





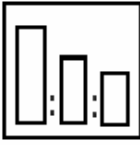



ALL PLASTIC PRIMER REDUCER

DESCRIPTION: A special reducer designed for use with Colorbuild Primer Sealer for application on previously unpainted plastic parts on which Primer PO or Plastoflex would normally be sprayed. With Colorbuild Primer Sealer, using All Plastic Primer Reducer, there is no need for a flex agent or plastic identification. Colorbuild Primer Sealer, with All Plastic Primer Reducer may also be used on non-plastic car parts

PRODUCT: All Plastic Primer Reducer

BASIC RAW MATERIALS: Special adhesion promoting resins and solvent.

APPLICATION:

- | | | | | | |
|----|---|---|----|--|---|
| 1. |  | Contains special resins and other ingredients. When mixed, also contains isocyanate. | 4. |  | 1x1
HVLP Siphon 1.8–2.2 mm
HVLP Gravity 1.3–1.5 mm
Max 10 psi |
| 2. |  | 100:50:30
Colorbuild
Colorbuild Primer Sealer
Hardener
All Plastic Primer Reducer | 5. |  | Non-sanding
30 minutes at 70°F (20°C)
Maximum
2-½ hours at 70°F (20°C) |
| 3. |  | Use the Sikkens Mixing #1 (100:50:30) | 6. |  | Apply topcoat.
(See appropriate TDS for subsequent topcoats) |

SUITABLE SURFACES:

- Flexible Parts:** Colorbuild Primer Sealer activated with All Plastic Primer Reducer can be applied over plastics for which application of Primer PO or Plastoflex would normally be recommended. Identifying the plastic is no longer needed.
- Existing finishes, degreased and sanded with #P320 to #P400 grit paper dry.
- Fiberglass gel coat, degreased and sanded with #P360 grit dry. If the gel coat is broken and has been sanded through, under no circumstance should Colorbuild be applied. Recommended is the use of Polysurfacer.
- Colorbuild with All Plastics Reducer can be applied over one coat of these primers without sanding after the stated flash off.
Washprimer EM CF after 30 minutes at 70°F (20°C)
Washprimer CR after 15 minutes at 70°F (20°C)
- OEM E-coat, Colorbuild may be applied to non-sanded, rigid OEM E-coated parts that have been thoroughly cleaned and degreased.

NOTE: For use on non-plastic parts. Please follow the “Suitable Surfaces, Wet-On-Wet” description on the Colorbuild Undercoat System technical data sheet.



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SURFACE

PREPARATION: Degrease all plastic parts with Sikkens Anti-Static Surface Cleaner. In areas where VOC emissions regulations apply, use recommended pre-cleaning product. Thoroughly abrade unpainted substrate with a 3M "Gray" scuffing pad and Sikkens Plastic Fix. Thoroughly rinse with clean water. Degrease again with Sikkens Anti-Static Surface Cleaner. Please refer to TDS, "Surface Cleaners".

When degreasing and cleaning unpainted plastic parts, allow the part to dry out for 20–30 minutes after the application of degreaser and before the application of Colorbuild Primer Sealer with All Plastic Primer Reducer.

MIXING RATIO: 100 parts Colorbuild
50 parts Colorbuild Primer Sealer Hardener
30 parts All Plastic Primer Reducer

NOTE: For flexible plastic parts the use of Autocryl Elast-O-Actif is not necessary when applying Colorbuild Primer Sealer with All Plastic Primer Reducer.

NOTE: For application on larger areas or in high temperatures the addition of 10% Autocryl Slow reducer is suggested.

SPRAYING VISCOSITY:

14–17 sec. DIN cup #4 at 70°F (20°C)

POT LIFE:

3 hours at 70°F (20°C).

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Siphon Feed	1.4–1.7 mm	40–50 psi
Gravity Feed	1.3–1.4 mm	40–50 psi
HVLP Siphon	1.8–2.2 mm	max 10 psi
HVLP Gravity	1.3–1.5 mm	max 10 psi

APPLICATION METHOD:

Apply one single wet coat. On sanded through areas, first apply one thin coat, flash for 5-10 minutes, then apply one single wet coat, allowing for a flash-off time of 30 minutes prior to topcoat.

CLEANING OF EQUIPMENT:

Clean with Sikkens Cleaning Solvent 790 or lacquer thinner.

RECOATABILITY:

Colorbuild Primer Sealer with All Plastic Primer Reducer can be recoated after 30 minutes flash-off at 70°F (20°C), maximum 2½ hours, with topcoat.

NOTE: After 2 ½ hours at 70°F (20°C) sanding is necessary before application of topcoat. Before sanding allow to dry 12 hours at 70°F (20°C) and 45 minutes at 140° F (60° C).



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STOCK KEEPING:

COLOR: Clear

CONTAINER SIZE: 1 gallon (3.785 lt)

SHELF LIFE: One year if stored unopened at room temperature.

SAFETY ASPECTS:

READY TO SPRAY VOC: 4.2 lb/gal 504 g/liter

NOTICE: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an organic vapor respirator or air supplied respirator when exposed to vapors or spray mist.