

# 1K Plastics Primer

**LESONAL**

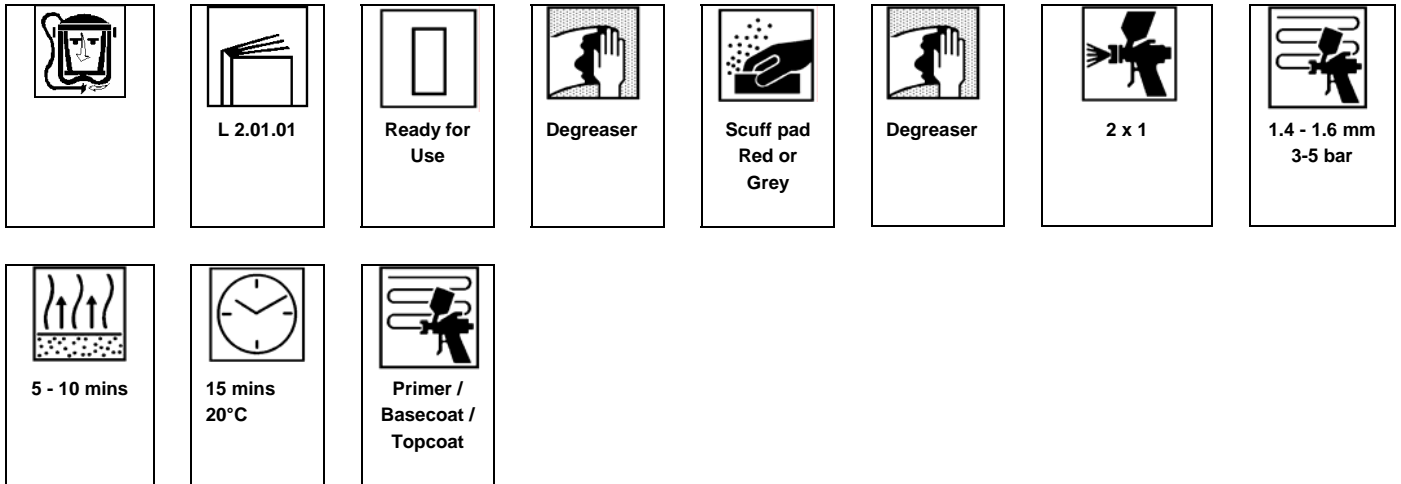
Technical Data Sheet



August 2006

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**Description** | Air drying, one-pack primer for most common plastic car body parts. To promote the adhesion on most common plastic car-body parts.



## Product & ancillary items

|                        |                             |
|------------------------|-----------------------------|
| <b>Product:</b>        | Lesonal 1K Plastics Primer. |
| <b>Chemical Basis:</b> | Polyurethane resin.         |

## Method of use

|   |  |                      |                          |
|---|--|----------------------|--------------------------|
| <b>Substrates:</b>                                    | Plastic substrates.<br>Adhesion may be lower on plastic substrates made of pure PP (polypropylene), pure PE (polyethylene) and similar components. |                      |                          |
| <b>Substrate Preparation:</b>                         | Degrease plastic surface thoroughly. Scuff surface with red or grey scuff pad. Next, degrease again and remove the dust with a tack rag.           |                      |                          |
| <b>Mixing Ratio:</b>                                  | Ready for use.<br><br>Shake well before use.   |                      |                          |
| <b>Spraying Viscosity:</b>                            | 16 – 18 secs DIN Cup 4 at 20°C.  |                      |                          |
| <b>Application Equipment &amp; Spraying Pressure:</b> | <b>Spraygun</b>  | <b>Fluid Opening</b> | <b>Spraying Pressure</b> |
|   | Gravity Feed   | 1.2 – 1.5 mm         | 3 – 5 bar                |
|   | Suction Feed   | 1.4 – 1.6 mm         | 3 – 5 bar                |
|   | HVLP Gravity Feed  | 1.3 – 1.6 mm         | 0.7 bar                  |
|   | HVLP Suction Feed  | 1.6 – 2.2 mm         | 0.7 bar                  |
| <b>Application Technique:</b>                         | Apply one or two wet coats, allowing for flash-off time of 5 – 10 minutes between  |                      |                          |

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|                                 |  |
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|                                 | coats.   |
| <b>Drying Times:</b>            | 15 – 20 minutes at 20°C.<br><br>May be recoated without previous flattening. If necessary, denib with scuff pad grey. After one night's drying, surface must be scuff with grey scuff pad prior to recoating.  |
| <b>Film Thickness:</b>          | Approximately 10 µm per coat.  |
| <b>Theoretical usage per m2</b> | 7 m <sup>2</sup> at layer thickness of 15 micron (the practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances). |
| <b>Recoatibility:</b>           | Recoatible by spray with Lesonal Basecoat SB MM 120 / Lesonal Clearcoats (any) / Lesonal 2K Topcoat MM 320 / Lesonal 2K Primer 480 / Lesonal Fast Dry Primer 410.  |
| <b>Equipment Cleaning:</b>      | Use Lesonal Multi Thinner 810 (any) or Lesonal NC Thinner 820.   |
| <b>Colour:</b>                  | Transparent.   |
| <b>Shelf life</b>               | 2 years.   |

**Health & Safety Data:** These products are intended for professional use only. Please refer to can labels and Safety Data Sheets concerned for more specific information. The user of these products is required to comply with the national laws pertaining to Health & Safety disposal. *The above information is given in good faith, but without warranty, as the final results are also dependent upon factors of use which are outside our control.*