

GENERAL INFORMATION

80-60 Low VOC 1K Plastic Adhesion Promoter is a Low VOC adhesion primer based on special resins to promote adhesion on new un-primed plastic parts for the Automotive Refinish Industry.

MIXING RATIO



GUN SETUP



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

APPLICATION



1 coat 0,2-0,6 mil

Spray one medium coat allowing minimum flash of 5 minutes, maximum flash of 20 minutes before applying sealer of topcoat.

FLASH OFF AND DRY TIMES



AIR DRY 20 °C / 68 °F		FORCED DRY 60°C / 140°F	
Flash off	5 - 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 20 minutes of drying of the 80-60 Low VOC 1K Plastic Adhesion Promoter scuff with scuff pad fine or equivalent and re-apply 80-60 Low VOC 1K Plastic Adhesion Promoter.

SUBSTRATES



Commonly used automotive interior and exterior plastics Thermopolyolefin (TPO), Polyvinyl Chloride (PVC), Reaction Injection Molded Polyurethane (RIM), and Polypropylene (PPO).

Do not use with Polyethylene (PE) and pure Polypropylene (PP). Do not use on pre-primed plastic parts if unsure of the plastic type, test adhesion prior to refinishing.

POTLIFE



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 90-851 WaterBase Degreaser 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 90-851 WaterBase Degreaser.



Tempering before cleaning will help to remove mould release.

NEXT LAYER



DeBeer 2K Primer / Surfacer
MM 900 - 9999 WaterBase 900+ Series

Except Epoxy Primers and Washprimers. For flexible and soft plastics add 10 - 30%, 47-39 2K Elastic to the 2K paint systems before adding the hardener and thinner if needed.

PHYSICAL DATA

80-60		
RTS REGULATORY DATA:		
	Ready for Use	
	lb./gal	g/L
Actual VOC	0.45 Max.	54 Max.
Regulatory VOC (less water and exempt solvents)	4.5 Max.	540 Max.
Density	7 - 9	840 - 1080
	WT%	VOL%
Total Solids Content	3 - 7	3 - 7
Total Volatile Content	93 - 97	93 - 97
Water	0	0
Exempt Compound Content	90 - 95	90 - 95
Coating Category	Specialty Coating / Adhesion Promoter	

PROTECTION

Use suitable respiratory protection (*we recommend the use of a fresh air supply respirator*).

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

<https://sds.de-beer.com>

CLEANUP

Cleaning the Equipment / Per local regulations.

STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES

INFORMATION: If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Refer to the Color Focus Formula Retrieval software for compliant color formula and thinner selection instruction. Confirm compliance with state and local air quality rules before use.