

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 0-20 µm (0,4-0,8 mil)

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 60°C / 140°F		FORCED DRY 60°C / 140°F
Flash off	15 - 20 minutes	Flash off	15 - 20 minutes	
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

NEXT LAYER

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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.	Not applicable
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
Film thickness	5 micron 0,2 mils
Economy; Ready to spray	9 m ² /L/5 µm 360 ft ² /qtr./0,2 mils
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 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



NOTES