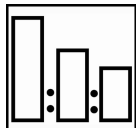


2K Plastic Primer

FOR PROFESSIONAL USE ONLY

Description

Two pack primer for plastics which are currently used in the automotive industry, except for soft polyurethane parts. 2K Plastic Primer is a non sanding (wet-on-wet) adhesion for plastic parts.



100 2K Plastic Primer
25 2K Plastic Primer Hardener Standard
35 Plus Reducers



Use Sikkens measuring stick

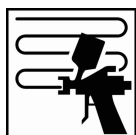
5 orange

Beware of different ratios on measuring stick.

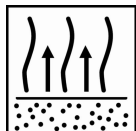


Spray gun set-up:
1.2-1.5 mm

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



1 x 1 coat

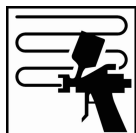


Flash off time

20 minutes at 20°C

Recoat after:

20 minutes at 20°C
Recoat within 24 hours at 20°C



Recoat with all Sikkens topcoats
PUR Fillers with Elast-O-Actif according to TDS



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

FOR PROFESSIONAL USE ONLY

Description

Two pack primer for plastics which are currently used in the automotive industry, except for soft polyurethane parts. 2K Plastic Primer is a non sanding (wet-on-wet) adhesion for plastic parts.

Suitable substrates

All plastic car body parts available to date, with the exception of those made of soft polyurethane thermoplastic car parts.

Thorough preparation of thermoplastics is necessary for optimum system properties.

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

Product and additives

Products	2K Plastic Primer (White, Dark Grey)
Hardeners	2K Plastic Primer Hardener Standard
Reducers	Plus Reducers (Fast, Medium, Slow, Extra Slow)

Basic raw materials

2K Plastic Primer: Unthinned paint is based on hydroxylated acrylic and polyester resin
2K Plastic Primer Hardener Standard: Polyisocyanate resin

Surface preparation



Remove contamination using either M700.
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:
Abrade the plastic part with a wet scuffing pad (grey) in conjunction with an abrasive compound detergent and (warm) water to scuff the untreated plastic surface, *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



Remove contamination using the appropriate degreaser M700 – M200.

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

Stir before use



Stir the 2K Plastic Primer thoroughly before mixing.

2K Plastic Primer

FOR PROFESSIONAL USE ONLY

Tinting Grey Shades

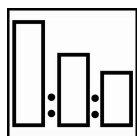
2K Plastic Primer White and Dark Grey can be intermixed according to the Quick-Mix table below.

Mix by Volume (parts)	SGS 1	SGS 2	SGS 3	SGS 4	SGS 5
White (SGS 1)	100	95	75	50	0
Dark Grey (SGS 5)	0	5	25	50	100

Mix by Volume (parts)	SGS 1	SGS 2	SGS 3	SGS 4	SGS 5
White (SGS 1)	RM	19	3	1	
Dark Grey (SGS 5)		1	1	1	RM



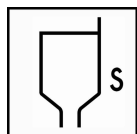
Mixing



100 2K Plastic Primer
25 2K Plastic Primer Hardener Standard
35 Plus Reducers

Use measuring stick 5

Viscosity



15-18 seconds Din-cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun

Gravity feed

Fluid tip-set-up

1.2-1.5 mm

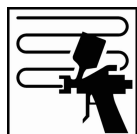
Application pressure

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

Pot-life

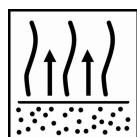
45 minutes at 20°C

Application



Apply one full flowing coat.

Flash off time



The final flash-off time:

- Recoatable after 20 min at 20°C with Plus Reducer Fast
- Recoatable after 30 min at 20°C with Plus Reducer Medium/ Slow/ Extra Slow.

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

2K Plastic Primer

FOR PROFESSIONAL USE ONLY

with scuff pad Grey prior to the application of any primer/filler/surfacer or topcoat.

Denibbing

Allow for a minimum flash off time of 20 minutes at 20°C.
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!

Recoatable with

All Sikkens topcoats
PUR Fillers with Elast-O-Actif according to TDS

Film thickness by using recommended application

20-30 µm

Theoretical coverage by using recommended application

The theoretical material coverage at 1 µm layerthickness is: ± 478 m²/liter RTS (based on white 2K Plastic primer and Plus Reducer Medium).

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 556 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C
Avoid extreme temperature fluctuation.
o Product shelf life data see TDS S9.01.02

Akzo Nobel Car Refinish bv.
Address: Rijksweg 31, PO Box 3, 2170 BA Sassenheim
Tel: +31(0)71308-6944

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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