

## 901R / 907R

27.08.2014

### 2K PLASTIC PRIMER-SURFACER

#### DESCRIPTION

Special 2-component primer-surfacer for all common plastic parts found on vehicle exteriors.  
Colour: white and black.  
Composition based on special polymers. Non-isocyanate primer-surfacer.

#### PRODUCTS

901R	2K Plastic Primer-Surfacer – white
907R	2K Plastic Primer-Surfacer - black
915R	2K Plastic Activator

#### PROPERTIES

- Requires no adhesion promoter and is suitable for all common plastics on vehicle exteriors.
- Reliable adhesion, high elasticity and good filling.
- Non-sanding primer-surfacer.
- Light wet sanding is possible after bake (30 min at 60°C or 2 hr air dry).
- Perfect topcoat hold-out.
- Can be coated with all topcoats.

#### SUBSTRATES








- All common plastic parts found on vehicle exteriors:  
PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, PUR, PUR flexible foam and UP-GF.

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#### PRODUCT PREPARATION

	<b>Mixing ratio ValueShade®</b>	ValueShade® 1	<b>901R</b>	<b>907R</b>		
		ValueShade® 2	100	0		
		ValueShade® 3	94	6		
		ValueShade® 4	86	14		
		ValueShade® 5	67	33		
		ValueShade® 6	50	50		
		ValueShade® 7	33	67		
		0	100			
	<b>Mixing ratio</b>		<b>Volume</b>	<b>Weight</b>		
	901R/907R		1	100		
	915R		1	74		
	<b>VOC</b>	681 g/l				
	<b>Pot life at 20°C</b>	8 hr				
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	16-18 s			
		<b>FORD 4</b>	16-18 s			
	<b>Spray equipment</b>	<b>Compliant guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>	
		Gravity feed	1.2-1.5 mm	15 cm		
		Suction feed	1.4-1.6 mm	15 cm		
		Pressure feed	1.0-1.2 mm	15 cm		
		<b>Conventional guns</b>				
		Gravity feed	1.3-1.6 mm	20-25 cm		2-2.5 bar
Suction feed	1.5-1.7 mm	20-25 cm	2-2.5 bar			
Pressure feed	1.0-1.2 mm	20-25 cm	2-2.5 bar			
	<b>Number of coats</b>	Gripcoat followed by 1 full coat.				
	<b>Flash time</b>	Wet-on-wet: 20 min before topcoat application (maximum 24 hr). Exception: 45 min before waterborne basecoat application. Before bake: 10 min.				
	<b>DFT</b>	25-30 µm				
	<b>Dry to sand</b>	If required, the product can be sanded lightly with wet sanding paper (P800 - P1000) after:				
	at 20°C	2 hr				
	at 60°C	30 min				
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.						

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#### SURFACE PREPARATION

1. Preheat 30 min at 60°C.
2. Allow to cool.
3. Clean surface with water and soap. Rinse and dry.
4. Clean with a preparatory cleaner for plastics. Wipe dry with a clean cloth.
5. Scuff sanding with sanding pad.
6. Remove all traces of sanding dust, blowing oil-free compressed air.
7. Optionally clean with preparatory cleaner for plastics. Wipe dry with a clean cloth.
8. Degrease with a correct final cleaner/degreaser.
9. Wipe and blow dry.

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

#### REMARKS

- Degrease AAS, ABS, PC and PVC with a correct final cleaner/degreaser.
- For PP and POM flame treatment is needed.
- Material has to be at room temperature (18-25°C) before use.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.

#### PRODUCT DATA

Package viscosity: 1400 cp  
Theoretical coverage: 7-9 m<sup>2</sup>/l at recommended DFT - ready-to-spray

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#### SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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