



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 wet-on-wet and sanding systems.		
Related Products	Cardea® 2K Plastic Primer Cardea® 2K Acrylic Hardener TDS no: 40-2-1 Cardea® Universal Thinners TDS no: 50-2-1		
Substrate	Automotive plastics (mainly PP, PA, ABS, ABS/PC ,PA) Note: Can be applied on metal surface as w/w or sanding primer.		
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		By Volume	By Weight
		Cardea® 2K Plastic Primer	100 100
		Cardea® 2K Acrylic Hardener	25 20
		Cardea® Universal Thinners	40 - 60 30 - 50
Viscosity		18 - 20 s/20°C (DIN 4)	
Pot Life	4 hours (at 20°C)		
Spray Gun Parameters		Gun Type	Nozzle size Air pressure
		Suction feed spray gun	1,4-1,6 mm 2 - 4 bars
		Gravity feed spray gun	1,5-1,5 mm 2 - 4 bars
		HVLP Suction feed spray gun	1,5-1,7 mm 2 - 2,2 bars
		HVLP Gravity feed spray gun	1,3-1,4 mm 2 - 2,2 bars



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Application		2 coats
Flash-off Time		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 µm / coat
Theoretical Coverage		18 m ² /l at 25 µm
Next Coat	  	<p>Dry sanding P400/P500</p> <p>Wet sanding P800/P1000</p> <p>Note: If wet sanding will be done, let the surface dry before next coat application.</p> <p>Clean with Cardea® U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.</p> <p>Cardea® 2K Topcoats and Basecoats. See TDS No: 30-3-1, 30-1-1</p>
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.