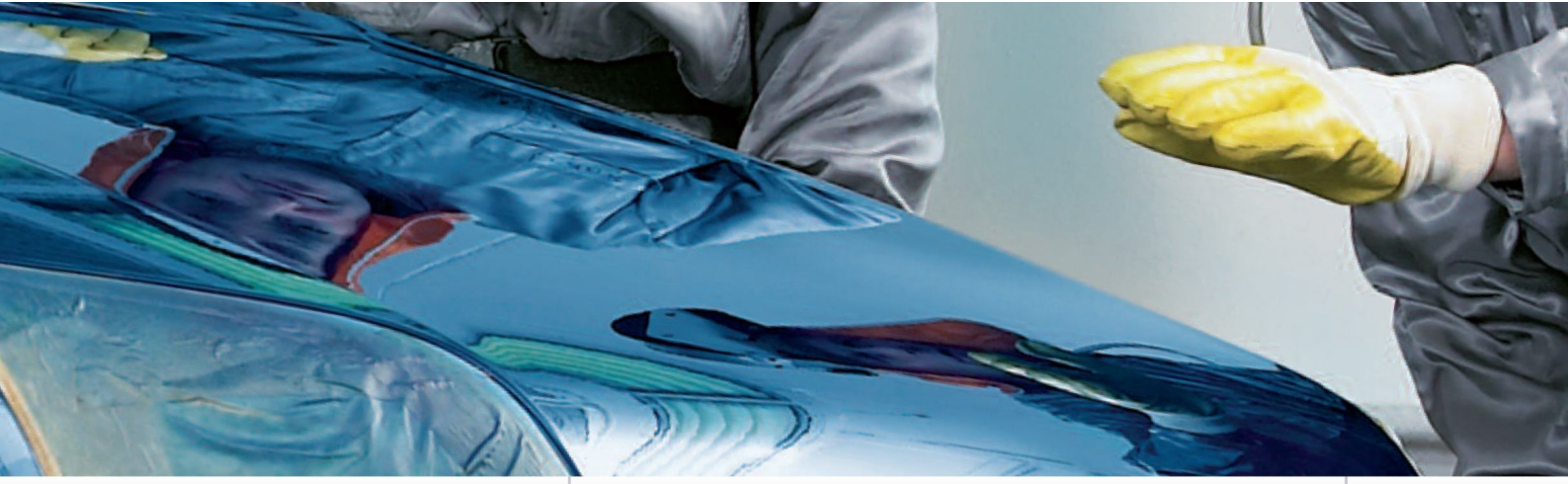


Technical Data Sheet.

Priomat® 1K Wash Primer 4085

1K wash primer for the Classic and Base Systems

Priomat 1K Wash Primer 4085 is a zinc chromate-free 1K wash primer for all common metal substrates.

- Offers good corrosion properties.
- Is easy to apply (1K product).
- Welding test report available.
- Supplied in different colours and also in a 1K spray can.

For professional use only!

Spies Hecker simply closer.

An Axalta Coating Systems Brand

Priomat® 1K Wash Primer 4085

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.

Bare steel sanded and cleaned
Galvanised steel or soft aluminium sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.

Primer		Reducer	
Volume	Weight	Volume	Weight
100 %	100	50 %	39
4085		3364 3365 SLOW 3380 3385 SLOW 8580	

Not applicable

	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions

Primer		Primer-surfacer	
1 coat	final flash-off: 10 min - 15 min	1 - 2 coats	with intermediate flash-off: 5 min final flash-off: 15 min - 8 hr

Primer	Primer-surfacer
2K Surfacer	2K Topcoat Permacron Basecoat 293/295 + Clearcoat

VOC compliant

2004/42/IIB(c)(780) 760: 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 760 g/l.

Priomat® 1K Wash Primer 4085

Product preparation - application STANDARD SANDING

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 soft aluminium sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.

Primer		Reducer	
Volume	Weight	Volume	Weight
100 %	100	50 %	39
4085		3364 3365 SLOW 3380 3385 SLOW 8580	

Not applicable

	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.5	1.8 - 2 bar	inlet pressure
HVLP	1.5 - 1.6	0.7 bar	atomisation pressure

see manufacturer's instructions

2 - 3 coats

with intermediate flash-off: 5 min
before bake: 8 min - 10 min

	3364/3365/3380/3385/8580
20 °C	45 min - 1 hr
60 - 65 °C	20 min

P500 - P600

2K Topcoat
Permacron Basecoat 293/295 + Clearcoat

VOC compliant

2004/42/IIB(c)(780) 760: 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 760 g/l.

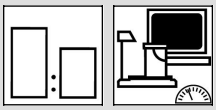
Priomat® 1K Wash Primer 4085

Products

Priomat® 1K Wash Primer 4085

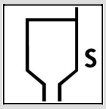
Permacron® MS Duraplus 8580
Permacron® Reducer 3364
Permacron® Reducer 3365 slow
Permacron® Reducer 3380
Permacron® Reducer 3385 slow

Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.
The choice of hardener and Reducer should be made according to application temperature and size of repair.

3364	Medium thinner suitable for partial up to full resprays. Mainly used at temperature range of 20-30°C.
3365	Slow thinner suitable for medium to large size repairs. Recommended also for warm conditions at 25-35°C.
3380	Medium thinner suitable for panel, multi panel and large size repairs. Mainly used at temperature range of 15-30°C.
3385	Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C.
8580	Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions.



DIN 4: 18 - 20 s at 20°C

15 µm per coat

Theoretical coverage

130 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.

Priomat® 1K Wash Primer 4085

Remarks

- Only use plastic or inner coated metal cans.
- Dry sanding only allowed for lightly denibbing.
- Material has to be at room temperature (18-25°C) before use.
- Not suitable for application on thermoplastic paintwork.
- Mix thoroughly by hand before placing the can on mixing machine.

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.