

901R / 907R

01.11.2014

2K PLASTIC PRIMER-SURFACER

DESCRIPTION

Special 2-component primer-surfacer for all common plastic parts found on vehicle exteriors.
Colour: white and black.
Composition based on special polymers. Non-isocyanate primer-surfacer.

PRODUCTS

901R	2K Plastic Primer-Surfacer – white
907R	2K Plastic Primer-Surfacer - black
915R	2K Plastic Activator

PROPERTIES

- Requires no adhesion promoter and is suitable for all common plastics on vehicle exteriors.
- Reliable adhesion, high elasticity and good filling.
- Non-sanding primer-surfacer.
- Light wet sanding is possible after bake (30 min at 60°C or 2 hr air dry).
- Perfect topcoat hold-out.
- Can be coated with all topcoats.

SUBSTRATES

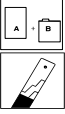







- All common plastic parts found on vehicle exteriors:
PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, PUR, PUR flexible foam and UP-GF.

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PRODUCT PREPARATION

	Mixing ratio ValueShade®	ValueShade® 1 ValueShade® 2 ValueShade® 3 ValueShade® 4 ValueShade® 5 ValueShade® 6 ValueShade® 7	901R 100 94 86 67 50 33 0	907R 0 6 14 33 50 67 100
	M-6148 Mixing ratio	901R/907R 915R	Volume 1 1	Weight 100 74
VOC	681 g/l			
 Pot life at 20°C	8 hr			
 Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	16-18 s 16-18 s 18-20 s		
	It is strongly recommended to use appropriate personal protection equipment during application.			
 Spray equipment	Compliant guns Gravity feed Suction feed Pressure feed Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip 1.2-1.5 mm 1.4-1.6 mm 1.0-1.2 mm 1.3-1.6 mm 1.5-1.7 mm 1.0-1.2 mm	Distance 15 cm 15 cm 15 cm 20-25 cm 20-25 cm 20-25 cm	Pressure According to supplier's specifications 3-4 bar 3-4 bar 3-4 bar
 Number of coats	Gripcoat followed by 1 full coat.			
 Flash time	Wet-on-wet: 20 min before topcoat application (maximum 24 hr). Exception: 45 min before waterborne basecoat application. Before bake: 10 min.			
DFT	25-30 µ			
 Dry to sand at 20°C at 60°C	If required, the product can be sanded lightly with wet sanding paper (P800 - P1000) after: 2 hr 30 min			
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.				

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SURFACE PREPARATION

1. Preheat 30 min at 60°C.
2. Allow to cool.
3. Clean surface with water and soap. Rinse and dry.
4. Clean with a preparatory cleaner for plastics. Wipe dry with a clean cloth.
5. Scuff sanding with sanding pad.
6. Remove all traces of sanding dust, blowing oil-free compressed air.
7. Optionally clean with preparatory cleaner for plastics. Wipe dry with a clean cloth.
8. Degrease with a correct final cleaner/degreaser.
9. Wipe and blow dry.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

REMARKS

- Degrease AAS, ABS, PC and PVC with a correct final cleaner/degreaser.
- For PP and POM flame treatment is needed.
- Material has to be at room temperature (18-25°C) before use.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.

PRODUCT DATA

Package viscosity: 1400 cp
Theoretical coverage: 7-9 m²/l at recommended DFT - ready-to-spray

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SAFETY

This product is classified according to regulation (EC) 1272/2008 (CLP). Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the paint system build-up are from Cromax[®]. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax[®], unless explicitly indicated otherwise.

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