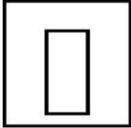


1K All Plastics Primer

FOR PROFESSIONAL USE ONLY

Description

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



1K All Plastics Primer
Ready to spray

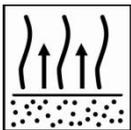


Spray gun set-up:
1.2-1.4mm

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



Recoat with all Sikkens primer 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

1K All Plastics Primer

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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.

Product 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 or M200.



Untreated thermoplastic part

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, in combination with a plastic suitable blend prepping paste and water. Rinse sufficiently with clean water.

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



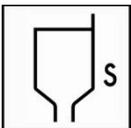
Painted plastic part

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



Surface cleaning; remove surface contamination using M700 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

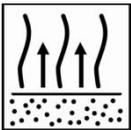
Application pressure
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

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 surfacers and *topcoats.

*In a case of a wet-on-wet topcoat application, for optimum system durability it is advised to apply a coat of wet-on-wet primer surfacer prior to the topcoat.

Film thickness

By using the recommended application: 1-4µm

Theoretical coverage

By using the recommended application the theoretical material usage is:

Per 1 µm 11.4 m²/liter

Note:

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

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is 860 g/liter.

1K All Plastics Primer

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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 Pty Ltd T/A Akzo Nobel Car Refinishes Australia
Address: Unit 3/344 Lorimer Street, Port Melbourne, VICTORIA, 3207
Tel: +61 3 9644 1711

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com