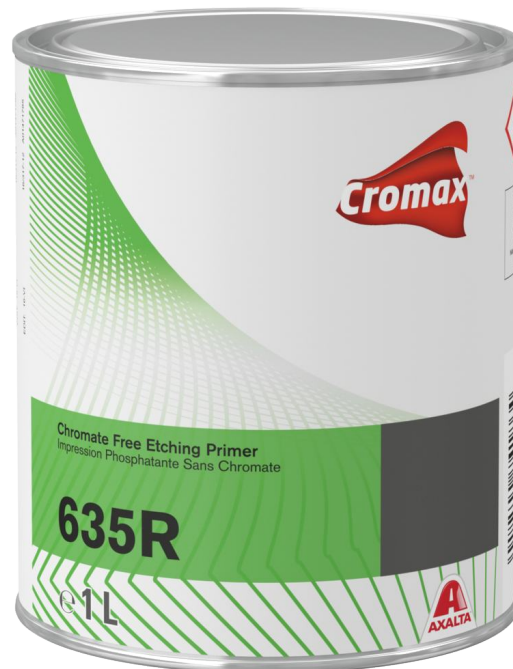


635R

CHROMATE FREE ETCHING PRIMER



PRODUCT DESCRIPTION

Chromate-Free Etching Primer 635R is a 2K etching primer approved by several leading car manufacturers. It can be coated with 2K Cromax surfacers.

Approval primer

FEATURES

- 01** Recommended as the first coat of a primer/surfacer/topcoat system from Cromax.
- 02** Has very good corrosion resistance.
- 03** Offers excellent adhesion and etching properties on all ferrous metal and light alloys.
- 04** Can be coated with 2K surfacers from Cromax.

TECHNICAL DATA SHEET



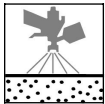
635R

CHROMATE FREE ETCHING PRIMER

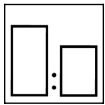
Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanised steel or soft aluminium sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
Old or original paintwork well sanded and cleaned



M-6148

	Standard	
	Volume	Weight
635R	1	100
636R	1	89

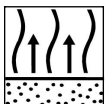


Pot life at 20°C: 8 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4 mm	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.5 mm	0.7 bar	atomisation pressure

see manufacturer's instructions

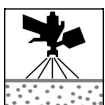


1 - 2 coats

with intermediate flash-off: 5 min - 10 min
final flash-off: 30 min



	636R
20 °C	30 min



2K Surfacer

VOC compliant

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.

TECHNICAL DATA SHEET

635R



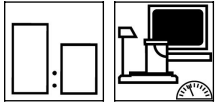
CHROMATE FREE ETCHING PRIMER

Products

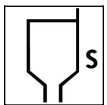
635R Chromate Free Etching Primer

636R Etching Activator Thinner

Product mix



Mixing ratios with special agents are available in the productmix table on ChromaWeb and in the specific TDS.



DIN 4: 16 - 18 s at 20°C



8 - 10 µm



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Do not recoat with polyester-, epoxy- or waterborne products.
- Only use plastic or inner coated metal cans.
- Maximum time before overcoating is 48 hours.
- Not suitable for application on thermoplastic paintwork.
- Do not use if RH >80%.
- Close can of Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.

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

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.