

Product Code:
522-1420

VISCOSITY: Z #4/24" at 77°F
FLASH POINT: 26°F (-3°C)
DENSITY (lb/gal): 10.1
SOLID (% by weight): 60%
SOLID (% by volume): 43%
SHELF LIFE (months): 12

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 provides an excellent base and is extremely easy to sand. After sanding, it may be topcoated with Plasticolor 900 White (177-10XX).

Uses: Plastiprimer is designed for hardwoods and MDF. This product offers excellent filling capabilities due to its high solid content (43%).

Environmental Data (as supplied):

VOC less exempt lb/gal: <4.10
VOC lb/gal: <4.10
VOC less exempt g/l: <500
VOC g/l: <500
VOC lb/lb Solid: <0.70
VHAPs lb/lb Solid: <0.25

See individual compliance sheets for specific data

Application Data:	SUGGESTED USES:	Wood Primer
	MIXING RATIO:	10 parts 522-1420 to 1 parts 873-0870
	POT LIFE:	12 hours
	APPLICATION VISCOSITY:	Z #2/20 – 30"
	REDUCER:	803-1325
	RETARDER:	800-5328
	CLEAN-UP SOLVENT:	803-1298
	RECOMMENDED WET FILM:	4 – 5 mils
	COVERAGE:	684 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.



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Directions for Use

Surface Preparation: Substrate should be sanded using 120, 150 or 180 grit steared paper. Plastiprimer cannot be used on metal, old oil or cellulose lacquers. Suitable topcoats are Plasticolor 900 White (117-10XX) or Optiset White (131-90XX)

General information: Mix Plastiprimer thoroughly, then catalyze and reduce material as recommended. Plastiprimer must be well mixed while adding catalyst and reducers and must be agitated at all times to ensure product consistency.

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 using 240/320 grit steared paper between coats is essential for adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded. Care should be taken to avoid sanding through the primer coat. With profiled edges, care must be taken with sanding of primer to avoid sanding through sharp edges. Complex profiles or profiles with sharp corners may cause difficulties in obtaining an effective primer 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 proper 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.

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 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors
Ammonia cleaners should not be used for cleaning the finish surfaces. This may accelerate discoloration.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION.

Drying Times:

	At 68°F	At 122°F
Tack Free Time:	10 – 15 mins.	Flash off before entering oven
Dry to Sand:	1 hour	30 mins.
Dry to Stack:	4 hours	60 mins.

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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