



TDS 20-3-1

Cardea® 2K Plastic Primer



Description		Cardea® 2K Plastic Primer is designed to provide high filling performance on automotive plastic substrates. It can be used in weton-wet and sanding systems.			
Related Products		Cardea® 2K Plastic Primer Cardea® 2K Acrylic Hardener Cardea® Universal Thinners	TDS no: 40-2-1 TDS no: 50-2-1		
Substrate		Automotive plastics (mainly PP Note: Can be applied on metal		•	er.
Surface Preparation		Pre-clean the surface with ward the substrate dry. Degrease with Cardea® U-Clean Use abrasive fiber clothes for sa	າ 300 by clean cloth	1.	d let
		Clean with Cardea® U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.			
Mixing			By Volume	By Weight	
		Cardea® 2K Plastic Primer	100	100	
		Cardea® 2K Acrylic Hardene	r 25	20	
		Cardea® Universal Thinners	40 - 60	30 - 50	
Viscosity	s	18 - 20 s/20°C (DIN 4)			
Pot Life		4 hours (at 20°C)			
Spray Gun Parameters	***	Gun Type Suction feed spray gun Gravity feed spray gun HVLP Suction feed spray gun HVLP Gravity feed spray gun	Nozzle size 1,4-1,6 mm 1,5-1,5 mm 1,5-1,7 mm 1,3-1,4 mm	2 - 4	bars bars 2 bars



The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.









TDS 20-3-1

Cardea® 2K Plastic Primer



Application		2 coats	
Flash-off Time	<u> </u>	Between coats 5 -10 minutes (at 20 °C) until touch dry. In wet-on-wet application wait for 30 min (at 20 °C) before next coat	
Drying		60°C / 30 min Overcoat should be applied after touch dry within 24 hours.	
Dry Film Thickness		$10-40~\mu m$ / coat	
Theoretical Coverage		18 m²/l at 25 μm	
Next Coat		Dry sanding P400/P500 Wet sanding P800/P1000 Note: If wet sanding will be done, let the surface dry before next coat application. Clean with Cardea® U-Clean 300 by clean cloth.	
	*	Wipe the surface with a tack cloth and blow air. Cardea® 2K Topcoats and Basecoats. See TDS No: 30-3-1, 30-1-1	
Equipment Cleaning		Use acrylic or cellulosic thinners.	
Package		Cardea® 2K Plastic Primer : 0,5 L Cardea® 2K Acrylic Hardener : 0,5 L; 1 L	
Color		Grey	
Safety		Professional use only. See Material Safety Data Sheet.	



