

Technical Data Sheet.



Priomat® 1K Wash Primer 4085

Substrate

Priomat® 1K Wash Primer 4085 is a zinc chromate-free one-pack product from our "PVB-System".

Application

Field of application: As a wash primer on all commonly found metallic substrates.

Drying

Recoating

- very good corrosion protection
- easy to use (one-pack product)
- efficient wet-on-wet application
- available in two different shades of grey

Special notes

Data

It can be applied as a primer surfacer either wet-on-wet or with intermediate sanding. It can be recoated with all top coats.

Storage

For professional use only!



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 old or original paintwork (except thermoplastic paintwork).
5. Surfaces treated with Raderal® 2K polyester products 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:



Steel, electroplated / roller galvanized steel panels or soft aluminium - degrease and sand lightly.

Factory primer - clean and sand lightly.

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, clean all substrates once more with Permanent Silicone Remover 7010 or Permanal® Silicone Remover 7799.

Application



Reducer: Permacron® MS Dura plus 8580
 Permacron® Reducer 3364
 Permacron® Reducer 3365 slow
 (for large objects and high temperatures)

Method of application		High-pressure/ Compliant	HVLP
		Gravity feed	Gravity feed
			
	Application viscosity at +20°C material temperature	DIN 4 mm = 18–20 sec. ISO 4 mm = 36–45 sec.	
	Reducer at +20°C material temperature	50%	
	Spray nozzle *	1.3–1.5 mm	1.5–1.7 mm
	Spray pressure *	3–4 bar	—
	Internal nozzle pressure *	—	0.7 bar
	Number of coats	When used as a wash primer 1 coat = 10–15 µm dry film thickness	
	Number of coats	When used as a primer surfacer with wet-on-wet application 1–2 coats = 15–30 µm dry film thickness	
	Number of coats	When used as a primer surfacer with intermediate sanding 2–3 coats = 30–50 µm dry film thickness	

* See manufacturer's instructions.

Drying



Air drying:

At +20°C ambient temperature



Recoating with Permacron®/Permasolid® 2K acrylic surfacers: 10–15 minutes

Recoating with top coat: 10–15 minutes

Recoating with Permahyd® Base Coat Series 280/285: 20–30 minutes

Dry for sanding: 45–60 minutes

Recoating



Application as primer:

Recoat with:
Permacron®/Permasolid® 2K acrylic surfacers

Application as primer surfacer:



Intermediate sanding:
wet with P 800–1000

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

Special notes



1. Do not recoat with polyester products.
2. Not suitable for application on thermoplastic paintwork.
3. Cannot be dry sanded.
4. This product may be used as a wash primer as its VOC value complies with that stipulated by CEPE.

Data



Viscosity as supplied: At least 60 seconds

Flash point: above +23°C

	Wash Primer 4085 light grey	Wash Primer 4085 dark grey	Wash Primer 4085 light grey with Reducer 3364	Wash Primer 4085 dark grey with Reducer 3364
Solids content:	43.5% by wt. 22.7% by vol.	41.2% by wt. 22.0% by vol.	31.3% by wt. 15.1% by vol.	29.3% by wt. 14.6% by vol.
Specific weight:	1.11 g/cm ³	1.08 g/cm ³	1.03 g/cm ³	1.01 g/cm ³
Coverage*:			10.1 m ² /l at 15 µm dry film thickness	9.8 m ² /l at 15 µm dry film thickness
			3.8 m ² /l at 40 µm dry film thickness	3.7 m ² /l at 40 µm dry film thickness
VOC content:			708 g/l	712 g/l

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume. No allowance was made for wastage during application.

Storage



Guaranteed shelf life:

6 months in sealed original containers

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