

Technical Information

1K-PLASTICS-ADHESION-PRIMER 934-0













clear
(AX 90-0444)

Resin base: Copolymer

**E
P**

<p>Products Required:</p>	<table border="0"> <tr> <td>1K-Plastics-Adhesion-Primer</td> <td>934-0</td> </tr> <tr> <td>Universal-Cleaner</td> <td>541-30</td> </tr> </table>	1K-Plastics-Adhesion-Primer	934-0	Universal-Cleaner	541-30
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Universal-Cleaner	541-30				
<p>Application/Properties:</p>	<p>Ready-for-use plastics adhesion primer for all paintable plastics found on cars.</p>				
<p>Substrates:</p>	<p>a) Flexible Plastics: PP-EPDM Polypropylene (Rubber modified) PUR foam Polyurethane Integral Foam (RIM)</p> <p>b) Hard/Rigid Plastics: ABS Acrylic Butadien Styrene GFK/GRP Glass Fibre Reinforced Plastic GF-UP Glass Fibre Reinforced Polyester SMC Sheet Moulding Compound DMC / BMC Bulk Moulding Compound</p> <p>PVC hard Polyvinyl chloride PC Polycarbonate PA Polyamide PBTP Polybutyleneterephthalate PPO Polyphenylene Oxide UP Unsaturated Polyester</p> <p>Not Paintable in pure form: PP/PE Polypropylene / Polyethylene PVC soft Polyvinyl chloride</p>				
<p>Remarks:</p> <p>Cleaning:</p> <p>Sanding:</p> <p>Re-cleaning:</p> <p>Tempering:</p>	<p>Careful cleaning is absolutely essential. Wash with warm water and soap.</p> <p>Pre-clean the plastic part using a sanding pad with 541-30.</p> <p>Sand with 400/P600</p> <p>Re-clean with 541-30 then rub dry and allow solvents to evaporate.</p> <p>PUR-Foam and PA Polyamide plastics should be tempered for 1 hr at 140°F/60°C and thoroughly cleaned with 541-30 to ensure that pores are opened and any moisture totally dried out.</p>				



Processing Data	1K-PLASTICS-ADHESION-PRIMER 934-0
Use	1-component Plastics Adhesion Primer
 System	B. 10
 Mixing ratio	Not applicable. Ready for use.
 Hardener	
 Reducer	
Potlife at 68°F/20°C	
 Spray viscosity DIN4 68°F/20°C	As supplied. Ready for use. VOC as applied: 6.9 lbs/gal; 834 gms/litre
 Gravity gun nozzle	1.3 – 1.5 mm
Gravity gun HVLP	1.3 mm
 Suction gun nozzle	1.7 – 1.8 mm
Suction gun HVLP	1.7 mm
Spray pressure	45 – 60 p.s.i.
 Spray coats	1 thin wet coat.
 Brushing	
Dry coat thickness	.1 - .25 mils
 Flash-off time 68°F/20°C	15 min. prior to filler or top coat application
 Drying at 68°F/20°C 140°F/60°C	
 Infra red short wave med. wave	
Sanding: Wet by Hand Wet by Machine Dry by Hand Dry by Machine	Do not sand Do not sand Do not sand Do not sand
Comments	Surfacing over 934-0 can be carried out with: Rapid Filler 285-100* 2.1 VOC Primer 285-21* HS Tintable Primer 285-95* HS Universal Primer 285-60 * HS Primer 285-50 Fiberglass Parts: 934-0 is not necessary. * Elastifier Additive 522-111 must be added as per Finishing System B. 10.

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use—read product label for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warranty for events resulting from their use.