

## 635R

27.08.2014

### CHROMATE FREE ETCHING PRIMER

#### DESCRIPTION

2-component clear to be used in clear over base system.  
Composition based on acrylic copolymer.

#### DESCRIPTION

Acid reactive zinc chromate-free two package etching primer.  
Composition based on polyvinyl butyral resin.

#### PRODUCTS

635R	Chromate Free Etching Primer
636R	Etching Activator Thinner

#### PROPERTIES

- Very good corrosion resistance.
- Excellent adhesion.
- Excellent etching properties on all ferrous metal and light alloys and is recommended as first coat of a primer/surfacer/topcoat system.
- Can be coated with 2K surfacers.
- VOC compliant, conform with directive 2004/42/EC.

#### SUBSTRATES







- Bare metals: steel, aluminium and galvanised steel.
  - OEM finishes\*.
  - Cured repair finishes.
- \* Not recommended to repair thermoplastic acrylic finishes.

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### PRODUCT PREPARATION

	<b>Mixing ratio</b>	635R 636R	<b>Volume</b>		<b>Weight</b>
			1	1	100 90
<b>VOC</b>		780 g/l			
	<b>Pot life at 20°C</b>	8 hr in non-metallic container.			
	<b>Spray viscosity at 20°C</b>	<b>DIN 4 FORD 4</b>	16-23 s 19-26 s		
	<b>Spray equipment</b>	<b>Compliant guns</b> Gravity feed Suction feed Pressure feed	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
			1.2-1.4 mm	15 cm	According to supplier's specifications
			1.4-1.6 mm	15 cm	
		1.0-1.2 mm	15 cm		
		<b>Conventional guns</b> Gravity feed Suction feed Pressure feed	1.2-1.5 mm	20-25 cm	2-2.5 bar
			1.4-1.8 mm	20-25 cm	2-2.5 bar
1.0-1.2 mm	20-25 cm		2-2.5 bar		
	<b>Number of coats</b>	1			
	<b>Flash time</b>	30 min before recoating - till 48 hr maximum. Do not use if RH > 80 %.			
<b>DFT</b>		8-10 µm			
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

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a preparatory cleaner for bare metals.  
Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
  - a. mechanical with P280 - P320;
  - b. wet with P600.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser.  
Wipe dry with a clean cloth.

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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#### REMARKS

- Activated material should not be returned to original can of non-activated material.
- Do not use polyester putty or epoxy primer-surfacer over 635R. Hardening and adhesion of polyester and epoxy products will be affected.
- 636R and activated material contain acid. Do not store in metal container.
- Do not sand 635R.
- Do not use if relative humidity is above 80 %.
- Close can of activator thinner tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

#### PRODUCT DATA

Package viscosity:	125 s AFNOR 4 at 20°C
Theoretical coverage:	8.8 m <sup>2</sup> /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	2004/42/IIB(c)(780)780: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 780 g/l.

#### SAFETY

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

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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