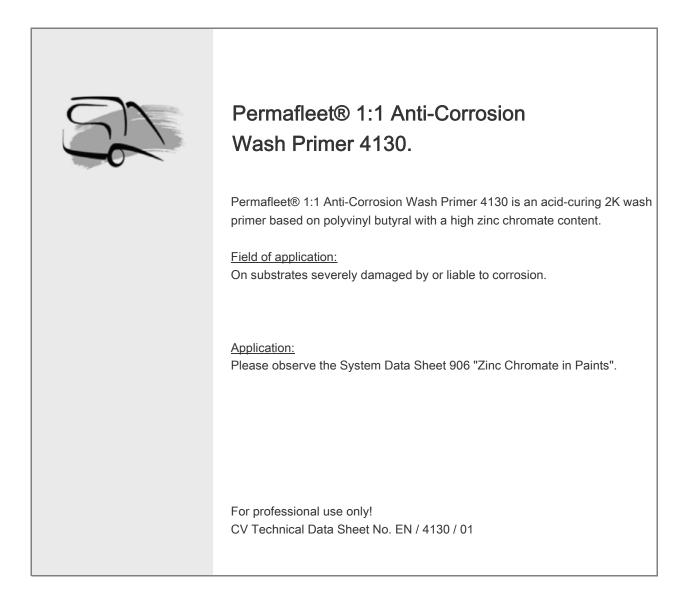
# Technical Data Sheet.





### Substrate.

Suitable substrates:

Substrate pretreatment:

#### 1. steel

- 2. electroplated / roller galvanised steel panels or soft aluminium, cleaned and sanded.
- 3. lightly sanded factory primer
- 4. well sanded old or original paintwork. (except thermoplastic paintwork)
- 5. Surfaces treated with Raderal® 2K polyester products and then finely sanded.



Steel, electroplated / roller galvanized steel panels or soft aluminium - degrease and sand lightly.



Factory primer - clean and sand lightly.



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.

## $\Box$

1:1 by volume with Permafleet® Activator 3690

or add 87 g activator per 100 g wash primer

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

8 – 10 µm dry film thickness

Application.

Mixing ratio:

Pot life:

Prescribed film thickness:

<b>~</b>	High pressure/ Compliant	Suction feed	HVLP	Pressure pot
[]s	15 – 16 seconds ready for spraying after mixing			
	1.3 - 1.5 mm	1.5 - 1.7 mm	1.3 - 1.5 mm	1.0 - 1.1 mm
	4 - 5 bar	4 - 5 bar		3 - 4 bar
	-		0.7 bar	1 - 2 bar
Ę	2 coats			
	approx. 8 µm dry film thickness			

 $\bigcirc$ 

at +20°C ambient temperature recoatable: 30 r

30 minutes



After flash-off at +20°C with: Permafleet® HS surfacers

Permafleet® HS Top Coat 670/675 Permahyd® Base Coat 280/285 and Permafleet®/Permasolid® HS clear coat

1. Concealed contact points (e.g. at fittings and hinges) do not have to be recoated.

2. Do not recoat with Raderal® polyester products.

- 3. Do not recoat with epoxy products.

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.

Method of application:

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

Spray nozzle\*:

Spray pressure\*:

Atomising pressure\*:

Number of coats:

Prescribed film thickness:

## Drying.

Air drying:

## Recoating.

Recoatable:

Then recoat with:

Special notes:

Note on safety:

Data.			
Viscosity as supplied:	at least 60 seconds		
Flash point:	below +21°C		
	1:1 Anti-Corrosion Wash Primer 4130	Mixed	
Solids content:	30.2 % by weight	19.1 % by weight	
(without reducer)	19.3 % by volume	11.0 % by volume	
Specific weight:	0.96 g/cm <sup>3</sup>	0.90 g/cm <sup>3</sup>	
Coverage*:	-	13.8 m²/l	
at 8 µm dry film thickness			
<b>VOC content:</b> 2004/42/IIB(c)(780)730	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. 730 g/l.		
* The coverage was calculated on the basis of the r	ecommended dry film thickness and the solids content	by volume (without reducer). No	

\* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume (without reducer). No allowance was made for wastage during application.

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