

GENERAL INFORMATION

A-534 1K Plastic Primer is a single component transparent plastic primer designed to provide excellent adhesion to a wide variety of un-coated external automotive plastic components.

MIXING RATIO



Ready For Use

GUN SETUP



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

APPLICATION



1 - 2 coats 5 - 10µm

FLASH-OFF AND DRY TIMES



AIR DRY 35°C / 95°F		FORCED DRY 60°C / 140°F	
Flash off	5 -10 minutes	Flash off	-
Dust free	-	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	-



POT LIFE



-

COMPONENTS



-

SUBSTRATES



Uncoated exterior plastic types as listed:
AAS, ABS, PBTP, PC, PP/EPDM, SMC, GFK, BMC and SMC.

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 W820 Antistatic 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 W820 Antistatic Degreaser.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



Recoat after 10 minutes flash off with:
- Prospray 2K Easy Sand HiFill Surfacer sanding.

PHYSICAL DATA



PHYSICAL DATA		
Chemical Base	-	
Physical Properties	Viscosity (RTS)	-
	Specific Gravity (kg/l)	1
	Flash Point Closed Cup	27°C / 80.6°F
	Volume % Solids	17%
	Economy	-
	Gloss	-
	Colour	-

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:

sds.prospray.eu

CLEANUP



Clean equipment after use with a cleaning solvent.

Dispose of solvent according to local regulations.

STORAGE / SHELF LIFE



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

NOTES



All reported product properties on the TDS are determined at a temperature of 30°C unless specified otherwise.