

1K Plastic Primer

IC-910 Universal Plastic Adhesion Promoter

Product Description







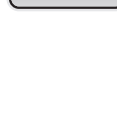
It is single-component product that combines an adhesion promoter, flex agent and blending aid in one, which provides superior adhesion on all common automotive plastics. It has good color coverage with 10% of any basecoat.

Technical Characteristics

Color: Slightly hazy yellow Recommended Storage Temperature: 5°C - 25°C/41°F - 77°F
Shelf life: 24 months Theoretical spreading rate: 250 - 300 m² / l (avg) at 1 µm

Pre-treatment

Degrease with IC-800 and washed with a tack rag. Scuff the unprimed plastic parts with a fine scuff pad to prepare smooth substrates and medium-coarse scuff pad for textured substrates. Shake well and filter before each use to secure a uniform mixture.

 Mixing Ratio	IC-910 Plastic Primer 90 (vol) Basecoat 10 (vol)	90 g 12 g	
 Spray Viscosity and Potlife	Mix well and strain before application. Spray Viscosity (20°C /68°F) Pot - Life (20°C /68°F)	10 - 13 s 24 h	
 Spray Guns	HVLP gravity - feed spray gun Conventional gravity - feed spray gun	1.2 - 1.4 mm 1.3 - 1.6 mm	1.5 - 2.0 bar 3.0 - 4.0 bar 10 - 15 cm 15 - 20 cm
 Application	Number of spray coats Film thickness	1 half wet + 1 wet coat 50-60 um	
 Drying	Drying Flash off Dust free after Ready for assembly after Ready for polish after	20°C/68°F 3 - 5 mins 5 - 10 mins - - -	60°C/160°F - - - -
 IR Drying	IR drying after dust free Step 1 - short wave: - Step 2 - medium wave: -		
 VOC(Ready to spray)	Actual VOC (Maximum) Regulatory VOC (Maximum) Weight of Solid Applied	523g/l (4.36lbs/gal) 782g/l (6.52lbs/gal) 9.5%	Further Treatment: Scuff with scuff after specified drying times and cooling.