OCTORAL

PA65
1K PLASTIC PRIMER

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

-

COMPONENTS

-

GUN SET UP

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

ADDITIVES

-

APPLICATION

1 coat 10 - 20 µm (0,4-0,8 mil)

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.

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.

NEXT LAYER

Octoral 2K Primer / Surfacer
W00 - W999 Octobase Eco Plus System
B00 - B999 Octobase System
A00 - A98 Octocryl System
F00 - F98 Octocoat HS420 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.

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.

PHYSICAL DATA

EU REGULATIONS		
VOC Code		**2004/42/IIB(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.		IIB/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
	Volume % Solids	4,4
	Economy	9 m²/L/5 µm
		365 ft²/Gal/0,2 mil
	Gloss	Matt
	Colour	-

POT LIFE AT 20°C / 68°F

-

The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. Unless valspar agrees otherwise in writing, valspar makes no warranties, express or implied, and disclaims all implied warranties including warranties of merchantability or fitness for a particular use or freedom from patent infringement. Valspar will not be liable for any special, incidental or consequential damages. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. © 2012 The Valspar Corporation. All rights reserved.

valspar AUTOMOTIVE

Revision Date: October 2018

PA65
1K PLASTIC PRIMER

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).

NOTES
-

The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. Unless valspar agrees otherwise in writing, valspar makes no warranties, express or implied, and disclaims all implied warranties including warranties of merchantability or fitness for a particular use or freedom from patent infringement. Valspar will not be liable for any special, incidental or consequential damages. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. © 2012 The Valspar Corporation. All rights reserved.

Revision Date: October 2018