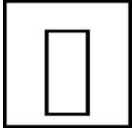


1K All Plastics Primer

Description

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



1K All Plastics Primer
 Ready to spray

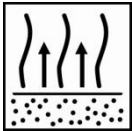


Spray gun set-up:
 1.2-1.4mm

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

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

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



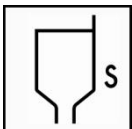
Painted plastic part

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



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

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

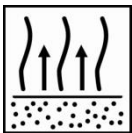
Application pressure
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

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

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

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