



Effective 8 January, 2008

825R

WASH PRIMER SURFACER

Description

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

Products

825R	Wash Primer Surfacer
XB383	Standard Thinner
XB387	High Temperature 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 DuPont Refinish 2K surfacers or DuPont Refinish 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 Cromax[®].
- VOC compliant, conform with directive 2004/42/EC.

Substrates

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

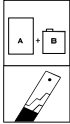








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PRODUCT PREPARATION

	Mixing ratio	Standard		Large surface/High temp.	
		Volume	Weight	Volume	Weight
	825R XB383 XB387	2 1 -	100 39 -	2 - 1	100 - 39
	VOC	710 g/l			
	Pot life at 20°C	5 days			
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	19-21 s 20-22 s 22-24 s		
	Spray equipment		Fluid tip	Distance	Pressure
		Conventional guns			
		Gravity feed	1.3-1.5 mm	20-25 cm	3-4 bar
		Suction feed	1.4-1.8 mm	20-25 cm	3-4 bar
		Pressure feed	1.0-1.2 mm	20-25 cm	3-4 bar
		Compliant guns (HVLP/HTE)			
Gravity feed	1.3-1.5 mm	15 cm	According to supplier's specifications		
Suction feed	1.4-1.6 mm	15 cm			
Pressure feed	1.0-1.2 mm	15 cm			
	Number of coats	1-2			
	Flash time	Between coats till flat. 15 min before recoating - till 8 hr maximum.			
	DFT	15 µ/coat			
	Dry to sand at 20°C at 40°C at 60°C	1 hr 40 min 15 min			
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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RECOMMENDED USE

Surface preparation

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a DuPont Refinish 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 DuPont Refinish 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 DuPont Refinish 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 DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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RECOMMENDED USE (con'd)

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 m²/l at recommended DFT - ready-to-spray
Directive 2004/42/EC: 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 710 g/l.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
825R	1 - 3.5	2	1.112
XB383	1 - 5 - 20	2	0.847
XB387	1 - 5	2	0.867

Safety

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