

## 222S

27.08.2014

### ADHESION PROMOTER

#### DESCRIPTION

A ready-to-spray adhesion promoter for use over OEM clearcoat finishes.

#### PRODUCTS

222S          Adhesion Promoter

#### PROPERTIES

- A ready-to-spray transparent adhesion promoter for use over OEM clearcoat finishes used on most clear over base finishes.  
Is designed to be used with Axalta Topcoats.

#### SUBSTRATES










- Cleaned and sanded OEM finishes.
- Cleaned and sanded cured repaired finishes.
- Cleaned and sanded 131S Fill 'n' Sand 1K Acrylic Primer
- Cleaned and sanded 1040R, 4004S, LE Primer Plus, 1052R, 1056R.

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### PRODUCT PREPARATION

	<b>Mixing Ratio</b>	Ready for use		
	<b>VOC</b>	790 g/l		
	<b>Pot life at 20°C</b>	Not applicable		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	16 – 18 s 16 – 18 s 19 – 20 s	
	<b>Spray equipment</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	<b>Fluid tip</b>	<b>Distance</b>
			1.4- -1.6 mm 1.6 – 1.8 mm 1.3 – 1.5 mm 1.0 – 1.2 mm	15 – 20 cm 15 – 20 cm 10 – 15 cm 15 – 20 cm
	<b>Spray pressure</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	2 – 2.5 bar 2.5 – 3 bar 0.7 bar at nozzle 3 – 4 bar	
	<b>Number of coats</b>	1 coat maximum		
	<b>Flash time at 20°C</b>	15 min before topcoating		
	<b>DFT</b>	15 – 20 µm		
	<b>Drying</b>	15 min to 1 h maximum after 1 h recoat Detail sanding (after flash time) Wet: P800 – P1000 Dry: P360 – P400		
	<b>IR Drying</b>	Not recommended		
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.				

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#### SURFACE PREPARATION

1. Clean surface with water and soap.
2. Degrease with correct preparatory cleaner and wipe dry with clean Sontara® wipes.
3. Repair according to damage.
4. Wet sand with P1000 and prepare any blend areas with P1500 or a white scotch pad & flattening paste.
5. Degrease with a correct final cleaner and wipe dry with clean Sontara® wipes.
6. Tack wipe.
7. Apply basecoat Centari® 600 or Centari® 6000 and blend out. Finish with DuPont 1K/2K clear.

#### RECOATABILITY

At any time after tape-free time.

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

#### CHEMICAL RESISTANCE

When fully cured, 222S is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20%	battery acid
sulphuric acid	25%	toluene
hydrochloric acid	20%	xylene
phosphoric acid	20%	glycol
ammonia	10%	brake fluid, petrol

#### SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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#### REMARKS

- 222S should not be used in place of primer when painting OE parts. PowerTints®.
- When painting replacement OE parts use the recommended Axalta Primer.
- Does not require a topcoat clear beyond the blend-out zone.  
222S must not be used as a clearcoat to protect pigment.  
Be sure to apply 222S to areas where colour/clear will be blended.
- To assist in laydown of metallics, apply 222S to panel as an antistatic coat and allow flash
- Reduces sand scratch swell marks.
- Material has to be at room temperature (18-25°C) before use.

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All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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