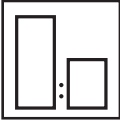




# 80-60 Low VOC Plastic Primer

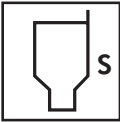
## APPLICATION DATA



**Mixing Ratio (Volume):**

\* Check local regulations for VOC compliance guidelines

: Ready to Spray



**Application - Viscosity**

RTS (Ready To Spray)  
Viscosity @ 20°C/70°F  
DIN Cup 4 mm

: Ready to Spray

Spray one medium coat allowing minimum flash of 5 minutes, maximum flash of 20 minutes before applying sealer of topcoat

\* For high impact areas, the use of a De Beer sealer is recommended prior to topcoat

**NOTE:** Do not spray when surface temperature is below 50°F (10°C)



**Spray Gun HVL**

Gravity Feed (Nozzle):  
Inlet Air Pressure

: 1.3 - 1.4 mm  
20 - 30 psi (1.5 - 2.0 bar)



**Conventional Gun**

Gravity Feed (Nozzle):  
Air Pressure:  
Siphon Feed (Nozzle):  
Air Pressure:

: 1.4 - 1.6 mm  
30 - 35 psi (2.0 - 2.4 bar)  
1.5 - 1.8 mm  
35 - 40 psi (2.4 - 2.8 bar)



**Flash/Bake/Air Dry Times:**

Flash Between Coats  
To Topcoat  
To Recoat

: N/A  
5 - 20 minutes  
4 hours maximum



# 80-60 Low VOC Plastic Primer

**General qualities**

: 80-60 Low VOC Plastic Primer is designed to promote adhesion on commonly used automotive interior and exterior plastics including Thermopolyolefin (TPO), Polyvinyl Chloride (PVC), Reaction Injection Molded Polyurethane (RIM), and Polypropylene (PPO)

**Surface Preparation**

- Spray surface with 90-851 Waterbase Degreaser and wipe dry with clean cloth before product evaporates
- Scuff surface with P600 grit wet or dry sandpaper or gray/yellow scuff pad
- Re-spray surface with 90-851 Waterbase Degreaser and wipe dry with clean cloth before product evaporates

**NOTE:** Tempering before cleaning will help to remove mould release

**Physical properties**

VOC	4.5 lbs/gal (540 g/L) Max
Vol. % Solids	4.47% Average
Theoretical Coverage	71.7 sq. ft. per mil/25 µm per gallon
Recommended DFT	0.2 - 0.6 mils (5 - 15 µm)

**Substrates**

: Commonly used automotive interior and exterior plastics  
Thermopolyolefin (TPO), Polyvinyl Chloride (PVC),  
Reaction Injection Molded Polyurethane (RIM), and Polypropylene (PPO)

**NOTE:** Not to be used on polyethylene or silicone rubber

**Storage life**

: Under normal storage conditions for up to two years  
(unopened container)