

Technical Data Sheet.

Permacron® 1:1 Elastic Primer Surfacer 3300

Permacron® 1:1 Elastic Primer 3300 is a high-grade 2K primer surfacer for plastic parts.

- good adhesion on all plastics commonly used for passenger cars
- can be applied wet-on-wet
- efficient paint system
- easy handling
- very long application time

For professional use only!
VR Technical Data Sheet No. EN / 3300 / 01

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 (3M 7448 or similar polishing compound from a 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 surfacer, clean lightly once more with Priomat® Plastic Reducer 8581 or Permaloid® Silicone Remover 7010 (antistatic effect).

Application.






Mixing ratio:



1:1 by volume with Permacron® Elastic Hardener 3301

Pot life: (ready for use)

At +20°C ambient temperature: 7 - 9 hours

Method of application:		Compliant	HVLP
Application viscosity 4 mm, +20°C, DIN 53211:		16 - 18 seconds	
Reducer at +20°C material temperature:		none (ready for use after hardener has been added)	
Spray nozzle*:		1.3 - 1.4 mm	1.4 - 1.5 mm
Spray pressure*:		2 - 2.5 bar	-
Atomising pressure*:		-	0.7 bar
Number of coats:		1 spray operation = apply one tack coat, followed by a full coat	
Recommended film thickness:		25 - 30 µm dry film thickness	
Flash-off time:		15 - 20 minutes at +20°C ambient temperature	

Drying.

Air drying:



At +20°C ambient temperature:

Can be recoated wet-on-wet after 15 - 20 minutes
(max. 24 hours) with a suitable top coat.

Special note:

If required, Permacron® 1:1 Elastic Primer Surfacer 3300 can be sanded lightly with wet sanding paper P800 - 1000 after low baking for 30 minutes at +60°C metal temperature or air drying for 2 hours at +20°C ambient temperature.

Further steps.

Special notes:

Any defects in the substrate can be treated with Raderal® Fine Putty 0911 after Permacron® 1:1 Elastic Primer Surfacer 3300 has dried.

Putty spots must be isolated with Permacron® 1:1 Elastic Primer Surfacer 3300 before the top coat can be applied.

* See manufacturer's instructions!

Recoat with:

- Permasolid® HS Automotive Top Coat 275
- Permahyd® Base Coat 280/285/286 and Permasolid® HS clear coat

For elastification of Permasolid® HS Automotive Top Coat 275 and of the clear coats, see System Data Sheet "Paint System for Plastic Parts" (System Data Sheet No. SYS 903.1).

Special notes:

Coated plastic parts should not be washed with a high-pressure jet cleaner within the first 6 weeks. After this period, the nozzle must be held at a distance of no less than 30 cm from the object.

Special notes:

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.

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:

+23 °C

Storage.

Storage conditions:



Permacron® 1:1 Elastic Primer Surfacer 3300
Storage temperature +20°C

Elastic Hardener 3301

Storage temperature +20°C

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

If it has been exposed to frost, the hardener must first be heated up to +20°C before it is ready for use.

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