

## **TDS 20-3-2**

## **Cardea® 1K Primer for Plastics**



Description		Cardea® 1K Primer for Plastics is a quick drying adhesion promoter for automotive plastics.			
Related Products		Cardea® 1K Primer for Plastics			
Substrate	Automotive plastics - mainly PP/EPDM				
		<b>Note:</b> Do not apply on pure PE.			
Surface Preparation		Pre-clean the surface with warm water and detergent, rinse and let the substrate dry.  Degrease with Cardea® U-Clean 300 by clean cloth.  Use abrasive fiber clothes for sanding plastic substrates.  Clean with Cardea® U-Clean 300 by clean cloth.  Wipe the surface with a tack cloth and blow air.			
Mixing		Ready to use - do not use thinner.			
Viscosity	s	9 – 13 s / 20°C (DIN 4)			
Spray Gun Parameters	***	Gun Type	Nozzle size	Air pressure	
		Gravity feed spray gun	1,2-1,4 mm	1,5 – 2,2 bars	
Application		Shake well before application, spray 1-2 wet coats. Dry film thickness shouldn't exceed 4 $\mu m$ in order to avoid adhesion problems.			
Flash-off Time	<u>/†/†/</u>	Approximately 3 - 5 minutes (at 20°C) before next coat.  Apply next coat within 48 hours (at 20°C), otherwise sand the primer with abrasive fiber cloth and re-apply one wet coat of primer before next coat.			



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.





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Dry Film Thickness	Up to 4 μm	
Theoretical Coverage	8,5 m²/l at 4 μm	
Next Coat	Cardea® Primers, Fillers, 2K Topcoats and Basecoats. See TDS 20-1-1, 20-1-2, 20-2-1, 30-3-1, 30-1-1	
Equipment Cleaning	Use acrylic or cellulosic thinners.	
Package	Cardea® 1K Primer for Plastics : 1 L	
Color	Transparent (Contents pearl pigments)	
Safety	Professional use only. See Material Safety Data Sheet.	



