

Technical Data Sheet.



Priomat® 1:1 Wash Primer 3688.

Priomat®1:1 Wash Primer 3688 is an acid-curing, two-pack adhesion promoter based on polyvinyl butyral from our "PVB-System".

- Specially developed to meet the needs of the commercial vehicles sector
- Promotes adhesion and serves to passivate metallic substrates
- Particularly suitable for aluminium and stainless steel
- It can be used in three-stage paint systems

Professional use only!

VR Technical Data Sheet No. 3688/04/2007-GB



Substrate.

Suitable substrates:

Aluminium
Unpolished stainless steel
Constructions made of different materials including steel
Electroplated/sendzimir galvanized steel sheets

Substrate pretreatment:

Depends on the substrate
– see Technical Data Sheet SYS_110.2

Application.

Mixing ratio:



1:1 by volume with
Priomat® Activator 3689

Potlife:

Ready for spraying 8 hours at +20°C
Mixed material must be used the same day.

Reducer:

Permacron® Reducer 6110 fast
(small objects +15-25 °C)

Permacron® Reducer 6120
(medium-sized objects at +20-25 °C)

Permacron® Reducer 6130 slow
(large objects at +20-30 °C)

Method of application:



High pressure/
Compliant

HVLP

Application viscosity 4 mm,
+20°C, DIN 53211:



15–16 seconds
ready for spraying after mixing

Reducer at +20°C material
temperature:



Permacron® Reducer 6110 or 6120 or 6130 slow
can be added if required.

Spray nozzle*:

1.3 -1.5 mm

1.3 - 1.5 mm

Spray pressure*:

1.5-3.0 bar

-

Atomising pressure*:

-

0.7 bar

Number of coats:



2 coats

Prescribed film thickness:

8 µm dry film thickness

* See manufacturer's instructions!

Special notes:

Do not recoat with Raderal® polyester products.
Do not recoat with Hepox epoxy products.

Do not recoat with Permasolid® HS Premium Surfacer 5310
or Permasolid® HS Spectro Flex 5400.

Drying.

Air drying:



At +20°C ambient temperature:

recoatable: 30-60 minutes

Recoating

For three-stage paint systems:

- 1 Permacron® Non-Sanding Surfacer 5510
Permasolid® HS Primer Surfacer 5520
Permacron® HS Bus Surfacer 5530
- 2 Permasolid® HS Top Coat Series 670/675
Permahyd® Base Coat Series 280/285 and
Permasolid® 2K clear coat

Data.

Viscosity as supplied:

At least 60 seconds

Flashpoint:

above +23°C

Solids content:

25.9 % by weight
14.4 % by volume

15.8 % by weight
8.3 % by volume

Specific weight:

0.96 g/cm³

0.92 g/cm³

Coverage:

at 8 µm dry film thickness

-

10.4 m²/l

VOC content:

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

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780 g/litre.

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume (ready for use). No allowance was made for wastage during application.

Storage.

Guaranteed shelf life:

6 months in sealed original containers

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose.

The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed.

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