

## PLASTOFLEX® PRIMER


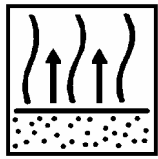
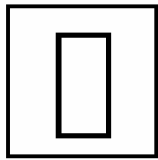
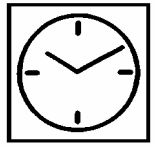


**DESCRIPTION:** Plastoflex Primer is a fast drying transparent adhesion primer for plastic car body parts. Plastoflex Primer should be used on untreated plastic parts whether these parts are hard, flexible or soft.

**PRODUCT:** Plastoflex Primer

**BASIC RAW MATERIAL:**

Alkyd resin

### APPLICATION:

- |    |   |  |    |  |  |
|----|---|--|----|--|--|
| 1. |    | Contains xylene, butyl alcohol and other ingredients.  | 4. |    | 5–10 minutes at 70°F (20°C)                |
| 2. |   | Plastoflex Primer<br>Ready to spray  | 5. |   | (Non-sanding)<br>20 minutes at 70°F (20°C) |
| 3. |  | 2x1<br>HVLP Siphon<br>0.071"–0.087" (1.8–2.2 mm)<br>HVLP Gravity<br>0.051"–0.059" (1.3–1.5 mm)<br>Max 10 psi (max 0.8 bar) | 6. |  | Apply sealer or topcoat                    |

### SUITABLE SUBSTRATES:

Plastoflex Primer can be applied on any existing plastic body part used on the outside of cars, such as grills, bumpers, spoilers and body panels. Plastoflex Primer will adhere to the following unpainted substrates:

#### A. Hard Plastics

SMC = Sheet moulding compound      GFK = Fiber glass laminate  
BMC = Bulk moulding compound      PC = Polycarbonate

#### B. Flexible Plastics

PP/EPDM = Polypropylene/Ethylene propylene diene modified  
PP/EPM = Polypropylene/Ethylene propylene modified  
ABS = Acrylonitrile butadiene styrene  
PPO = Polyphenylene oxide polymer  
PA = Polyamide  
HP-Alloy = Honda Polymer alloy  
PUR = Polyurethane  
P.D.T. = Polybutylene terephthalate (pocan)  
TPU = Thermoplastic Polyurethane

#### C. Soft Plastics

PUR = Polyurethane

Plastoflex Primer should not be used on: polypropylene or polyethylene.  
For these types of plastic, use Primer PO.



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## PLASTOFLEX<sup>®</sup> PRIMER

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### SURFACE PREPARATION:

- Degrease with Sikkens Anti-Static Surface Cleaner. In areas where VOC emissions regulations apply, use recommended pre-cleaning product.
- Sand the part to be primed with #P360 grit paper dry or #P500 to #P600 wet. Or abrade substrate carefully using an appropriate scuffing pad, red or grey, and Sikkens Plastic Fix.
- Degrease again with Sikkens Anti-Static Surface Cleaner.
- When degreasing and cleaning unpainted plastic parts, allow the part to dry out for 20–30 minutes after the application of surface cleaner and before the application of Plastoflex Primer.

### NOTE:

Plastic body parts already having a paint system (or pre-primed), should not be treated with Plastoflex Primer. These can be treated as existing finishes.

### MIXING RATIO:

None. Product is ready to use.

### SPRAYING VISCOSITY:

18–20 sec. ZAHN cup #2 (16–18 sec. DIN #4) at 70°F (20°C).

### POT LIFE:

None

### SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Siphon Feed	0.055"–0.067" (1.4–1.7 mm)	40–50 psi (3–4 bar)
Gravity Feed	0.051"–0.055" (1.3–1.4 mm)	40–50 psi (3–4 bar)
HVLP Siphon	0.071"–0.087" (1.8–2.2 mm)	max 10 psi (max 0.8 bar)
HVLP Gravity	0.051"–0.059" (1.3–1.5 mm)	max 10 psi (max 0.8 bar)

### APPLICATION METHOD:

Spray two single coats. Allow 5–10 minutes flash off time after each coat at 70°F (20°C).

### CLEANING OF EQUIPMENT:

Clean with Sikkens Cleaning Solvent 790 or lacquer thinner.

### FILM THICKNESS:

0.6–1 mil per single coat.



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**RECOATABILITY:** Without sanding, Plastoflex Primer can be recoated after 20 minutes flash off at 70°F (20°C) with Colorbuild, Autosurfacers 940 HS, Autosurfacers 2+1 HS, Autocryl, or Autobase<sup>®</sup> Plus. After 16 hours drying, abrade with a grey scuffing pad before applying topcoat. Please see the TDS relative to the product chosen.

**COVER RATE:** Approximately 55 sq. ft./liter of Plastoflex Primer per single coat.

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### STOCK KEEPING:

**COLOR:** Transparent

**CONTAINER SIZE:** One quart (946 ml)

**SHELF LIFE:** Two years if stored unopened at room temperature.

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### SAFETY ASPECTS:

**READY TO SPRAY VOC:** Plastoflex Primer: 6.8 lb/gal      815 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.