

Technical Data Sheet

Date of Issue: 01/09/2021 Revision Date 01/09/2021 | Version 1.0

Product name

# MASTERMIX PLASTIC PRIMER



## PRODUCT DESCRIPTION

Transparent 1K adhesion promoter. (PTK 186)

## INTENDED USES

Adhesion promoter to all exterior OEM plastic car parts except polyethylene

## FEATURES AND BENEFITS

- Ready for spraying.
- Very fast drying.

## PRODUCT INFORMATION

Appearance	Transparent
Volume Solids	± 5%
Recommended DFT	Min: 3 µm, Max: 5 µm
Recommended WFT	Min: 60 µm, Max: 100 µm
Theoretical spreading rate	10.0 m <sup>2</sup> /ℓ @ 5 µm DFT at stated volume solids
VOC	800 g/l
Flash Point	< 27°C
Viscosity	Ready for spraying

## APPLICATION DETAILS

Mixing	Mix thoroughly until homogeneous.		
Method	<u>Conventional spray (HVLP):</u> Recommended Tip size: 1.2 - 1.3 mm Nozzle pressure: 1 – 1.5 bar		
Application environment	Surface Temperature	Min*: 10°C	Max: 40°C
	Ambient Temperature	Min*: 10°C	Max: 40°C
	Relative Humidity	Min*: 10%	Max: 85%
	*or 3°C min. above dew point		



Thinning	Not required.	
Cleaning	FLOWLINE THINNER (KNT 1)	
Drying Time	Touch dry	10 min at 23°C
	Overcoating	10 min at 23°C

### STORAGE AND PACKAGING

Store away from direct sun, heat, open flames, sparks and severe cold.  
Shelf Life: 18 months

### SURFACE PREPARATION

Ensure that surfaces are dry, sound and free from dust, dirt, grease and oil before painting.

#### POLYPROPYLENE and PLASTIC – NEW

- Bake for two cycles 30min at 60°C to exude release agents.
- Remove all contamination with MASTERMIX PRE-CLEANER (PTK 310). Using the spray on wipe off method. Abrade surfaces with P5000 - 800 grit sandpaper to provide a key.
- Leave overnight or bake for 40min at 60°C.

#### POLYPROPYLENE and PLASTIC - REPAIRS

- Remove all contamination with MASTERMIX PRE-CLEANER (PTK 310). Using the spray on wipe off method. Abrade surfaces with P500 - 800 grit sandpaper to provide a key.

### APPLICATION INFORMATION

Applicators must ascertain the most suitable needle, Fluid tip, and air cap for the article being coated. Air and atomising pressures must be set to produce the optimum delivery efficiency and quality of finish.

### SAFETY PRECAUTIONS

- Always keep paint out of reach of children.
- Ensure good ventilation during application and drying.
- If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner.
- Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention.
- Harmful if swallowed. Seek medical attention and do not induce vomiting.



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- Do not smoke while painting.
- Flammable. Store in a cool dry place away from heat and sparks.
- CATALYST contains isocyanate – use suitable respirator, particularly during spray application of the mixed material.
- Refer to Safety Data Sheet for complete information.

#### **DISCLAIMER**

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

**NB:** Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

**NB: TO ORDER:** Quote product name, product code number, packaging and colour.

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