

1K Multi Plastic Primer

Primer

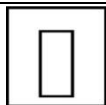
01/08/2019

L2.01.05

DESCRIPTION

Lesonal 2K Primer 480 is an air drying, one-pack primer to promote the adhesion on plastic car-body parts.

Mixing ratio



RFU

1K Multi Plastic Primer

Equipment



Spray gun set-up:
1.3-1.5 mm

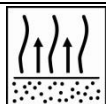
Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.7 bar at the air cap

Application



x 1 coat

Flash-off



Between coats
NA

Recoat after:
20 minutes at 20°C

Application



All Lesonal Primers, Fillers and topcoats

Protection



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

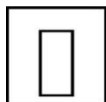
Product 1K Multi Plastic Primer

Basic raw materials Polyolefine resin

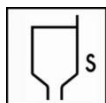
METHOD OF USE

Suitable substrates All plastic car parts with the exception of pure PE (polyethylene).

Mixing None, shake well before use.



Spraying Viscosity 14-16 sec. DIN Cup 4 at 20°C.



**Spray gun set-up /
application pressure**

Spray gun
Gravity feed

Fluid tip-set-up
1.3-1.5 mm

Application pressure
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.7 bar at the air cap



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APPLICATION TECHNIQUE

Application process & blending

Apply even closed coat.
Note: minimum application temperature 15°C
Allow for a flash off time of 20 minutes at 20°C



Film Thickness

By using the recommended application: 1-4 µm per coat

Theoretical Coverage

11.4m²/l unthinned paint at 1 µm (the practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances).

Recoatability

All Lesonal primers and topcoats

Cleaning of equipment

Use Lesonal Multi Thinner 810 (any)

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
Product shelf life data see TDS S9.02.01

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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