

GENERAL INFORMATION

PA65 1K Plastic Primer is an adhesion primer based on special resins to promote adhesion on new un-primed plastic parts for the Automotive Refinish Industry. PA65 1K Plastic Primer is an adhesion primer based on special resins, to improve adhesion on new un primed plastic parts for Automotive Refinish. Special Note: PA65 1K Plastic Primer can be used as a Plastic adhesion additive in PH254 High Production Non-Sanding Primer, saving you application and drying time. See in PH254 High Production Non-Sanding Primer TDS for Instructions. (This system is recommended with in PH254 High Production Non-Sanding Primer, no other Octoral primer/surfacer.

MIXING RATIO



GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,3-1,4	2/29

APPLICATION



1 coat 5 - 10 µm (0,2-0,4 mil)

FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	15 - 20 minutes	Flash off	-
Dust free	20 minutes	Dust free	-
Dry to handle	-	Dry to handle	-
Dry to tape	-	Dry to tape	-
Dry to sand	-	Dry to sand	-
Dry to polish	-	Dry to polish	-

After more than 2 hours drying of the PA65 1K Plastic Primer, scuff with scuff pad fine or equivalent and re-apply PA65 1K Plastic Primer.

SUBSTRATES



Plastic substrate code	Type
PP-EPDM	Flexible Plastic
TPO	Flexible Plastic
ABS	Medium Plastic
PUR	Flexible - Soft/Hard Plastic
PA	Hard Plastic

All common plastic types currently used to produce OEM exterior parts and used in automotive refinish industry. Do not use with Polyethylene (PE) and pure Polypropylene (PP). Do not use on pre-primed plastic parts. If you're unsure of the plastic type, test the adhesion prior to refinishing.

POT LIFE AT 20°C / 68°F



COMPONENTS



ADDITIVES



SURFACE PREPARATION



Remove the release agent by washing down the substrate with hot soapy water and a scuff pad fine or equivalent. Rinse the substrate thoroughly with clean water. Blow dry the substrate, degrease with TD20 Silicone Remover. Scuff the unprimed plastic parts with a fine scuff pad to prepare smooth substrates and medium-coarse scuff pad for textured substrates. Degrease again with TD25 Antistatic Degreaser.

Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



Octoral 2K Primer / Surfacer
W00 - W999 Octobase Eco Plus System
B00 - B999 Octobase System
A00 - A98 Octocryl System

Except Epoxy Primers and Washprimers. For flexible and soft plastics add 10 - 30%, AE001 Elastic 2K to the 2K paint systems before adding the hardener and thinner if needed.

PHYSICAL DATA

EU REGULATIONS	
VOC Code	2004/42/IIIB(e)(840)830
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIIB/e. Special finishes - All types. EU limit values: 840 g/l. (2007). This product contains a maximum of 830 g/l VOC.
Chemical Base	Special resins
Physical Properties	Viscosity (RTS)
	< 12 sec / Dincup 4 / 20°C
	Specific Gravity (kg/l)
	0,874
	Flash Point Closed Cup
	24°C / 75,2°F
Physical Properties	Volume % Solids
	4,4
	Economy
	9 m ² /L/50 µm
Physical Properties	Gloss
	Matt
Physical Properties	Colour
	-

PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.octoral.com/en/octoral/choose_localization

CLEAN UP



Gun Cleaner

STORAGE/SHELF LIFE

Minimum 3 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



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