

220-222 Plastiprimer Neutral Post-Cat Pigmented Primer

Product codes:	220-222 Plastiprimer Neutral	Viscosity	610 ± 30 cps at 25°C
		Flash Point:	7°C
		Density (kg/l):	1.16 ± 2% at 25°C
		Solid (% by weight):	58%
		Solid (% by volume):	42%
		Shelf Life (months):	12

Product Description:

Plastiprimer is a fast drying, easy to sand, high solids acid curing primer for interior use that gives a smooth, dense finish suitable for topcoating to produce very high quality pieces.

Uses:

Plastiprimer is especially suited to the sealing of MDF profiles. The product adheres well to wood and wood products. For interior usage only.

Environmental Data (as supplied):

VOC less exempt lb/gal:	<5.20
VOC lb/gal:	<4.47
VOC less exempt g/l:	
VOC g/l:	
VOC lb/lb Solid:	<1.85
VHAPs lb/lb Solid:	<0.7

Note:

See individual compliance sheets for specific data

Application Data

Suggested Uses:	Spray
Mixing Ratio:	10% 999-017
Suggested Uses:	4 hours, if reduced 10 to 20% with 121-8020
Application Viscosity:	22-30 sec Zahn #2 at 25°C
Reducer:	121-8020 (for recommended viscosity, add 10 to 20% by volume)
Retarder:	N/A
Clean-up Solvent:	Lacquer Thinner
Recommended Wet Film:	3 - 5 mils wet
Coverage:	N/A

Note:

N/A

Directions for use:

Surface Preparation:

Substrate must be sanded with #120, 150 grit paper, free of dust and other contaminants. Before the application of the topcoat, the Plastiprimer must be sanded with a #280/320 grit paper. The primer must be recovered within 8 hours after sanding. This primer must not be applied over metal, old finish or nitrocellulose lacquer.

General Information:

Mix well before and during the addition of catalyst and diluents. To assure consistency, always keep the product under agitation. The Plastiprimer can be applied in one or two coats. A good sanding between coats with paper # 240/320 is needed to get a good adhesion. The Plastiprimer must be covered within 8 hours after the sanding. When sanding, it is important not to wear through the surface and to pay particular attention to sharp edges of the profile. This can create a non-uniform thickness of the application. Once catalyzed, avoid all contact with metallic surface. The dry film thickness of the Plastiprimer must not exceed 3 mils. The total dry film thickness of the system should not exceed 6 mils.

To obtain a complete cure, the system should be applied at an ambient temperature above 18°C and a relative humidity below 65%. During curing, this product should not be exposed to ammonia vapors. The finished surface cannot be cleaned with an ammonia-based product. Always use containers and equipment in plastic or stainless steel to eliminate any source of discoloration due to oxidation.

The Plastiprimer is used under following topcoats: 117-32XX, 440-XXX

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:

	Room Temperature (20°C / 68°F)	Forced Drying Schedule (50°C / 122°F)
Tack Free Time:	20 - 30 minutes	Flash off before entering oven
Dry to Sand:	60 - 90 minutes	3 - 4 hours
Dry to Stack:	30 - 45 minutes	60 - 90 minutes

Note:

N/A

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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