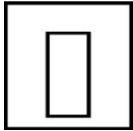


# 1K All Plastics Primer

**FOR PROFESSIONAL USE ONLY**

## Description

Quick drying, one-pack adhesion primer for plastic car body parts.



1K All Plastics Primer

Ready to spray

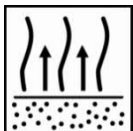


Spray gun set-up:  
1.2-1.4 mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



1 coat



Recoat after:  
20 minutes at 20°C

Recoat within:  
24 hours at 20°C



Recoatable with all Sikkens primers/surfacers and topcoats



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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## Description

Quick drying, one-pack adhesion primer for plastic car body parts.

## Suitable substrates

All plastic car body parts available to date, with the exception of those made of pure PE (polyethylene).

1K All Plastics Primer is specially designed for application to soft polyurethane plastic car parts.  
*Do **not** apply 1K All Plastics Primer to plastic parts that are pretreated with OEM primer*

## Products and additives

1K All Plastics Primer

## Basic raw materials

Polyolefine resins

## Surface preparation



Pre-clean the surface with warm water and detergent and rinse sufficiently with clean water.  
Remove surface contamination with M700 Anti Static Degreaser or M200



### Untreated thermoplastic part

Thoroughly abrade all surfaces using Sikkens Blend Prep in combination with water.  
*Use a 3M VFN (Purple) abrasive pad on hard plastics and a 3M UFN (Grey) abrasive pad in case of a flexible/soft plastic part, rinse sufficiently with clean water after use.*

*For specific plastic part preparation procedures and detailed surface preparation see TDS S8.06.03*



### Painted plastic part

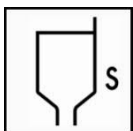
Sanding; final dry sanding steps; P220 - P320  
For spot repair sand the featheredge with P400 - P500



Surface cleaning; remove surface contamination using M700 Anti Static Degreaser or M200

*Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

## Viscosity



14-16 seconds - DIN cup 4 at 20°C.

# 1K All Plastics Primer

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## Pot-life

Unlimited.  
*Within product shelf life*

## Spray gun set-up / application pressure



### Spray gun

Gravity feed

### Fluid tip – set-up

1.2-1.4 mm

### Application pressure

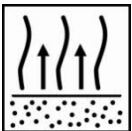
1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

## Application



Apply 1 even coat over untreated plastic substrates.

## Recoat time



Allow for a minimum of 20 minutes flash-off time at 20°C before recoating.  
Apply the primer fillers/surfacers or topcoat within 24 hours at 20°C

*Should this maximum time be exceeded, abrade the surface with 3M UFN (Grey) before recoating once again with one full coat of 1K All Plastics Primer.*

## Recoatable with



All Sikkens primers/fillers, surfacers and topcoats.

## Film thickness

By using the recommended application: 1-4µm

## Theoretical coverage

By using the recommended application the theoretical material usage is  
Per 1 µm

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

### Note:

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

## VOC

### 2004/42/IIb(e)(840)780

The EU limit value for this product (product category: IIb(e)) in ready to use form is 840 gram/liter of VOC.  
The VOC content of this product in ready to use form is max. 780 gram/liter.

# 1K All Plastics Primer

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## Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

## Product storage

Product shelf life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

### 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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#### Head Office

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