

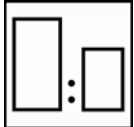


WANDA PLASTIC PRIMER 405.02500

FOR PROFESSIONAL USE ONLY

Description

Wanda Plastic Primer is a one-pack product designed to promote adhesion on plastic substrates.



Ready to spray



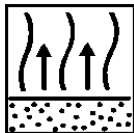
Spray gun set-up:
1.2 – 1.4 mm
HVLP max. 10 psi at air cap

Application pressure:
30-40 psi (spray gun air inlet)
o Check gun manufacturer specification



Application: Ready to spray
2 Single Coats

o Do not apply over Primed Plastic parts



Dry Time & Between Coats:
Allow each coat to flash off for approximately 5 to 10 minutes at 70°F (20°C).
Recoat time: 15-30 minutes before applying topcoat.



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

Read complete TDS for detailed product information

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Description

Wanda Plastic Primer is a one-pack product designed to promote adhesion on plastic substrate.

Suitable substrates

- Bumpers, rear-view (mirrors) and other plastic parts.

Products and additives

Product: -Wanda Plastic Primer - 405.02500

**Activators /
Reducers:** - None

Additives: - None

Basic raw materials

-Wanda Plastic Primer: Ureic resin and polyolefin, solvents and additives.

Surface preparation

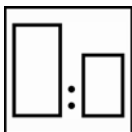


- Wash the panels with soapy water, rinse and dry.
- Dry it with air.

- o For Unprimed plastic surfaces:
 - Sand surface with gray scuff pad.
 - Using a clean cloth, re-clean part using Wanda Degreaser 408.10400. While degreaser is still wet, wipe dry with second dry, clean cloth.
- o For Repaired plastic surfaces:
 - Sand as required.
 - Using a clean cloth, re-clean part using Wanda Degreaser 408.10400. While degreaser is still wet, wipe dry with second dry, clean cloth.
 - Apply only over areas of exposed raw plastic.

NOTE: Do not apply over Primed plastic parts.

Material preparation and mixing

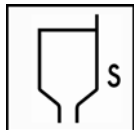


Ready to Spray

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Spray Viscosity



12–14 seconds DIN cup #4 at 70°F (20°C).

Spray gun set-up / application pressure



Spray gun	Fluid tip – set-up	Application pressure
Siphon feed	1.3-1.4 mm	30-40 psi at the spray gun air inlet
Gravity feed	1.2-1.4 mm	30-40 psi at the spray gun air inlet
Gravity feed HVLP	1.2-1.4 mm	HVLP max 10 psi at the air cap
		o Check gun manufacturer specification

Pot-life

Indefinite when stored in sealed container at room temperature.

Application process



Apply 2 single coats.
Allow each coat to flash off for approximately 5 to 10 minutes at 70°F (20°C).
Recoat time: 15-30 minutes before applying topcoat.

Film thickness

Approximately 3 - 5 microns per coat.

Recoatable with

– Wanda Primer (405.08980), Sealer (405.03100), Wandabase HS, Wanda PU 2K HS

Material usage

Theoretical material usage is $\pm 269.1 \text{ ft}^2/\text{L}$ RTS mixture, per coat

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Use Wanda Reducer – 407.04001

VOC

The VOC content of this product in ready to use form is 7.0 lb. /gallon. (840gr/lit)



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Storage / Shelf life

Product shelf-life is determined when products are stored unopened.
Shelf life: 3 years at 70°F and 95°F (20°C and 35°C)

Notes

Before spraying on pure polyethylene (PE) and polypropylene (PP) substrates, do an adhesion test, following the normal spraying procedure.

In general, the plastic identification is on the other side of the substrate.

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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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