



Effective 15 July, 2010

# 635R

## ETCHING PRIMER

### Description

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

### Products

635R	Etching Primer
636R	Activator Thinner

### Properties

- Very good corrosion resistance.
- Excellent adhesion.
- Excellent etching properties on all ferrous metal and light alloys and is recommended as 1<sup>st</sup> coat for 3-coats systems.
- Can be coated with DuPont 2K filling primers.

### Substrates

- bare metals, steel, aluminium, galvanised steel
  - OEM finishes\*
  - cured repaired finishes
- \* not recommended to repair thermoplastic acrylic finishes



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### PRODUCT PREPARATION

	<b>Mixing ratio</b>	635R	<b>Volume</b>	<b>Weight</b>
		636R	1	100
			1	90
	<b>VOC</b>	771 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</b>	16-23 s	
		<b>FORD 4</b>	19-26 s	
	<b>Spray equipment</b>		<b>Fluid tip</b>	<b>Distance</b>
		<b>Gravity feed</b>	1.2-1.5 mm	20-25 cm
		<b>Suction feed</b>	1.4-1.8 mm	20-25 cm
		<b>HVLP</b>	1.2-1.4 mm	15 cm
		<b>Pressure feed</b>	1.2 mm	20-25 cm
	<b>Spray pressure</b>	<b>Gravity feed</b>	3-4 bar	
		<b>Suction feed</b>	3-4 bar	
		<b>HVLP</b>	0.7 bar at nozzle	
		<b>Pressure feed</b>	4-6 bar	
	<b>Number of coats</b>	1		
	<b>Flash time</b>	30 min before applying 2K filling primers - till 48 hr maximum. Do not use if RH > 80 %.		
	<b>DFT</b>	8-10 µm		
<p>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.</p>				



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### RECOMMENDED USE

#### Surface preparation

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

- Clean substrate with 3608S using clean Sontara® wipes.
- Sand and eliminate all rust or corrosion.
- Clean with 3920S using clean Sontara® wipes.
- Before priming, wipe dry using clean Sontara® wipes.

OEM and cured repaired finishes

- Clean surface with water and soap. Rinse and dry.
- Degrease with 3919S. Wipe dry using clean Sontara® wipes.
- Wet sand with P600 or dry sand with P280 - P320.
- Clean with 3920S using clean Sontara® wipes.
- Before priming, wipe dry using clean Sontara® wipes.

#### Equipment cleaning

Use 3608S.



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### RECOMMENDED USE (con'd)

#### Remarks

- Activated material should not be returned to original can of non-activated material.
- Do not use polyester putty over 635R. Hardening and adhesion of polyester putty 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 %.
- Do not recoat with epoxy primer.
- Close can of 636R 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

Products	Packages (l)	Shelf life at 20°C (year)
635R	4	2
636R	4	2

#### Safety

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