



Priomat® 1K Primer Surfacer 4085



GENERAL

DESCRIPTION

A zinc chromate-free one component product from our “PVB-System.” Priomat® 1K Primer Surfacer 4085 is recommended for cars requiring wet-on-wet finishes on small areas or finishes with intermediate sanding. Priomat 1K Primer Surfacer 4085 is easy to use and apply and offers reliable adhesion and corrosion protection. Priomat 1K Primer Surfacer 4085 may also be used as a weld-through primer.

Both a sprayable and aerosol version of Priomat 1K Primer Surfacer 4085 is available in light gray and dark gray.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Priomat 1K Primer Surfacer 4085

REDUCERS

Permacron® Dura Plus 8580,
Permacron Reducer 3363 Medium, or
Permacron Reducer 3365 Slow

For optimum reducer selection, refer to Technical Data Sheet No. 780.0

MIX RATIO

Component	Volume
4085	1
8580 / 3363 / 3365	+50%

APPLICATION VISCOSITY

18 - 20 seconds at 68°F/20°C, DIN 4

POT LIFE

Unlimited (in a sealed container).

SPECIAL TIPS

1. 0.3 mil dry film thickness is necessary for adequate corrosion resistance.
2. **Metal substrates must be primed within one half-hour of sanding or re-sanding is required.**
3. All traces of rust must be removed before applying Priomat 1K Primer Surfacer 4085.
4. Do not recoat with polyester or epoxy products.
5. Do not use on reversible finishes.
6. We recommend the following three-stage system:
 - a. Prime with Priomat Primer 4085.
 - b. Apply 2K Permasolid® Surfacer.
 - c. Apply Topcoat.
7. Once Priomat 1K Primer Surfacer 4085 has been applied at a film thickness of 1.0 – 1.2 mils, the repair area must be primed within a week's time or re-sanding or re-application of an additional layer of Priomat 1K Primer Surfacer 4085 is required.



8. *Priomat 1K Primer Surfacer 4085 can be top-coated directly on small areas such as sand-throughs.
9. Do not apply seam sealer or chip guard directly to 4085 or other 1K products.



APPLICATION

SUBSTRATES

Sanded Bare Steel
 Sanded Galvanized (cut-through)
 Sanded Aluminum (cut-through)
 Sanded E-Coat
 Original or old paintwork (except reversible substrates, Example: lacquer)

SURFACE PREPARATION

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with:
 - Permaloid® Silicone Removers 7087 or 7010 Slow, Permahyd® Silicone Removers 7085, 7086 or 7096.
 - Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

SPRAYGUN SETUP

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- Option 1: Apply 1 medium coat followed by 1 full coat without intermediate flash-off.
- Option 2: Apply 2 coats with approximately 5 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

1.5 coats for 0.7 – 1.0 mil dry film thickness
 2 coats for 1.1 – 2.0 mils dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C:	10-15 minutes to maximum 2 hours (Depending on reducer selected)
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Dry to Sand:	45-60 minutes
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DRY SANDING

Sanding:	P500 – 800
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RECOAT

With Permasolid Surfacers



PHYSICAL PROPERTIES

Coating Category: Primer
 Max. VOC (AP): 738 g/l; 6.2 lbs/gal
 Max. VOC (LE): 741 g/l; 6.2 lbs/gal
 Avg. Gallon Weight: 1017.6 g/l; 8.5 lbs/gal
 Avg. Weight % Volatiles: 72.9 %
 Avg. Weight % Water: 0.4%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.4%
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 208.6 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 104 - 297 sq. ft.

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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