

TECHNICAL INFORMATION

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Product name: Plastic Primer Spray APP Kunststoff Ref Primer Spray. APP No.: 020906.

Elastic, quick-drying, one-component primer that improves primer and top coat adhesion to plastic, available in pressure container. It is purposed for polycarbonate diffusers and covers (PC) and is compatible with “wet on wet” system and other plastic.

Packaging: 400 ml spray.

Basic components: Elastic combination of resins.

Colour: Transparent colourless.

Yield: 1.5-2 m²/container

Caution!

In practice coverage depends on different factors including: shape, substrate roughness, application method and ambient conditions.

Purpose

Purposed for application of plastic components made from: PC, ABS, EP-laminate, PA, PBTP, POM, PP/EPDM, PPO, PUR-hard, PUR-soft and PVC e.g. headlight diffusers, mirror casing, spoiler, bumpers etc..

Advantages

- Short drying time.
- Compatible with wet on wet system.
- Multi- purpose use on many substrates.
- Provides uniformed colourless and transparent coat that improves adhesion to PC – no cracking.
- Product ready to use in pressure container provided with wide open nozzle that imitates application with spray gun.

Substrate

Appropriate substrate:

PP/EPDM	Modified Polypropylene	Elastic
ABS	Acrylonitrile Butadiene Styrene	Elastic
PPO	Polyphenyle Oxide Polymer	Elastic
PA	Polyamide	Elastic
PBTP	Poly-Butylene Terephthalate	Elastic
PUR	Polyurethane	Soft
PC	Polycarbonate	Elastic

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Substrate preparation:



Clean and degrease the surface with plastic dedicated antistatic APP WK900 stripper or APP WB910 stripper.

In case of hard plastic, sanding with P240/320 sandpaper or medium abrasive pad (red coloured) is recommended upon drying.

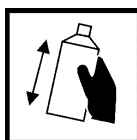
In case of soft plastic, sanding with P400/500 or fine (grey coloured) abrasive pad is recommended.

Clean with APP WK900 stripper again.

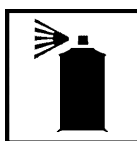
Caution!

If it is difficult to remove bond-breaking agents (e.g. paste) heat the plastic component at temperature +60°C for 30-60 min., and then degrease again with APP WK900 antistatic stripper dedicated for plastic and allow to dry.

Use



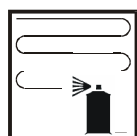
Before use, mix well the container by shaking for 2-3 minutes.



Test spraying is recommended.

Apply by spraying evenly keeping distance 20-30 cm.

Application:

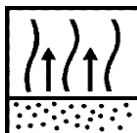


Coat qty: 1-2 x 1.

Dry coat thickness: 3-5 µm.

Recommended ambient conditions:

- Minimum temperature: +15°C,
- Maximum relative humidity: 80%.



Evaporation time between coats at temperature +20°C:

- 3-5 min.

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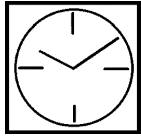


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Drying



At temperature +20°C:
Dust dry: 5 min.
Readiness for covering: 10-15 min.

Headlight diffuser repair

Degrease the surface with APP WK900 stripper.

For protection during works, cover the adjacent parts with silver reinforced protective tape APP S 50. In case of works performance with open bonnet, cover the interior with masking film.

Firstly remove any visible damages and damaged protective coat of polycarbonate glass (PC) using abrasive disks and eccentric sander e.g. NTools ROS, NTools SWR, as well as exhaust system.

Recommended sandpaper grades (in order):

- Coarse sanding P180, P240, P320, P500, P800,
- Finish sanding: P1000, P1500, P2000,
- Manual finish sanding at hard to access places with water resistant sandpaper: P800, P1200, P1500; P2000.

Firstly dry, clean and degrease the surface with APP WK900 stripper.

Then cover the adjacent elements with self-adhesive tape and paper or masking film. Wipe the surface with dust absorber cloth.

Priming – to ensure good adhesion of top coat, firstly apply one thin coat of APP Kunststoff Ref Primer Spray and wait for ca. 10-15 minutes.

Top coat – following primer evaporation, mix with the hardener and then apply with spray gun two coats of clear top coat APP Klarlack FD Spray adhering to evaporation time between coats of 5-10 minutes or other clear top coat cured by chemical reaction. It is recommended to mix the top coat with APP Elastic elasticizer (30%).

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Coverage:

- For headlight diffusers:
APP Klarlack FD Spray, APP Klarlack UHS,
APP Klarlack Glosser, APP Klarlack S Pro etc.,
- APP AcrylFiller 401,
- APP AcrylFiller 501,
- APP AcrylFiller Rapid,
- APP AcrylFiller Compact,
- APP Primer Filler,
- Acrylic top coats including e.g.
APP Modular Acryl Line.

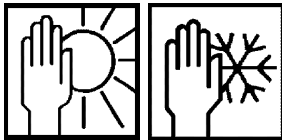
Caution!

In case of plastic substrate, before mixing with hardener, APP Elastic elasticizer shall be added to products sprayed on APP Kunststoff Primer Ref. Spray according to mixing table.

Tool cleaning:

Before nozzle cleaning, firstly position the container upside down and activate aerosol for moment. The propellant gas will push remains of paint to prevent drying and will enable subsequent use of spray.

Storage:



Store in closed, original containers, in dry and well ventilated spaces.
Protect against freezing.

Occupational safety:



Product for professional use only.
See: labels on containers and the Material Safety Data Sheet.
User shall follow applicable local and national industrial safety regulations.

VOC:

Permitted VOC in g/L of product ready to use.
780 g/L for APP Kunststoff Ref Primer Spray
Maximum VOC in g/L of product ready to use.
714.1 g/L for APP Kunststoff Ref Primer Spray

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