



Technical Data Sheet.

Permacron® 1:1 Elastic Primer Surfacer 3300

Wet-on-wet primer surfacer for painting plastic substrates

Permacron 1:1 Elastic Primer Surfacer 3300 is a high-quality 2K primer surfacer for all common external plastic vehicle parts.

- Offers secure adhesion.
- Can be applied in wet-on-wet processes.
- Enables easy and efficient handling.
- Offers a very wide application window.



For professional use only!

Spies Hecker simply closer.



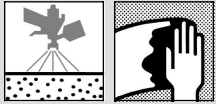
An Axalta Coating Systems Brand

Permacron® 1:1 Elastic Primer Surfacer 3300

Product preparation - application STANDARD WET ON WET



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.

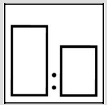


New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in Permaloid Silicone Remover 7010 / final cleaning use a cloth moistened with Permaloid Silicone Remover 7010.

Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth. Change cloths often, never use dirty cloths.

Remove thoroughly all traces of release agents.

Repairs to exterior common plastic car parts, sanded and cleaned.



Primer		Hardener	
Volume	Weight	Volume	Weight
1	100	1	73
3300		3301	



Pot life at 20°C: 7 hr - 9 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions

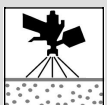


0.5 + 1
1 operation
1st: thin and closed
2nd: normal

final flash-off: 20 min - 1 day with 2K Topcoat / Permacron Basecoat 293/295
final flash-off: 45 min - 1 day with Permahyd Base Coat 280/285/286



P800 - P1000



Elastified 2K Topcoat
Basecoat + Elastified Clearcoat

VOC compliant

This product mix is out of scope for VOC directive

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Products

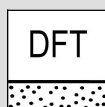
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Permacron® Elastic Hardener 3301

Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.



25 - 30 µm

Theoretical coverage

195 m²/l at 1 micron dry film thickness

Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Material should be stored at 20°C.
- Coated plastic car parts should not be washed with a high-pressure jet cleaner within the first six weeks. After this period, the nozzle must be held at a distance of no less than 30 cm from the object.
- Must be overcoated within maximum 24 hours.
- PE, PP and POM should not be overcoated due to risk of adhesion failures.
- Mix thoroughly by hand before placing the can on mixing machine.
- For countries outside the EU or usage other than vehicle refinishing: As an alternative, Permacron Base Coat 293/295/297 or Permacron MS Top Coat 730/Top Coat 257 can be used if not banned by the VOC Directive 2004/42/EC and if available.
- For detailed information regarding suitable plastic substrates, please refer to the Spies Hecker Plastic Painting System TDS - SHPlasticSystem.

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Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

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