

CAR REFINISH PAINTS

DYO 2K PLASTIC SURFACE PRIMER (563-1405)

Resin Base : Acrylic Copolymer Based

Products required	<ul style="list-style-type: none"> - Dyo 2K Plastic Surface Primer 563-1405 - Acrylic Primer Hardener 871-0A90 - Universal Thinner 803-9391 - Plastic Surface Cleaning Thinner 803-9330 																										
Properties	Plastic adhesion primer for all paintable plastics found on cars.																										
Substrates	<p>Paintable plastics found on cars :</p> <p>a) Flexible plastics</p> <table> <tr> <td>PP-EPDM</td><td>Polypropylene (Rubber modified)</td></tr> <tr> <td>PUR foam</td><td>Polyurethane Integral Foam (RIM)</td></tr> </table> <p>b) Hard / Rigid Plastics</p> <table> <tr> <td>ABS</td><td>Acrylic Butadiene Styrene</td></tr> <tr> <td>GFK/GRP</td><td>Glass Fibre Reinforced Plastics</td></tr> <tr> <td>GF-UP</td><td>Glass Fibre Reinforced Polyester</td></tr> <tr> <td>SMC</td><td>Sheet Moulding Compound</td></tr> <tr> <td>DMC/BMC</td><td>Bulk Moulding Compound</td></tr> <tr> <td>PVC hard</td><td>Polyvinyl Chloride</td></tr> <tr> <td>PC</td><td>Polycarbonate</td></tr> <tr> <td>PA</td><td>Polyamide</td></tr> <tr> <td>PBTP</td><td>Polybutyleneterephthalate</td></tr> </table> <p>Non paintable plastics :</p> <table> <tr> <td>PP/PE</td><td>Polypropylene / Polyethylene</td></tr> <tr> <td>PVC soft</td><td>Polyvinyl Chloride</td></tr> </table>	PP-EPDM	Polypropylene (Rubber modified)	PUR foam	Polyurethane Integral Foam (RIM)	ABS	Acrylic Butadiene Styrene	GFK/GRP	Glass Fibre Reinforced Plastics	GF-UP	Glass Fibre Reinforced Polyester	SMC	Sheet Moulding Compound	DMC/BMC	Bulk Moulding Compound	PVC hard	Polyvinyl Chloride	PC	Polycarbonate	PA	Polyamide	PBTP	Polybutyleneterephthalate	PP/PE	Polypropylene / Polyethylene	PVC soft	Polyvinyl Chloride
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Cleaning Plastic Surfaces	Careful cleaning with 822-9330 is absolutely essential.																										
Initial Cleaning	822-9330																										
Sanding	Scotch Brite																										
Re-cleaning	822-9330 (rub dry and allow solvents to evaporate)																										
Tempering	PUR-Foam and PA Polyamide plastics should be tempered for 1 hour at 60°C and thoroughly cleaned with 822-9330 to ensure that pores are opened and any moisture totally dried out.																										

PROCESSING DATA

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Mixing ratio	Volume: 4/1/1 Dyo 2K Plastic Surface Primer: 563-1405 :4 units Acrylic Primer Hardener: 871-0A90 : 1 unit Universal Thinner: 803-9391 : 1 unit
Spray viscosity (DINCUP4) 20°C)	16-18 sn.
Gravity gun nuzzle	1.3-1.5 mm
Suction gun nuzzle	1.6-1.8 mm
Pressure	3-5 bar
Spraycoats	2 coats.
Dry film thickness	15-20 microns
Flash off time (20°C)	15 minutes prior to filler or top coat application.
Drying time (20°C)	60 °C 30 min. 20 °C 8 hrs.
Sanding Wet (with machine) Wet (with hand)	P1000 P800
Suggestions	Before lining application to PP-EPDM bumper surfaces to improve adhesion performance flame operation must be performed. Wet on wet application can be applied with 563-1405 2K Plastic Surface Primer.
Health and Safety Aspects	Please carefully read the health and safety instructions given on product container label. Users of this product are responsible to eliminate the related application wastes accordingly. Also, necessary precautions must be taken during transportation usage and storage.

Use only in well ventilated areas.Wear air breathing apparatus.

This technical information being to the latest standard of technology and contained in this leaflet is to be understood as advice only and not binding in any respect.All details about working with our products should be adapted to prevailing local conditions and materials used. Best results could only be obtained by using appropriate application parameters and equipment. Patents , if any , must be observed. All rights reserved.