



Technical Data Sheet.

Priomat® 1K Wash Primer 3255



Corrosion-resistant 1K wash primer for the Base System

Priomat 1K Wash Primer 3255 red brown is a zinc chromate-free 1K product for refinishing passenger cars.

- Offers good corrosion protection.
- Demonstrates good adhesion.
- Comes with welding certificate.

For professional use only!

Spies Hecker simply closer.



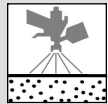
An Axalta Coating Systems Brand

Priomat® 1K Wash Primer 3255

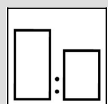
Product preparation - application STANDARD



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
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	40 %	32
3255		3364 3365 SLOW 3380 3385 SLOW 8580	

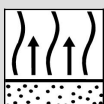


Not applicable



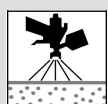
	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 15 min - 20 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

Priomat® 1K Wash Primer 3255

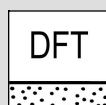
Permacron® MS Duraplast 8580
Permacron® Reducer 3364
Permacron® Reducer 3365 slow
Permacron® Reducer 3380
Permacron® Reducer 3385 slow

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.

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.
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.
8580	Accelerated fast thinner suitable for Speed Repair and panel repairs. Recommended for cooler application conditions.



15 - 30 µm

Theoretical coverage

110 - 115 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.
- Application with a flat paint brush: 1-2 coats (application viscosity as supplied).
- Do not recoat with polyester-, epoxy- or waterborne products.
- This product gives three months weather resistance on bare steel at the dry film thickness of minimum 50 micron.
- Mix thoroughly by hand before placing the can on mixing machine.

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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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