

Product Information

Plastiprimer 220-214

PRODUCT DESCRIPTION

Plastiprimer is a fast drying, acid curing primer for interior use that gives a smooth, dense finish suitable for topcoating to produce very high quality pieces. Plastiprimer adheres well to wood and wood products and is extremely easy to sand. After sanding, it may be topcoated with Plasticolor® or Super Plasticolor®.

FEATURES

Plastiprimer must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.

Plastiprimer must not be used and dried at temperatures below 18°C or relative air humidity above 65% as the hardening may otherwise become incomplete. During hardening, the enamel must not be exposed to ammonia vapours.

Ammonia cleaners should not be used for cleaning the finished surface.

SPECIFICATION VALUES

| | |
|------------------------|--------------|
| Gloss: | Matte |
| Flash Point: | -1°C (48°F) |
| Specific Gravity: | 1.24 |
| Weight per Gallon: | 10.4 lbs. |
| Solids by Weight: | 63% |
| Solids by Volume: | 45% |
| Fire Hazard Class: | 3 |
| Health Hazard Class: | 2 |
| Viscosity: | 600 cps |
| EPA VOC: | 465 g/l |
| Lbs. VOC/Gallon: | 3.88 lbs/gal |
| Lbs. VOC/lbs solids: | 0.60 |
| Lbs. VHAPs/lbs solids: | 0.25 |

Values at Application:(10% catalyst, 30% reduction)

Lbs. VHAPs/Lbs. Solids: 1.00

Lbs. VOC/Lbs. Solids: 0.30

If additional reducers or additives are used, compliance values must be recalculated.

SPECIFICATION INFORMATION

Shelf Life: Six months recommended if unopened and stored between 15°C - 25°C (59°F - 77°F). Always rotate stock.

Pot Life: Mix only enough material for 8 hours use for optimum product performance. Use of product that has been catalyzed for more than 8 hours may result in film failure.

Coverage: Coverage is 12-13 m²/L (550 sq.ft./G) at 1 mil dry and 100% transfer efficiency.

Hardener Mixing Ratio: 10 parts by volume 220-214 Plastiprimer. 1 part by volume 999-017 Hardener.

Reduction: Use slow reducer 121-802 for hot climates and extra flow. Use reducer 121-803 for temperature climates. Use reducer 121-032 to improve pot life. Use up to 30% by volume of thinner as required to obtain recommended viscosity.

DIRECTIONS FOR USE

Surface Preparation: Substrate should be sanded with 120, 150 or 180 grit sandpaper prior to application of Plastiprimer.

Directions for Use: Plastiprimer is applied in one or two coats and can be used as a primer for most wood and wood products meant for indoor use. A thorough sanding between coats is essential to adhesion. A second coat or topcoat must be applied no more than eight hours after the primer has been sanded with 240/320 grit paper. Care should be taken to avoid sanding through the primer coat.

With profiled edges, care must be taken with sanding of the primer to avoid sanding through on sharp edges. Complex profiles or profiles with sharp corners may cause difficulties in obtaining an effective prime coat of even thickness. In these cases, profile design must be discussed with your technical representative.

Contact with metal surfaces should be avoided once the Plastiprimer has been catalyzed. To ensure product uniformity, the material should be agitated at all times.

Recommended film build of Plastiprimer is not to exceed 4 mils dry. Total recommended film build of Plastiprimer and topcoat is not to exceed 6 mils dry.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this Technical Data Sheet will likely result in unsatisfactory film appearance or film failure.

The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION

Method of Application

| Method | Viscosity | Recommended | |
|----------------------|------------|-------------|--------------|
| | | Wet Film | Dry Film |
| Spray - Conventional | 20-30"/Z#2 | 4-5 mils | 1.8-2.2 mils |
| - Airless | 22-35"/Z#2 | 4-5 mils | 1.8-2.2 mils |
| - HVLP | 35-50"/Z#2 | 4-5 mils | 1.8-2.2 mils |
| Curtain Coater | 35-50"/Z#2 | 4-5 mils | 1.8-2.2 mils |

Note: All measurements recommended are based on results at temperatures of 20°C.

Drying Times:

Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures.

| | |
|---------------|--------------------------------|
| At 20°C: | (Minimum Required) |
| Tack Free: | 10-15 minutes |
| Dry to Sand: | ~4 hours |
| Dry to Stack: | Overnight |
| At 50°C: | |
| Tack Free: | Flash off before entering oven |
| Dry to Sand: | 30-40 minutes |
| Dry to Stack: | 60-90 minutes |