

# 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**

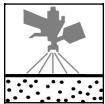


## CHROMATE FREE ETCHING PRIMER

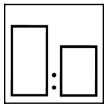
### Product preparation - application STANDARD



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
<b>635R</b>	1	100
<b>636R</b>	1	90

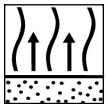


Pot life at 20°C: 8 hr



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.3 - 1.4	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions

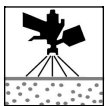


1 - 2 coats

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



	<b>636R</b>
<b>20 °C</b>	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.

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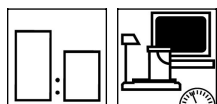
## CHROMATE FREE ETCHING PRIMER

### Products

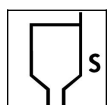
635R Chromate Free Etching Primer

636R Etching Activator Thinner

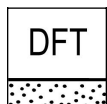
### Product mix



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

#### Theoretical coverage

90 m<sup>2</sup>/l at 1 micron dry film thickness

Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



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.
- Only use plastic or inner coated metal cans.
- Maximum time before overcoating is 48 hours.
- Not suitable for application on thermoplastic paintwork.
- Mix thoroughly by hand before placing the can on mixing machine.
- Do not recoat with polyester-, epoxy- or waterborne products.
- 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.

# TECHNICAL DATA SHEET

**635R**



## CHROMATE FREE ETCHING PRIMER

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.

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