

Technical Data Sheet

Priomat[®] Primer 3255 Red Brown

Priomat[®] Primer 3255 Red Brown is a based, zinc chromate free, single component product for car refinishing from our "PVB-system". The special composition of its pigment and binding agent enable it to offer 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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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 thoroughly with Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.



Mixing ratio:



50% Permacron® Reducer

Pot Life: Unlimited (in sealed container)

Reducer: Permacron® Dura Plus 8580, Permacron® Reducer 3363 Medium or Permacron® Reducer 3365 Slow
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	50%	
Number of coats	<ol style="list-style-type: none"> 1. 1.5 coat operation = 1 medium coat followed by 1 full coat without Intermediate flash-off time. 2. 2 coats with approx. 5 minutes intermediate flash-off. 3. 1 coat brushed (for weld through applications) 	

Recommended film thickness: 0.4 - 0.6 mil dry film thickness

Flash-off time:

At 68°F/ 20°C 15 – 20 minutes depending on reducer used.

Recoat With: Permacron® or Permasolid® Surfacer.

Special Tips:

1. 0.4 - 0.6 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 reversible 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 Surfacer 8590, Permasolid® Spectro Surfacer 5400, or Permasolid® HS Premium Surfacer Plus 5310. (Sand if needed.)
 - c) Topcoat
7. May be brushed on for use as a weld through primer.

Important Regulatory Information

VOC Category	VOC Regulatory and Actual	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
1 Liter-Pretreatment Coating	751 g/l, 747 g/l	1014 g/l	76.5%, 0.5%, & 0.0%	0.5%
Aerosol-California Aerosol Coatings: Auto Body Primer	VOC% = 57.5% PVMIR = .58	769 g/l	86.1%, 0.3%, & 28.3%	27.8%

- **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. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. 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.**
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