

Technical Data Sheet.

Priomat[®] Primer 3255 Red Brown

Priomat[®] Primer 3255 Red Brown is a polyvinyl-butyril based, zinc chromate free, single component product for car refinishing. The special composition of its pigment and binding agent enable it to offer top quality corrosion protection and excellent adhesion. Priomat[®] Primer 3255 Red Brown may also be used as a weld through primer. Priomat[®] Primer 3255 Red Brown is also available as an aerosol.

This product is for professional painting of vehicles only



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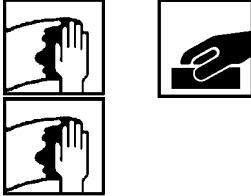
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Substrates

Suitable Substrates:

Bare Steel
 Sanded E-Coat
 Original or old paintwork (except reversible substrates, **Example:** lacquer)
 Raderal® Polyester products

Substrate pretreatment:



Degrease and sand.

Before further treatment, clean all substrates once more with Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

Application

Mixing ratio:








Approximately 50% Permacron® Reducer

Pot Life:

Unlimited

Reducer:

Permacron® Reducer
 ex. -Permacron® Dura Plus 8580 or
 -Permacron® Reducer 3363 Medium
 For optimum reducer selection, refer to TDS # 780.0

Method of application	HVLP	Approved Transfer Efficiency
		
Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.		
Spray Nozzle	1.3-1.4mm	1.2-1.3mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	18 - 20 seconds	
 Reducer at 68°F/20°C material temperature	Approximately 50%	
 Number of coats	a) 1 operation = 1 medium coat followed by 1 full coat without Intermediate flash-off time. b) 2 coats with approx. 5 minutes intermediate flash-off c) 1 coat brushed (for weld through applications)	

Recommended film thickness:

.4 - .6 mil dry film thickness

Drying

Flash-off time:

At 68°F/ 20°C

15 - 25 minutes



Further steps

Recoat with:

Permacron® or Permasolid®
Surfacers.



Examples:

Permasolid® Premium HS Premium Surfacers Plus 5310
Permacron® Vario Surfacers 8590
Permasolid® Spectro Surfacers 5400

Special tips

1. .4 - .6 mil dry film thickness is necessary for adequate corrosion resistance.
2. All traces of rust must be removed before priming with Priomat® Primer 3255 Red Brown
3. Do not recoat with polyester products.
4. Do not use on TPA (lacquer) finishes.
5. Do not recoat with Permahyd® products.
6. We recommend the following three stage system:
 - a) Prime with Priomat® Primer 3255 Red Brown
 - b) Apply 2K Permacron® Vario Surfacers 8590, Permasolid® Spectro Surfacers 5400, or Permasolid® HS Premium Surfacers Plus 5310. (Sand if needed.)
 - c) Topcoat
7. May be brushed on for use as a weld through primer

Important Regulatory Information

Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are "as applied regulatory (highest possible combination)" for the coating. Values have been determined using EPA Test Method 24. Please see the Master Values List for information for information on individual components. This product is exempt in areas outside of California. This product does not meet the California Aerosol Coatings Regulation limitations and is banned for sale to California.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
1 Liter-Pretreatment Coating	6.3 lbs/gal - 756 g/l	1000 g/l	77.0%	0.4%
Aerosol-California Aerosol Coatings: Auto Body Primer	VOC% = 86% PVMIR = .68 gO ₃ 1g	769 g/l	86.0%	0.3%

- Contains acid. May cause eye burns.
- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

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