



# 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

- 0.3 mil dry film thickness is necessary for adequate corrosion resistance.
- Metal substrates must be primed within one half-hour of sanding or re-sanding is required.**
- All traces of rust must be removed before applying Priomat 1K Primer Surfacer 4085.
- Do not recoat with polyester or epoxy products.
- Do not use on reversible finishes.
- We recommend the following three-stage system:
  - Prime with Priomat Primer 4085.
  - Apply 2K Permasolid® Surfacer.
  - Apply Topcoat.
- 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)
- Axalta™ Etch Primer 420
- Axalta™ Etch Primer Low VOC 425
- Axalta™ Metal Treatment Wipes 495

**SURFACE PREPARATION**

1. Thoroughly clean surface as per Axalta™ Silicone Remover TDS
2. Use a scuff pad first to scuff areas to be primed where sanding with DA is not possible
3. Use a DA sander to featheredge OEM paint at the repair area
4. Use P180 sandpaper to remove any straight line scratches
5. Begin featheredge process by stepping through P240, P320, and finish with P600 making sure to remove the previous grit's sand scratches
6. Be sure to sand 6-8" beyond featheredge for proper primer adhesion
7. Clean the surface as per Axalta™ Silicone Remover TDS

**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)

Dry to Sand: 45-60 minutes

**DRY SANDING**

Sanding: P500 – 800



**RECOAT WITH ITSELF**

After sanding

**OVERCOAT**

With Permasolid surfacers

**TOPCOAT**

Topcoat with Permacron Base Coat Series 293/295 or Permahyd Hi-TEC 480 after applying appropriate Permasolid or Permahyd sealer per TDS.



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**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.

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**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.

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**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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