Technical Data Sheet.

Priomat® Elastic Primer 3304

User-friendly 1K plastic primer

Priomat Elastic Primer Surfacer 3304 is a translucent universal 1K adhesion promoter for all commonly-found external plastic vehicle parts.

- Achieves reliable adhesion.
- Provides high elasticity.
- Enables easy application.

For professional use only!

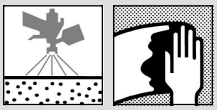
Spies Hecker simply closer.

An Axalta Coating Systems Brand

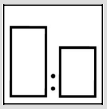
Priomat® Elastic Primer 3304

Product preparation - application STANDARD

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.

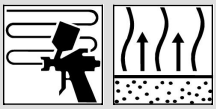


Primer	
Volume	Weight
100 %	100
3304	

Not applicable

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

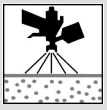
see manufacturer's instructions



1 normal coat

final flash-off: 10 min

20 °C	10 min



Appropriate Surfacer
Putty

VOC compliant

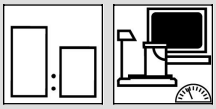
This product mix is out of scope for VOC directive

Priomat® Elastic Primer 3304

Products

Priomat® Elastic Primer 3304

Product mix



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

1 - 2 µm

Theoretical coverage

40 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.
- Shake before use.
- 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.
- For detailed information regarding suitable plastic substrates, please refer to the Spies Hecker Plastic Painting System TDS - SHPlasticSystem.

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.