PRIMERS

CHAMÄLEON



2K WASH/ ETCH PRIMER
404



1K PLASTIC PRIMER/ ADHESION PROMOTER
409



1K PRIMER FAST
422



2K PRIMER
444



2K EPOXY PRIMER
455



2K ALL-IN-ONE PRIMER
466



2K WET ON WET PRIMER
467



2K FILLING PRIMER HS
488



2K EXPRESS PRIMER
499

PARAMETERS

	404	409	422	444	455	466	467	488	499
Mixing ratio	2:1 (on large surfaces 1:1)	-	-	4:1	2:1	4:1	5:1	5:1	4:1
Hardener	204	-	-	288	255	266	288	288	299
Addition of thinner*	-	-	50 - 70%	10 - 15%	not necessary	5 - 20% (sanding filler) 15 - 40% (wet-on-wet)	25 - 35%	20 - 30 % (sanding filler) 30 - 40 % (wet-on-wet)	0 - 10%
Colour	yellow-green	transparent - silver	grey	black, grey, white; mixable to achieve any grey shade	light grey	grey	light grey	black, grey, white, red; mixable to achieve any grey shade	black, grey, white; mixable to achieve any grey shade
Purpose/use	chromate-free 2K acid primer with excellent adhesion and active corrosion protection, especially for aluminium	adhesion promoter for most automotive synthetic parts; forms a barely visible, slightly matt surface and requires no further processing after application	fast-drying 1K primer with excellent filling and hiding power	high-filling, easy-to-sand 2K primer with excellent adhesion and corrosion protection, suitable for spot repairs	chromate-free 2K epoxy primer with high moisture and chemical resistance, suitable under polyester body fillers and spray fillers	multi-purpose 2K DTM primer combining sanding, wet-on-wet and plastic filler properties; no sanding required on intact cataphoretic coatings	2K wet-on-wet non-sanding primer with excellent universal adhesion; direct application on metal, plastic substrates and intact e-coatings	easy-to-sand 2K primer with excellent filling capacity, high corrosion resistance and good adhesion, suitable for spot repairs without sagging or edge formation	fast-drying 2K express filling primer with excellent adhesion to bare metals, sandable after only 60 min at room temperature, ideal for spot repairs
Consumption	8 - 10 m²/l	8 - 10 m²/l	5 - 7 m²/l	5 - 6 m²/l	9 - 10 m²/l	5 - 6 m²/l	14.5 - 15 m²/l	5 - 6 m²/l	6 - 8 m²/l
Spraying viscosity 4 mm DIN	15 - 18 s	12 - 15 s	15 - 20 s	30 - 55 s	16 - 22 s	20 - 30 s (sanding filler) 15 - 20 s (wet-on-wet/plastic filler)	16 - 18 s	30 - 55 s	20 - 30 s
HVLP	1.6 - 2 bar	1.6 - 2 bar	1.6 - 2 bar	1.6 - 2 bar	1.6 - 2 bar	1.6 - 2 bar	1.6 - 2 bar	2 - 2.5 bar	1.6 - 2 bar
Pressure/Nozzle	1.2 - 1.5 mm	1.2 - 1.4 mm	1.3 - 1.6 mm	1.3 - 2 mm	1.3 - 1.6 mm	1.2 - 1.8 mm	1.3 - 1.5 mm	1.5 - 1.9 mm	1.3 - 1.8 mm
Number of coats	1 - 1.5	1	2 - 3	1 - 3	1 - 2	1 - 3	1	1 - 3	1 - 2
DFT	10 - 15 µm	3 - 5 µm	20 - 40 µm	60 - 180 µm	25 - 50 µm	20 - 30 µm (plastic filler) 40 - 60 µm (wet-on-wet) 60 - 180 µm (sanding filler)	20 - 30 µm	60 - 180 µm	50 - 100 µm
Flash-off time	-	-	5 min	5 - 8 min	5 - 8 min	5 - 8 min	-	5 - 8 min	2 - 5 min
Pot life	12 h	-	-	2 h	5 h	1 h	2 h	1 - 3 h	45 min
Drying time 20 °C	30 min	10 min	45 min	3 - 5 h	30 - 45 min	4 - 5 h	15 - 20 min	3 - 5 h	1 h
60 °C	not recommended		15 - 20 min	30 - 40 min	30 min	30 - 40 min		30 - 40 min	10 - 15 min
IR	8 min		8 min	8 min	8 min	8 min		8 min	5 min
Wet-on-wet	+	+	-	-	+	+	+	+	-
Sanding	-	-	P400 - P600 (dry) P600 - P1000 (wet)	P400 - P600 (dry) P600 - P1000 (wet)	P400 - P500 (dry) P600 - P1000 (wet)	P400 - P500 (dry) P500 - P800 (wet)	-	P400 - P500 (dry) P500 - P800 (wet)	P400 - P600 (dry) P600 - P1000 (wet)

SUBSTRATES

	404	409	422	444	455	466	467	488	499
old paint coating			●	●	●	●	●	●	●
polyester putties			●	●	●	●	●	●	●
epoxy primer			●	●		●	●	●	●
wash primer			●	●		●		●	●
plastics		● ABS, EP laminate, PA, PBTP, PC, POM, PP/EPDM, PPO, hard and soft PUR, PVC		● **	● GRP, CFRP	● PP-EPDM, ABS, PC, ABS-PC, PMMA, PUR, PVC, GRP	● PP-EPDM, ABS, PC, ABS-PC, PUR, PVC, GRP	● **	● **
steel	●		●		●	●	●	●	●
galvinized steel	●				●				
bare metal (Iron/Fe)	●		● ***	● ***	●	● ***	● ***	● ***	● ***
cataphoretic coating (e-coat)			●	●	●	●	●	●	●
aluminium	●				●	●	●		
zinc	●				●	●	●		

For more detailed information, please refer to the TDS

* Recommended thinner: Chamäleon UNI Thinner 322/323
** For bare plastic areas larger than hand-sized, apply Chamäleon 409 Plastic Primer/Adhesion Promoter
*** For improved adhesion and long-term corrosion protection on larger areas, use Chamäleon 404 Wash/Etch Primer

QUALITY FROM GERMANY