

Technical Data Sheet.

Priomat® Elastic Primer 3304 transparent.

Priomat® Elastic Primer 3304 transparent is a versatile one-pack adhesion promoter for all plastic parts commonly found on vehicle exteriors.

This primer is characterised by excellent adhesion, high elasticity and easy application.

For professional use only!
VR Technical Data Sheet No. EN / 3304 / 03

Substrate.

Suitable substrates:

All plastic parts commonly found on vehicle exteriors (PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, PVC, PUR, PUR flexible foam, UP-GF).

Substrate pretreatment:

The substrate must be free of release agents.

Before cleaning plastic parts, heat them for 60 minutes at +60°C to let the release agents exude.



Clean with Priomat® Plastic Reducer 8581 or the milder Permaloid® Silicone Remover 7010.

The extent of cleaning required depends on the type and quantity of release agents present.

To facilitate the cleaning process, we recommend the use of a sanding pad (e.g. 3M 7448 or similar pad from different manufacturer).

Allow the reducer to evaporate completely (e.g. air dry overnight at ambient temperature or low bake for 30 - 40 minutes at +60°C).








Before applying the primer, clean lightly once more with Priomat® Plastic Reducer 8581 or Permaloid® Silicone Remover 7010 (antistatic effect).

Application.

Reducer:

Do not add reducer!

<p>Method of application:</p> <p>Application viscosity 4 mm, +20°C, DIN 53211:</p> <p>Reducer at +20°C material temperature:</p> <p>Spray nozzle*:</p> <p>Spray pressure*:</p> <p>Atomising pressure*:</p> <p>Number of coats:</p> <p>Flash-off time:</p> <p>Further steps.</p> <p>Surfacer:</p> <p>Recoat with:</p> <p>Special notes:</p>		Compliant	HVLP
		11 seconds	
		no reducer required (viscosity as supplied = application viscosity)	
		1.2 - 1.4 mm	1.3 - 1.5 mm
		2 - 2.5 bar	-
		-	0.7 bar
		1 full coat = 1 - 2 µm	
		10 minutes at +20°C ambient temperature	
<p>Permasolid® HS surfacer elastified with Permasolid® Elastic Additive 9050 (for application see Technical Data Sheet of the respective surfacer)</p> <ul style="list-style-type: none"> Permasolid® HS Automotive Top Coat 275 Permahyd® Base Coat 280/285/286 or Permahyd® Hi-TEC Base Coat 480 and Permasolid® HS Clear Coat <p>For elastification of the products see Technical Data Sheet.</p> <p>For countries outside the EU or usage other than vehicle refinishing: As an alternative, Permacron® Base Coat 293/295/297 or Permacron® MS Top Coat 730 / Top Coat 257 can be used if not banned by the VOC Directive 2004/42/EC and if available.</p>			

* See manufacturer's instructions!

Note 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.

Data.**Flash point:**

above +23°C

Storage.**Storage conditions:**

Storage temperature +20°C

(do not store at temperatures below +5°C)

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