
| Solids content:
(without reducer) | approx. 54.0% by wt.
approx. 37.0% by wt. | approx. 35.7% by wt.
approx. 23.5% by wt. |
| Specific weight: | approx. 1.20 g/cm ³ | approx. 1.04 g/cm ³ |
| Coverage*: | | approx. 8.1 m ² /l
at 30 µm dry film thickness |
| VOC content:
(without reducer) | | 673 g/l |

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

Storage



Guaranteed shelf life: 6 months in sealed original containers

Storage conditions: 1:1 Elastic Primer Surfacer 3300
Storage temperature approx. +20°C



Elastic Hardener 3301
Storage temperature approx. +20°C
(+5°C may not be exceeded)

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