



## Technical Data Sheet.

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# Permafleet® 1:1 Wash Primer 3688

2K wash primer with very good adhesion for use on commercial vehicles with difficult substrates

Permafleet Wash Primer 3688 is an acid-curing 2K adhesion promoter for commercial vehicles.

- Allows for an adhesion-promoting and passivating pre-treatment of metal substrates.
- Is particularly suitable for aluminium and stainless steel.
- Can be applied in a three-coat process.



For professional use only!

Spies Hecker simply closer.



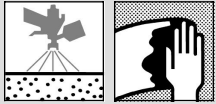
An Axalta Coating Systems Brand

# Permafleet® 1:1 Wash Primer 3688

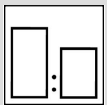
## Product preparation - application STANDARD



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



Bare steel sanded and cleaned  
Galvanised steel or aluminium sanded and cleaned  
Pretreated corrosion damages (e.g. sandblasted)  
Stainless steel, sanded and cleaned  
Old or original paintwork well sanded and cleaned.  
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



Primer		Hardener	
Volume	Weight	Volume	Weight
1	100	1	92
3688		3689 *	

\* Mix material must be used the same day.



Pot life at 20°C: 8 hr



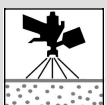
	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.3 - 1.5	2 - 2.5 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.5	0.7 bar	atomisation pressure
<b>Membrane pump</b>	1.1	2.5 - 3 bar	atomisation pressure
<b>Membrane pump</b>	1.1	0.8 - 1.2 bar	material pressure

see manufacturer's instructions



2 coats

with intermediate flash-off: 10 min - 15 min  
final flash-off: 30 min



2K Surfacer

VOC compliant

2004/42/IIB(c)(780) 780: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 780 g/l.

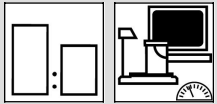
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## Products

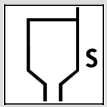
Permafleet® 1:1 Wash Primer 3688

Permafleet® Activator 3689

## Product mix



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



DIN 4: 15 - 16 s at 20°C



8 - 10 µm

### Theoretical coverage

80 - 90 m<sup>2</sup>/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 cleaning thinner.

## 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.
- Must be overcoated within maximum 24 hours.
- Mix thoroughly by hand before placing the can on mixing machine.
- Do not recoat with Raderal polyester products.
- Do not recoat with epoxy products.
- Do not recoat with Permasolid HS Premium Surfacer 5310 or Permasolid HS Spectro Flex 5400.
- On sanded and cleaned aluminium, prime immediately to prevent oxidation of the aluminium and to avoid further problems due to absorption.

# Permafleet® 1:1 Wash Primer 3688

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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.