

# 1K Multi Plastic Primer

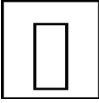


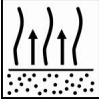


Adhesion Primers

06/11/2019

L2.01.05 UK & Ireland

## DESCRIPTION

Air drying, one-pack primer to promote the adhesion on plastic car-body parts.

Mixing ratio		RFU	1K Multi Plastic Primer
Equipment		Spray gun set up: 1.2-1.4 mm	Application pressure: 2.0-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		1 x 1 coat	
Flash-off		Recoat after 20 minutes at 20°C	Recoat within 24 hours at 20°C
Recoatability		All Lesonal primers, fillers and topcoats	
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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Air drying, one-pack primer to promote the adhesion on plastic car-body parts.

## PRODUCT AND ADDITIVES

Product 1K Multi Plastic Primer

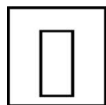
Chemical Basis 1K Multi Plastic Primer Polyolefin resin

## METHOD OF USE

Substrates All plastic car parts with the exception of pure PE (polyethylene).

Substrate preparation Clean substrate (without OEM primer) with warm water and detergent.  
Degrease with Lesonal Degreaser.  
Scuff surface with Scotch Brite S (Grey) very fine.  
Degrease with Lesonal Degreaser and tack rag.

### Mixing ratio



RFU 1K Multi Plastic Primer

Spraying viscosity 14 - 16 sec. DIN Cup 4 at 20°C

### Spray gun set up



Spray gun:  
HVLP Gravity  
LVLP/HR Gravity

Fluid opening:  
1.2-1.4 mm  
1.2-1.4 mm

Spraying pressure:  
0.7 bar (at air cap)  
1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

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## APPLICATION TECHNIQUE

### Application

Apply one even closed coat.

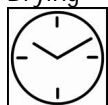


Minimum application temperature: 15°C

### Equipment cleaning

Use Multi Thinners or nitro cellulose thinner

### Drying

Recoatable after  
20 minutes at 20°CRecoat within  
24 hours at 20°C

### Layer thickness

1 – 4 microns

### Material usage

Ready for use mixture at 1 µm layer thickness :

11.4 m<sup>2</sup>/liter

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances

### Recoatability

All Lesonal primers, fillers and topcoats

### Product storage

Avoid extreme temperature fluctuation and high humidity levels

### Shelf life

2 years at 20°C

### VOC

2004/42/IB(e)(840)780

The EU limit value for this product (product category : IIB.e) in ready to use form is max. 840 g/l VOC.

The VOC content of this product in ready to use form is max. 780 g/litre.

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**Akzo Nobel Coatings LTD**  
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## FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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