PROGRAMMED SYSTEM TECHNIQUE
NORTH AMERICA

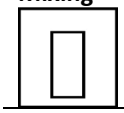
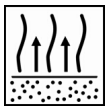
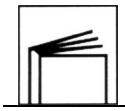
LESONAL®

All Plastics Primer™

Programmed System Technique (PST)
Primer
04/10/2020

DESCRIPTION

Lesonal All Plastics Primer is a fast drying, transparent, adhesion primer. Specially designed for plastic car parts manufactured from, polyolefin, polypropylene and ethylene propylene modified. Primer PO should be used only on those plastic parts that have no existing primer or other coating applied.

Safety Considerations 	Use suitable personal protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
Mixing 	Product is supplied ready to spray	
Equipment 	**HVLP or Compliant Spray-Gun Set-Up:** 1.3-1.5 mm	**Application Air Pressure:** Consult spray gun manufacturer specifications. HVLP – 10 psi at the air cap maximum.
Application 	1-2 medium coats	
Flash-off 	**Flash Between Coats at 70°F (20°C)** 5-10 minutes	**Flash Before Force Drying at 70°F (20°C)** Not recommended
Drying 	**Air Drying at 70°F (20°C)** All Plastic Primer must be recoated within 16 hours of application. If 16 hours are exceeded, abrade the surface with a gray scuff pad and reapply All Plastic Primer.	
Drying 	**Force Drying at 140°F (60°C)** Not recommended	**Infrared** Not recommended
Recoatable With 	• Lesonal Primers	

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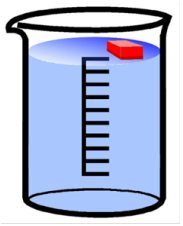
PRODUCT AND ADDITIVES

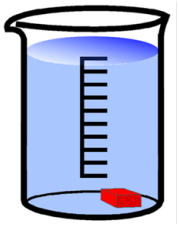
Product	Lesonal All Plastics Primer	Item #396289

METHOD OF USE

Basic Raw Materials	All Plastic Primer – special polyester resin, xylene and other ingredients
Bare Plastic Identification –	**STEP #1 – Float Test** Carefully cut a matchstick sized piece of bare plastic from the back side of the part. Ensure that the sample piece is free of paint, mold release agent or any other coating. Submerge the sample in a container of clean water. If the sample floats, it indicates that the part is a polyolefin type plastic. All plastics that float require the use of All Plastic Primer. If the sample sinks, go to step #2.



Polyolefin Plastic



Proceed to Step #2

STEP #2 – Plastic Code Sea...

Common plastics used by the automotive industry can normally be identified by markings on the back of the part. These codes are based on ISO (International Standardization Organization) codes. ISO codes are a uniform set of letter combinations that identify plastics and plastic alloys. Normally the plastic ISO code can be found on the back of plastic parts. The position of the code on the part varies by manufacturer and / or part so careful examination of the part may be required to find the code. Repair situations will likely require part removal from the vehicle to access the code.

If no code can be found on the part is to obtain the information from the part supplier. Plastic information is available from OEM Repair Manuals or Service Manuals. The OEM information includes codes or plastic types for exterior parts as well as interior pieces.

There are two families of plastic for the purpose of automotive refinishing. These are 1) polyolefin type plastics or 2) generic non-polyolefin plastics such as acrylonitrile-butadiene-styrene (ABS) or polyurethanes (PUR).

All Plastics Primer™

Plastics that are coded with the letter combinations below or contain within them these letter combinations are considered polyolefin type plastics. These plastics require the use of All Plastic Primer.

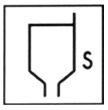
Popular Polyolefin Plastic Codes	
• PP	• PP+EP
• PO	• PP/EPM
• TPE	• PP/EPDM
• TPO	• PPE/EPDM

Plastics that do not contain letters designating polyolefin type plastics with the exception of polyethylene (PE) are non-polyolefin plastic and require no adhesion promoter. Polyethylene (PE) plastics are difficult if not impossible to paint.

Sanding Uncoated Plastics

- Pre-Clean uncoated plastic with Autoprep Ultraprep.
- Prior to painting uncoated polyolefin plastics or parts abrade with a gray scuffing pad and a quality scuffing paste.
- Before painting uncoated non-polyolefin plastic or parts sand with #P400 grit dry or abrade with a red scuffing pad and a quality scuffing paste.
- When prepping plastic parts primed with reversible, solvent soluble primers, sand with P400 grit dry or abrade with a gray scuffing pad and a quality scuffing paste.
- When prepping primed or painted plastic parts with non-reversible coating sand with #P400 grit dry or abrade with a red scuffing pad and a quality scuffing paste.

Viscosity When Mixed



DIN #4

10-12 seconds Measured with a DIN #4 viscosity cup at 70°F (20°C).

Spray Gun Set-Up

Consult spray gun manufacturer instructions for spray gun pressure specifications.

Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Feed	1.3-1.5 mm	Max 10 psi at the spray gun inlet (<10 psi at cap).
Compliant Gravity Feed	1.3-1.5 mm	Max 10 psi at the spray gun inlet.

APPLICATION TECHNIQUE

Application

1-2 medium wet coats

Allow a flash off time between coats and prior to primer application of 5-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available airflow.

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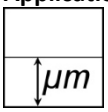
Film Thickness – Using Suitable Application 	1 Coat will achieve a thickness of 0.15-0.25mils (3.8 –7 µm).
Drying 	• Infrared drying not recommended.

POST-APPLICATION

Recoating 	All Plastics Primer can be recoated with all Lesonal Primers. Please refer to the Lesonal Flex TDS for information regarding the amount of Flex Additive needed for each undercoat.

ADDITIONAL INFORMATION

Cleaning of Equipment 	Clean equipment following local and federal regulations.
VOC / Regulatory Information 	Product VOC Ready to Spray is 7.0 lbs/gal (840 g/L)
Product Storage 	• Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimal storage temperature is approximately 70°F (20°C). • Refer to the Product Shelf-Life Overview TDS or the current price list for the most up-to-date shelf-life information.

LESONAL®

All Plastics Primer™

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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