



22880S™ LOW VOC ETCH PRIMER



GENERAL

DESCRIPTION

A two-component, olive green, non-sanding etch primer that provides premium-quality results, exceptional corrosion resistance and adhesion to bare steel, galvanized and aluminum.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

22880S™ Low VOC Etch Primer
 22806S™ Etch Primer Reducer
 22808S™ Etch Primer Reducer High Temperature (80°F+)

MIX RATIO

Combine the components by volume or weight (cumulative pt.). Mix thoroughly.

Component	Volume	Weight
22880S™ Low VOC Etch Primer	2	312 grams
22806S™ / 22808S™ Reducer	1	441 grams

Tips for Success

- Hand stir components or agitate on a mechanical shaker prior to mixing.
- Stir thoroughly while adding activator, until uniform.
- Use 22808S™ Reducer when temperature is above 80°F (27°C) or when priming large areas.

POT LIFE

8 hours at 70°F (21°C)

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not required
Flex Additive:	Not recommended
Reducer:	Not recommended
Retarder:	Not recommended



APPLICATION

PRIMERS OR SEALERS

4004S™ Ultra Productive 2K Primer Filler
 ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler
 ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
 ChromaPremier® Pro 33430S™ Productive Primer Sealer
 ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
 ChromaPremier® Pro 44410S™ / 44440S™ / 44470S™ 2K Premier Sealer
 Cromax® LE LE3004S™ 2K Primer Surfacer
 Cromax® LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer
 Cromax® Premier LE LE3401S™ / LE3404S™ / LE3407S™ Urethane Primer Filler
 Cromax® Premier LE LE3410S™ / LE3440S™ / LE3470S™ Urethane Primer Sealer

ChromaPremier® 22880S™ must always be followed with a primer-surfacer or sealer.



SUBSTRATES

Properly prepared/cleaned steel, aluminum, and galvanized.

SURFACE PREPARATION

- Wipe surface with surface cleaner
- Sand and featheredge with P180 DA grit paper followed by P240 DA grit
- Remove sanding sludge with surface cleaner

GUN SETUPS*

Compliant
 Siphon Feed: 1.4 mm-1.6 mm
 Gravity Feed: 1.3 mm-1.6 mm

HVLP
 Siphon Feed: 1.6 mm-1.8 mm
 Gravity Feed: 1.3 mm-1.6 mm

AIR PRESSURE*

Compliant Panel Overall
 Siphon Feed: 30-40 psi at the gun 35-45 psi at the gun
 Gravity Feed: 25-35 psi at the gun 30-40 psi at the gun

HVLP 6-8 psi at the cap 6-8 psi at the cap

*The listed setups cover the usual range for standard application equipment.

APPLICATION

Apply 1 medium-wet coat to ½ mil dry film thickness.

CLEANUP

Clean spray equipment as soon as possible with equipment cleaning solvent.



DRY TIMES

Nib Sanding: 20 minutes after flash
 Wet sanding not recommended
 Priming: 20 minutes
 Max Allowable Dry Time: 8 hours, then sanding is required
 Force Dry: Not recommended

RECOATABILITY/RE-REPAIR

If 22880S™ Low VOC Etch Primer is allowed to air dry for more than 8 hours, re-coat with itself.

SANDING

No sanding is necessary. May be nib sanded after 20 minutes. Do not wet sand.

Tips For Success

If sanding is required to remove imperfections, dry sand with P600-1000 grit paper using light hand pressure to avoid any cut-throughs.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	655 g/L (5.5 lbs./gal)
Max. VOC (AP):	312 g/L (2.6 lbs./gal)
Avg. Gal. Wt.:	931 g/L (7.77 lbs./gal)
Avg. Wt.% Volatiles:	84.8%
Avg. Wt.% Exempt Solvent	51.9%
Avg. Wt.% Water:	1.2%
Avg. Vol.% Exempt Solvent:	53.6%
Avg. Vol.% Water:	1.1%
Theoretical Coverage:	265 sq. ft. per RTS gallon at 0.5 mil DFT
Recommended Dry Film Thickness:	0.5 mils in 1 coat
Flash Point:	See MSDS/SDS

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
1.855.6.AXALTA
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In Canada:
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