



# INTERNATIONAL SYSTEMS TDS – North America

## METALUX 2™ Polypropylene Primer

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**TD Sheet CS141 rev. 12/4/07**

<b>Description:</b>	A one pack, clear primer for use on polypropylene plastic substrates.				
<b>Product and Additives:</b>	METALUX 2™ Polypropylene Primer 3812				
<b>Suitable Substrates:</b>	METALUX 2™ Polypropylene Primer 3812 can be applied over: - Polypropylene plastic bumpers. (New Raw Plastic)				
<b>Surface Preparations:</b>	Clean thoroughly at least 3 to 4 times, each time using fresh Silicone Remover 9020 to ensure that the surface is clean and free of contamination Use a clean silicone free rag to apply. Do not place rag on opening of container as contamination could occur. Pour silicone remover onto rag or into a separate container and use from this container and then discard. Wipe in one direction followed up with a separate clean rag in the same direction. Clean article in sections. Allow to evaporate and dry thoroughly. Now wipe in <u>one direction</u> with Anti Static Degreaser 9145 with a clean cloth making sure to dry thoroughly.				
<b>Mixing Ratio:</b>	METALUX 2™ Polypropylene Primer 3812 is ready for use (RFU).				
<b>Pot Life:</b>	No pot life restrictions.				
<b>Process:</b>	Apply 1- 2 single wet coats with 10 minute flash between coats. Allow a 15 minute flash before applying primers or color.				
<b>Spray Gun Settings:</b>	HVLP Gravity	1.3 – 1.5mm	0.5 – 0.6 (Bar)	8 – 10 (PSI)	*At the cap
	High Efficiency	1.3 – 1.6mm	2.0 – 2.7 (Bar)	30 – 40 (PSI)	Inlet Pressure
	Conventional	1.4 – 1.6mm	2.7 – 4.1 (Bar)	40 – 60 (PSI)	Inlet Pressure
	<b>Note:</b> Refer to spray gun manufacturers for further information regarding inlet pressures.				
<b>Film Thickness:</b>	± 2.5 microns / .1 mils per coat				
<b>Drying Time:</b>	To Overcoat:	15 minutes @ 20°C / 68° F			
<b>Recoatibility:</b>	2K Primers: May be used for additional film build using 10% Softflex Additive in fillers. 2K Enamel: Mix 10% Softflex Additive before adding selected hardener and 2K thinner. Metalux2™ Basecoat <b>Note:</b> Softflex Additive is not required to be added to METALUX 2™ Basecoat. 2K Clears: Mix 10% Softflex Additive before adding selected hardener and 2K thinner.				
<b>Cleaning Equipment:</b>	Clean equipment immediately with quality lacquer thinner.				
<b>Health &amp; Safety:</b>	Reference text on label. Flammable – keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.				