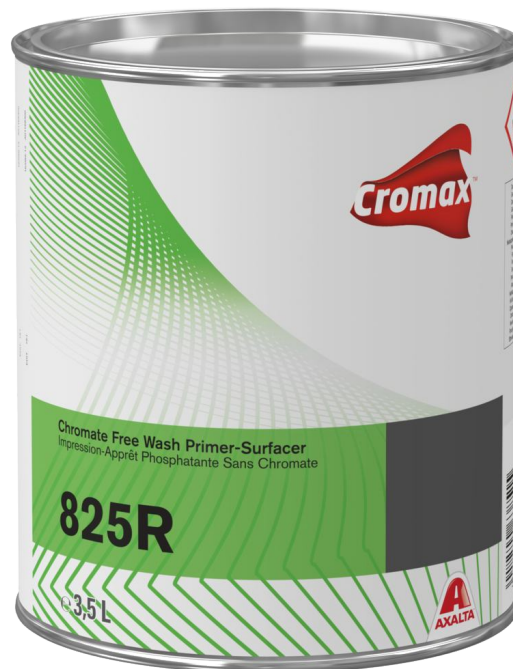


# 825R

# CHROMATE FREE WASH PRIMER-SURFACER



## PRODUCT DESCRIPTION

Chromate Free Wash Primer-Surfacer 825R Off White is a universal, VOC-compliant 1K wash primer-surfacer. It is a versatile and chromate-free, and can be used as an etching or filling wash primer. Chromate Free Wash Primer-Surfacer 825R is available in ValueShade 2 (off white) and can be darkened to ValueShade 4 (medium grey) when required.

## Chromate-free wash primer-surfacer



Developed by Cromax®, ValueShade® delivers the optimal undercoat for every topcoat colour.

## FEATURES

- 01** Has very good corrosion and blistering resistance.
- 02** Helps to eliminate lifting, sand scratches and swelling.
- 03** Can be used to isolate small sand-throughs before application of waterborne basecoats.
- 04** Provides good filling properties together with excellent etching properties on metals.
- 05** Works with standard Cromax thinners.
- 06** Suitable for tinting with AM Centari MasterTints, up to maximum 5% by weight.
- 07** Can be coated with 2K surfacers or solventborne topcoats.
- 08** Helps to improve productivity.

# TECHNICAL DATA SHEET



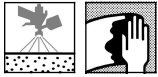
## 825R

## CHROMATE FREE WASH PRIMER-SURFACER

### Product preparation - application STANDARD NON-SANDING



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



M-6149

	VS2	VS3	VS4
825R	100	100	100
AM5	-	2	5

	Standard		Large surface	
	Volume	Weight	Volume	Weight
825R	2	100	2	100
XB383	1	38	-	-
XB387	-	-	1	39



Pot life at 20°C: 5 days



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

see manufacturer's instructions



	Primer	Primer-surfacer
1 coat	final flash-off: 10 min - 15 min	1 - 2 coats with intermediate flash-off: 5 min final flash-off: 15 min - 8 hr



	Primer	Primer-surfacer
2K Surfacer		Centari 2K Topcoats Centari Basecoats + Clearcoat

VOC compliant

2004/42/IIB(c)(780) 760: 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 760 g/l.

# TECHNICAL DATA SHEET



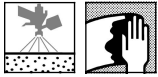
**825R**

## CHROMATE FREE WASH PRIMER-SURFACER

### Product preparation - application STANDARD SANDING



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



M-6149

	VS2	VS3	VS4
<b>825R</b>	2	100	100
<b>AM5</b>	-	2	5

	Standard		Large surface	
	Volume	Weight	Volume	Weight
<b>825R / AM5</b>	2	100	2	100
<b>XB383</b>	1	38	-	-
<b>XB387</b>	-	-	1	39



Pot life at 20°C: 5 days



	Spray nozzle	Spray pressure	
<b>Compliant</b>	1.4 - 1.5 mm	1.8 - 2 bar	inlet pressure
<b>HVLP</b>	1.5 - 1.6 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats  
with intermediate flash-off: 5 min  
before bake: 8 min - 10 min



	XB383
<b>20 °C</b>	1 hr
<b>60 - 65 °C</b>	15 min



P500 - P600



Centari 2K Topcoats  
Centari Basecoats + Clearcoat

VOC compliant

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# TECHNICAL DATA SHEET

## 825R



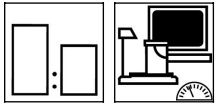
## CHROMATE FREE WASH PRIMER-SURFACER

### Products

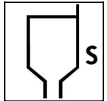
825R Chromate Free Wash Primer-Surfacer  
AM5 Centari® MasterTint® Jet Black

XB383 Standard Thinner  
XB387 HI-Temp Thinner

### Product mix



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



DIN 4: 18 - 20 s at 20°C



15 µm per coat



Clean after use with a suitable solventbased guncleaner.

### Remarks

- Only use plastic or inner coated metal cans.
- Dry sanding only allowed for lightly denibbing.
- Do not recoat with polyester-, epoxy- or waterborne products.
- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Not suitable for application on thermoplastic paintwork.
- Can be used to isolate small sand throughs (not bigger than Ø 5 cm) prior to application of waterborne basecoats.
- Maximum time before overcoating is 8 hours.

# TECHNICAL DATA SHEET

**825R**



## CHROMATE FREE WASH PRIMER-SURFACER

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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