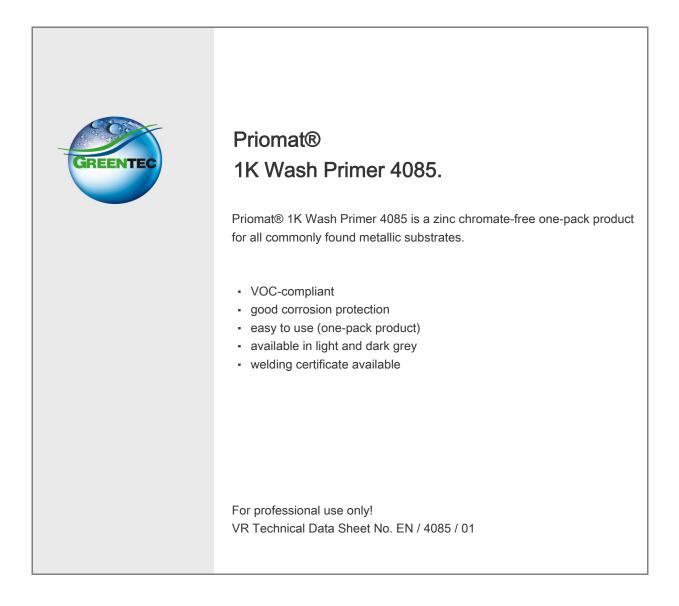
Technical Data Sheet.





Substrate.

Suitable substrates:

Important note:

Substrate pretreatment:

1. Steel

- 2. Electroplated / roller galvanised steel panels or soft aluminium, cleaned and sanded.
- 3. Lightly sanded factory primer
- 4. Well sanded original or old paintwork (except thermoplastic paintwork)
- 5. Surfaces treated with Raderal® putty and then finely sanded.

Owing to the wide variety of metal alloys and manufacturing processes, it is essential to carry out a preliminary test on the respective substrate to ensure that the pretreatment is sufficient to guarantee perfect adhesion.



Clean all substrates carefully with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.



Original or old paintwork – clean and sand lightly, remove all traces of rust and sand the areas around the former rust spots to create a smooth transition to the old paintwork.



Before further treatment carefully clean substrate with a suitable cleaning agent to remove dust and residues.

Application.

Reducer:

- Permacron® Reducer 3364
- Permacron® Reducer 3380
- Permacron® Reducer 3365 slow (for large objects and high temperatures)
- Permacron® Reducer 3385 slow (for large objects and high temperatures)
- Permacron® MS Duraplus 8580

Method of application:	⊳ ₩ €	Compliant	HVLP
Application viscosity 4 mm, +20°C, DIN 53211:	∏ s	mixing viscosity	
Reducer at +20°C material temperature:		50%	
Spray nozzle*:		1.3 - 1.5 mm	1.3 - 1.5 mm
Spray pressure*:		2.0 - 2.5 bar	-
Atomising pressure*:		-	0.7 bar
Number of coats:	Ę	When used as a wash primer: 1 coat = 10 - 15 µm dry film thickness	
Special note:	R	Isolating small sand Permahyd® base coat/Permaso applied wet-on-wet or with inte Priomat® 1K Wash Primer 4085 not bigger tha 1 - 2 coats = 15 - 30 μ	blid® HS top coat may only b ermediate sanding on top of 5 if the sanded-through spot i n Ø 5.0 cm.
Drying.			
Air drying:		 <u>At +20°C ambient temperature r</u> Permasolid® HS surfacers Permasolid® HS Automotive Top Coat 275 (for small sanded-through spotential sanded section of the sec	10 - 15 min 10 - 15 min ots only!) 885/286 20 - 30 min
		Dry for sanding:	45 - 60 min
Recoating.			
Application as wash primer:		<u>Recoat with:</u> Permasolid® HS surfacers	

intermediate sanding:	e	wet with P800 – 1000
		 Recoat with: Permasolid® HS Automotive Top Coat 275 (for small sanded-through spots only!) Permahyd® Base Coat 280/285/286 and Permasolid® HS clear coat (for small sanded-through spots only!)
ecial notes.		 Do not recoat with polyester products, epoxy products or waterborne products. Not suitable for application on thermoplastic paintwork. Cannot be dry sanded.
te on safety:		This product is classified according to regulation (EC) 1272/2008 (CLP). Please consult the Safety Data Sheet. It is strongly recommended to use appropriate personal protection equipment during application.
ta		

Data.

Flash point:

Special notes.

Note on safety:

VOC content: 2004/42/IIB(c)(780)760

Application as wash primer with

above +23°C

The EU limit value for this product (product category IIB.c) in ready to use form is max. 780 g/litre of VOC.

The VOC content of this product in ready to use form is max. 760 g/l.

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