





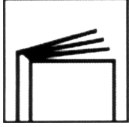
	North America	Technical Data Sheet #
	<b>All Plastic Primer™</b>	Primer
		04.15.15
<b>FOR PROFESSIONAL USE ONLY</b>		

**Description**


Lesonal All Plastic Primer is a fast drying, transparent adhesion promotor for all raw plastic parts.

	<b>Safety Considerations</b> Use suitable personal protection. AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator. Refer to the product Material Safety Data Sheet (MSDS) for more complete safety information.	
	<b>Mixing</b>	Product is supplied ready to spray
	<b>HVLP or Compliant Spray-Gun Set-Up:</b>  1.3-1.5 mm	<b>Application Air Pressure:</b>  Consult spray gun manufacturers' specifications. HVLP – 10 psi at the air cap maximum.
	<b>Application</b> 1-2 medium coats	
	<b>Flash Between Coats at 70°F (20°C)</b>  5-10 minutes	<b>Flash Before Force Drying at 70°F (20°C)</b>  Not recommended
	<b>Air Drying at 70°F (20°C)</b>  All Plastic Primer must be recoated within 16 hours of application. If 16 hours are exceeded, abrade the surface with a gray scuff pad and reapply All Plastic Primer.	
	<b>Force Drying at 140°F (60°C)</b>  Not recommended	<b>Infra-Red</b>  Not recommended
	<b>Re-Coatable With:</b> <ul style="list-style-type: none"> <li>• Lesonal Primers</li> </ul>	

Read complete TDS for detailed product information.





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**Bare Plastic Identification, Continued –**

Plastics that are coded with the letter combinations below or contain within them these letter combinations are considered polyolefin type plastics. These plastics require the use of All Plastic Primer.

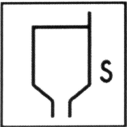
Popular Polyolefin Plastic Codes	
• PP	• PP+EP
• PO	• PP/EPM
• TPE	• PP/EPDM
• TPO	• PPE/EPDM

Plastics that do not contain letters designating polyolefin type plastics with the exception of polyethylene (PE) are non-polyolefin plastic and require no adhesion promoter. Polyethylene (PE) plastics are difficult if not impossible to paint.


**Sanding Uncoated Plastics**

- Pre-Clean uncoated plastic with AutoPrep Ultra Prep.
- Prior to painting uncoated polyolefin plastics or parts abrade with a gray scuffing pad and PlasticFix.
- Before painting uncoated non-polyolefin plastic or parts sand with #P400 grit dry or abrade with a red scuffing pad and PlasticFix.
- When prepping plastic parts primed with reversible, solvent soluble primers, sand with P400 grit dry or abrade with a gray scuffing pad and PlasticFix.
- When prepping primed or painted plastic parts with non-reversible coating sand with #P400 grit dry or abrade with a red scuffing pad and PlasticFix.


**Viscosity When Mixed**

 <p>DIN #4</p>	<p><b>10-12 seconds</b></p>	<p>Measured with a DIN #4 viscosity cup at 70°F (20°C).</p>
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**Spray Gun Set-Up**

	<p><b>Consult spray gun manufactures instructions for specific spray gun pressure specifications.</b></p>		
	<p><b>Spray Gun</b></p>	<p><b>Fluid Tip</b></p>	<p><b>Application Pressure</b></p>
	<p><b>HVLP Gravity Fed</b></p>	<p>1.8-2.2 mm</p>	<p>Max 10 psi at the spray gun inlet (&lt;10 psi at cap).</p>
<p><b>Compliant Gravity Fed</b></p>	<p>1.3-1.5 mm</p>	<p>Max 10 psi at the spray gun inlet.</p>	



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**Application**

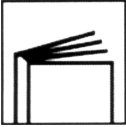
	1-2 medium wet coats
	Allow a flash off time between coats and prior to primer application of 5-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

**Film Thickness – Using Suitable Application**


1 Coat will achieve a thickness of 0.15-0.25mils (3.8 –7 µm).

	<ul style="list-style-type: none"> <li>Not recommended.</li> </ul>
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**Recoating**

	All Plastic Primer can be recoated with all Lesonal Primers.
	Please refer to the Lesonal Flex TDS for information regarding the amount of Flex Additive needed for each undercoat.

**Cleaning of Equipment**

	Clean equipment following local and federal regulations.
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**VOC / Regulatory Information**

Product VOC Ready to Spray is 7.0 lbs/gal (840 g/L)
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**Product Storage**

Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (20°C).	
All Plastic Primer	2 years



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**AkzoNobel Car Refinishes Inc, North America**  
**Address: 1845 Maxwell Street – Troy, MI USA**  
**Telephone: 800.618.1010**

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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**Head Office**

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