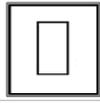
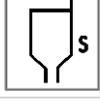
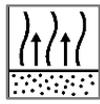




TDS 20-3-2

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 Note: 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		9 – 13 s / 20°C (DIN 4)							
Spray Gun Parameters		<table border="1"> <thead> <tr> <th>Gun Type</th> <th>Nozzle size</th> <th>Air pressure</th> </tr> </thead> <tbody> <tr> <td>Gravity feed spray gun</td> <td>1,2-1,4 mm</td> <td>1,5 – 2,2 bars</td> </tr> </tbody> </table>	Gun Type	Nozzle size	Air pressure	Gravity feed spray gun	1,2-1,4 mm	1,5 – 2,2 bars	
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 µm in order to avoid adhesion problems.							
Flash-off Time		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.							



TDS 20-3-2

Cardea® 1K Primer for Plastics

Dry Film Thickness	Up to 4 µm
Theoretical Coverage	8,5 m ² /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.