

2K Universal Plastic Primer

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Technical Data Sheet

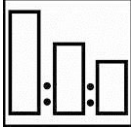



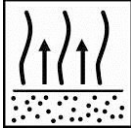



07 / 11 / 2016

L2.05.02 UK & Ireland

Primers/Surfacers

Description

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

Mixing ratio		5 1 2	2K Universal Plastic Primer Universal Hardener Plastic Primer Multi Thinner
Mixing stick		G	
Equipment		Spray gun set-up: 1.4-1.6 mm	Application pressure: 2 – 2.2 bar* <small>* refer to user manual spray gun</small>
Application		2 x 1 coat	
Flash-off		Between coats 5 - 10 minutes at 20°C	
Drying		30 mins. at hours 20°C	
Recoatability		Topcoat HS 420	Basecoat WB Basecoat WB GT
Protection			

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 & ancillary items	
Product	2K Universal Plastic Primer
Hardener	Hardener Universal Plastic Primer
Thinners	Multi Thinners
Chemical Basis	2K Universal Plastic Primer – Epoxy resins Hardener Universal Plastic Primer – Amine resins Multi Thinners – A blend of organic solvents
Method of use	
Substrates	All plastics which are currently used in the automotive industry, except for soft Poly-urethane parts. Do not apply 2K Universal Plastic Primer to pre primed plastic parts.
Substrate preparation	To remove any traces of release agent from the surface, 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 again with Lesonal Degreaser.
Tinting	If necessary, 2K Universal Plastic Primer can be tinted with up to 10 parts by weight of Topcoat HS 420 mixing color (without hardener).
Mixing Ratio	5 volumes – 2K Universal Plastic Primer
Mixing stick G	1 volume – Hardener Universal Plastic Primer 2 volumes – Multi Thinner



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Spraying Viscosity	15 - 17 sec. DIN Cup 4 at 20° C.		
Pot life	After mixing, use within: 8 hrs. at 20°C.		
Spraying pressure	Spraygun	Fluid opening	Spraying pressure
	HVLP Gravity	1.4 – 1.6 mm	0.7 bar (at aircap)*
	LVLP (HR) Gravity	1.4 – 1.6 mm	2 – 2.2 bar (at inlet)*
	Conventional Gravity feed	1.2 – 1.5 mm	2 – 2.2 bar (at inlet)*
	*Please refer to user manual of spraygun used		
Application Technique	Apply 2 single coats, allowing a flash off time of 5 to 10 minutes between coats. (Drying times will be very much influenced by factors such as temperature and air movement at the time of application).		
Film Thickness	10-15 micron per coat		
Theoretical use per ltr/m²	19 m ² at a layer thickness of 15 micron (the practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances)		
Cleaning Equipment	Use Multi Thinner or a nitrocellulose thinner.		
Drying Times	After 30 minutes at 20°C 2K Universal Plastic Primer can be recoated; after 24 hours sanding is necessary.		
Recoatibility	Topcoat HS 420 and Basecoat WB		
Color	Light grey		
Shelf life	2K Universal Plastic Primer: 1 year		
	Hardener Universal Plastic Primer: 1 year		

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