


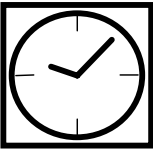


ALL PLASTIC PRIMER

DESCRIPTION: Lesonal™ All Plastic Primer is a fast drying, transparent adhesion primer for all raw plastic parts.

PRODUCT: All Plastic Primer

BASIC RAW MATERIALS: Special polyester resins

APPLICATION:

-  Contains special polyester resins xylene and other ingredients.
-  Ready to Spray
-  1-2 Medium Coats
Siphon Feed: 1.6–1.8 mm
Gravity HVLP: 1.3–1.5 mm
-  (non-sanding)
5–10 minutes at 70°F (20°C)
-  Apply
- Lesonal™ topcoats
- Suitable Undercoats

SUITABLE SURFACES: All raw plastic parts.

NOTE: Do not use Lesonal™ All Plastic Primer over primed or painted existing surfaces.

SURFACE PREPARATION: Degrease with Lesonal Plastic Surface Cleaner. In areas where VOC emissions regulations apply, use recommended pre-cleaning product. Thoroughly abrade substrate with a gray scuffing pad and Lesonal Plastoblend. Thoroughly rinse with clean water. Degrease again with Lesonal Plastic Surface Cleaner.

When degreasing and cleaning unpainted plastic parts, allow the part to dry out for 20–30 minutes after the application of Lesonal Plastic Surface Cleaner and before the application of Lesonal All Plastic Primer.



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MIXING RATIO: The product is ready to spray.

VISCOSITY: 13–14 seconds DIN Cup #4 at 70°F (20°C).

POT LIFE: None

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
Siphon HVLP	1.8–2.2 mm	max 10 psi
Gravity HVLP	1.3–1.5 mm	max 10 psi

APPLICATION METHOD: Spray one to two medium coats.

FLASH TIME: 5–10 minutes at 70°F (20°C).

RECOATING: May be recoated with Lesonal™ HS Surfacer/Sealer, LV HS Surfacer/Sealer, Gray Urethane Surfacer (including Low VOC version), Epoxy Primer Sealer and Basecoat SB without sanding up to a maximum of 16 hours at 70°F (20°C). When using these undercoats over flexible plastic parts, Flex Additive must be used. Do not use flex additive in Lesonal Epoxy Primer Sealer or Basecoat SB. (See Lesonal Flex Additive technical data sheet for details.)

NOTE: After 16 hours at 70°F (20°C), abrade with the gray pad and reapply Lesonal™ All Plastic Primer.

FILM THICKNESS: 0.5 – 0.8 mil per single coat

SHELF LIFE: 2 years if stored unopened at room temperature.

SAFETY ASPECTS:

READY TO SPRAY VOC: 7.0 lb/gal (840 g/liter)

NOTICE: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for which they come in contact. The manufacturer recommends the use of an organic vapor respirator or air-supplied respirator when exposed vapors or spray mist.