

2K Universal Plastic Primer





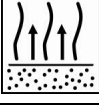



Adhesion Primers

09/02/2020

L2.05.02 UK & Ireland

DESCRIPTION

Two component primer for plastic car parts, with the exception of soft polyurethane parts.

Mixing ratio		5 1 2	2K Universal Plastic Primer Hardener Universal Plastic Primer Multi Thinner Standard / Fast
Mixing stick		G	
Equipment		Spray gun set up: 1.4-1.5 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		2 x 1 coat	
Flash-off		Between coats 5-10 minutes at 20°C	
Drying		Recoat after 30 minutes at 20°C	Recoat within 24 hours at 20°C
Recoatability		Topcoat HS 420	Basecoat WB (GT)
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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DESCRIPTION

Two component primer for plastic car parts, with the exception of soft polyurethane parts.

PRODUCT AND ADDITIVES

Product 2K Universal Plastic Primer

Hardener Hardener Universal Plastic Primer

Thinner Multi Thinner Fast
Multi Thinner Standard

Chemical Basis 2K Universal Plastic Primer Epoxy resins
Hardener Universal Plastic Primer Amine resins

METHOD OF USE

Substrates All plastics car parts, except for soft polyurethane parts.

Do not apply 2K Universal Plastic Primer to pre primed plastic parts.

Substrate preparation Wash thoroughly with hot soapy water, using a stiff brush if necessary.
Rinse with clean water and dry.
Degrease with Degreaser SB or WB.
Scuff hard plastic surface with Scotch Brite type A (red) or flexible plastics with type S very fine (grey).
Rinse with clean water and dry
Degrease with Lesonal Degreaser.

Tinting If necessary, 2K Universal Plastic Primer can be tinted with up to 10 parts by weight of Topcoat HS 420 (without hardener).

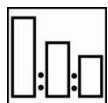
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Mixing ratio



- 5 2K Universal Plastic Primer
- 1 Hardener Universal Plastic Primer
- 2 Multi Thinner

Mixing stick G

Spraying viscosity 15-17 sec. DIN Cup 4 at 20°C

Potlife 8 hours at 20°C

Spray gun set up



Spray gun:
HVLP Gravity
LVLP/HR Gravity

Fluid opening:
1.4-1.6 mm
1.4-1.6 mm

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

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application

Sanding
Apply two single coats, allowing for a flash off time of 5 to 10 minutes between coats



Equipment cleaning Use Multi Thinners or nitro cellulose thinner

Drying



20°C
Recoatable after 15 min
Recoat within 24 hrs

Layer thickness 20 – 30 microns

Material usage Ready for use mixture at 1 µm layer thickness : 285 m²/liter

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

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Recoatability	Topcoat HS 420 Basecoat WB GT
Product storage	Avoid extreme temperature fluctuation and high humidity levels
Shelf life	1 year at 20°C
VOC	2004/42/IIIB(e)(840)660 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. 660 g/litre.

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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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