

# Technical Data Sheet.

## Permacron<sup>®</sup> Pre-Polyester Coat 4583

Permacron<sup>®</sup> Pre-Polyester Coat 4583 is a special primer from our "2K-Acryl-System". This primer is applied prior to Raderal<sup>®</sup> Spray Polyester 3508 for adhesion and corrosion protection.

This product is for professional painting of vehicles only.



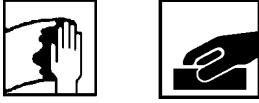
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## Substrates

### Suitable Substrates:

Original or old paintwork (except reversible substrates, **Example:** lacquer)  
Priomat® Primers

### 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.

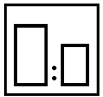
## Application



Hand stir.






### Mixing ratio:

4:1 by volume  
Permacron® Pre-Polyester Coat Hardener 3183.



### Pot Life:

approx. 2 hours at 68°F/20°C.

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	1.3-1.4mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	15-18 seconds	
 Reducer at 68°F/20°C material temperature	N/A	
 Number of coats	1 full, wet coat	

### Recommended film thickness:

0.8 mil dry film thickness

## Drying

### Flash-off time:

At 68°F/ 20°C

20 - 30 minutes ( max.8 hours)  
before Raderal® Spray Polyester  
3508



40-50 minutes (max. 8 hours) for  
Raderal® spreadable putties.

## Further steps

Recoat with:

Raderal® Spray Polyester 3508



## Special tips

1. Permacron® Pre-Polyester Coat 4583 is a corrosion protection primer only for use under Raderal® Polyester Products.
2. Due to wide variety of metal alloys, the use of Priomat® Wash Primer 4075 is recommended to assure optimum adhesion and corrosion protection. (Use prior to 4583)
3. All traces of rust must be removed before priming with Permacron® Pre-Polyester Coat 4583.
4. Do not use on TPA (lacquer) finishes.
5. Permacron® Pre-Polyester Coat 4583 must be sanded after 8 hours before recoating with Polyester Products.
6. Permacron® Pre-Polyester Coat 4583 may not be used under Permacron® 2K surfacer/Permasolid® HS surfacer.

## Important Regulatory Information

Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “as applied regulatory” 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.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Precoat-Adhesion Promoter	4.8 lbs/gal - 578 g/l	1211 g/l	56.0%	.04%

- **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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