

GENERAL INFORMATION

SP5399 1K Plastic Primer is an adhesion primer based on special resins to promote adhesion on new un-primed plastic parts for the Automotive Refinish Industry.

MIXING RATIO



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GUN SET UP



| | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|------|-------------|--------------------------|
| HVLP | 1,3-1,4 | 2/29 |
| HE | 1,3-1,4 | 2/29 |

APPLICATION



1 coat 15-20 µm (0,4-0,8 mil)

FLASH OFF AND DRY TIMES



| | AIR DRY 20°C / 68°F | FORCED DRY 60°C / 140°F |
|---------------|------------------------|----------------------------|
| Flash off | 15 - 20 minutes | Flash off - |
| Dust free | 20 minutes | Dust free - |
| Dry to handle | - | Dry to handle - |
| Dry to tape | - | Dry to tape - |
| Dry to sand | - | Dry to sand - |
| Dry to polish | - | Dry to polish - |

SUBSTRATES



| Plastic substrate code | Type |
|------------------------|------------------------------|
| PP-EPDM | Flexible Plastic |
| TPO | Flexible Plastic |
| ABS | Medium Plastic |
| PUR | Flexible - Soft/Hard Plastic |
| PA | Hard Plastic |

All common plastic types currently used to produced OEM exterior parts and used in automotive refinish Industry. Do not use with Polyethylene (PE) and pure Polypropylene (PP). Do not use on pre-primed plastic parts if unsure of the plastic type, test adhesion prior to refinishing.

POT LIFE AT 20°C / 68°F



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COMPONENTS



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ADDITIVES



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SURFACE PREPARATION



- Remove the release agent by washing down the substrate with hot soapy water and a scuff pad fine or equivalent.
- Rinse the substrate thoroughly with clean water.
- Blow dry the substrate, degrease with SP6499 Silicone Remover.
- Scuff the unprimed plastic parts with a fine scuff pad to prepare smooth substrates and medium-coarse scuff pad for textured substrates.
- Degrease again with Antistatic Degreaser.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER

All 2K Primers/Surfacers

Except Epoxy Primers and Washprimers.

EU REGULATIONS

| VOC Code | | - |
|--|-------------------------|--|
| Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product. | | - |
| Chemical Base | Special resins | |
| Physical Properties | Viscosity | < 12 sec / Dincup 4 / 20°C |
| | Specific Gravity (kg/l) | 0,874 |
| | Flash Point Closed Cup | 24°C / 75,2°F |
| | Vol. % Solids | 4,4 |
| | Economy: Ready to spray | 9 m ² /L/5 µm 365 ft ² /Gal/0,2 mil |
| | Gloss | Matt |
| | Colour | - |



SP5399

1K Plastic Primer

PROTECTION



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

CLEAN UP



Gun Cleaner

STORAGE/SHELF LIFE

Minimum 3 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



NOTES