

## 825R

27.08.2014

### CHROMATE FREE WASH PRIMER-SURFACER

#### DESCRIPTION

Zinc chromate-free 1K etching primer-surfacer.  
Colour: off white.  
Composition based on polyvinyl butyral resin.

#### PRODUCTS

825R	Chromate Free Wash Primer-Surfacer
XB383	Standard Thinner
XB387	HI-Temp Thinner

#### PROPERTIES

- Very good corrosion and blistering resistance.
- Very mild, eliminates lifting, sand scratches and swelling.
- Good filling properties. Used as etching primer-surfacer.
- Excellent etching properties on metals and is recommended as adhesion promotor.
- Can be coated with 2K surfacers or solventborne topcoats.
- Can be tinted with AM Centari® MasterTints® (up to max. 5 % by weight).
- Can be used to isolate small sand throughs prior to application of waterborne basecoats
- VOC compliant, conform with directive 2004/42/EC.

#### SUBSTRATES





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

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#### PRODUCT PREPARATION

	<b>Mixing ratio</b>	825R XB383 XB387	<b>Standard</b>		<b>Large surface/High temp.</b>	
			Volume	Weight	Volume	Weight
			2	100	2	100
			1	39	-	-
			-	-	1	39
	<b>VOC</b>	760 g/l				
	<b>Pot life at 20°C</b>	5 days				
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	19-21 s 20-22 s 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>	
			1.3-1.5 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	1.3-1.5 mm	20-25 cm	2-2.5 bar	
			1.4-1.8 mm	20-25 cm		
1.0-1.2 mm	20-25 cm					

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

- Reduced material should not be returned to original can of unreduced material.
- Do not use polyester putty or epoxy primer-surfacer over 825R. Hardening and adhesion of polyester and epoxy products will be affected.
- Adhesion and flow problems will occur with reduced material older than 5 days.
- Material has to be at room temperature (18-25°C) before use.
- ValueShade® 2 (VS2) is equal to 100 % of 825R.  
ValueShade® 3 (VS3) can be obtained by adding 2 g of AM5 to 100 g of 825R.  
ValueShade® 4 (VS4) can be obtained by adding 5 g of AM5 to 100 g of 825R.

#### PRODUCT DATA

Package viscosity:	2300-2700 cp
Theoretical coverage:	5.1-10.1 m <sup>2</sup> /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	2004/42/IIB(c) (780)760: 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 760 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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