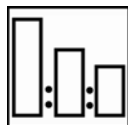


2K Plastic Primer

FOR PROFESSIONAL USE ONLY

Description

Two-pack primer for plastic parts which are currently used in the automotive industry, except for soft polyurethane parts.



- 5 2K Plastic Primer
- 1 2K Plastic Primer Hardener
- 2 Autoclear LV Superior Reducer Medium / Autocryl LV Thinner 420 / Plus Reducers



Use Sikkens measuring stick

23 Violet

Beware of different ratios on measuring stick.

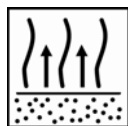


Spray gun set-up:
1.2-1.5 mm

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

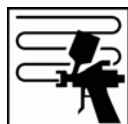


2 x 1 coat



Flash off time:
5-10 minutes at 20°C

Recoat after:
30 minutes at 20°C
Recoat within 24 hours at 20°C



Recoat with all Sikkens 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

2K Plastic Primer

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Description

Two-pack primer for plastic parts which are currently used in the automotive industry, except for soft polyurethane parts.

Suitable substrates

All thermoplastic car body parts available to date, with the exception of soft polyurethane thermoplastic car parts; for these parts use Plastoflex Primer.

Do not apply 2K Plastic Primer to thermoplastic parts that are pretreated with any OEM primer.

Thorough preparation of thermoplastics made of PP (polypropylene) or PE (polyethylene) is necessary for optimum system properties.

Product and additives

2K Plastic Primer

Hardeners 2K Plastic Primer Hardener

Reducers Autoclear LV Superior Reducer Medium
Autocryl LV Thinner 420
Plus Reducers

Basic raw materials

2K Plastic Primer: Epoxy resins

2K Plastic Primer Hardener: Amine resin

Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using appropriate surface cleaner. Use either M700 or Anti Static Degreaser, which are dedicated thermoplastics surface cleaners.
Pre-clean the surface with warm water and detergent using a stiff brush if necessary to remove any traces of release agent from the surface, rinse sufficiently with clean water.



Virgin (untreated) thermoplastic part;
Thoroughly abrade all surfaces that are to be coated using Sikkens Plastic Prep in combination with water. Use a 3M VFN (Purple) abrasive pad on hard thermoplastics and a 3M UFN (Grey) abrasive pad in case of a flexible/soft thermoplastic part, rinse sufficiently with clean water after use.

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



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



Surface cleaning; remove any surface contamination prior to 2K Plastic Primer application using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

2K Plastic Primer

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Stir before use

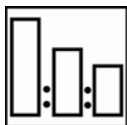


Stir the 2K Plastic Primer thoroughly before mixing.

Tinting

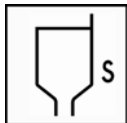
If necessary, 2K Plastic Primer can be tinted with up to 10 parts by volume with either; Autocryl LV 420 or Autocryl Plus LV MM toners.

Mixing



- 5 2K Plastic Primer
- 1 2K Plastic Primer Hardener
- 2 Autoclear LV Superior Reducer Medium / Autocryl LV Thinner 420 / Plus Reducers

Viscosity



15-17 seconds Din-cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun	Fluid tip-set-up	Application pressure
Gravity feed	1.2-1.5 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

Pot-life

8 hours at 20°C

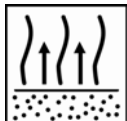
Application



Apply two full flowing coats.

Allow each coat to flash-off naturally until the surface is completely matt; do not force-dry by air support. Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow.

Flash off time



Allow for a flash off time of 5-10 minutes at 20°C between coats and 30 minutes at 20°C prior to topcoat application.

Apply the topcoat within 24 hours at 20°C

Should this maximum time be exceeded, abrade the surface with P500 dry or P1000 wet sanding paper or with 3M UFN (Grey) prior to the application of any primer/filler/surfacer or topcoat.

2K Plastic Primer

FOR PROFESSIONAL USE ONLY

Denibbing

For minor defects (e.g. dust) 2K Plastic Primer can be denibbed with either P500 dry or P1000 wet sanding paper. After a drying time of longer than 4 hours thorough sanding is necessary!

Recoat with

All Sikkens topcoats

Film thickness by using recommended application

20-30 µm

Theoretical coverage

By using the recommended application, the theoretical material usage is: $\pm 19 \text{ m}^2/\text{liter RTS}$.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure 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 630 g/liter.

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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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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