


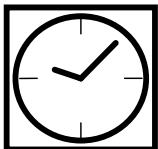



ALL PLASTIC PRIMER

DESCRIPTION: Lesonal™ All Plastic Primer is a fast drying, transparent adhesion primer for all raw plastic parts.

PRODUCT: All Plastic Primer

BASIC RAW MATERIALS: Special polyester resins

APPLICATION:

- | | | | | | |
|----|---|--|----|--|--|
| 1. |  | Contains special polyester resins xylene and other ingredients. | 4. |  | (non-sanding)
5–10 minutes at 70°F (20°C) |
| 2. |  | Ready to Spray | 5. |  | Apply
-Lesonal™ topcoats
- Suitable Undercoats |
| 3. |  | 1 Medium Coat
Siphon Feed: 1.6–1.8 mm
0.063”–0.071”
Gravity HVLP: 1.3–1.5 mm
0.051”–0.059” | | | |

SUITABLE SURFACES: All Raw Plastic Parts

NOTE: Do not use Lesonal™ All Plastic Primer over primed or painted existing surfaces.

SURFACE PREPARATION:

- Use appropriate cleaner and abrade with a gray pad and Lesonal™ degreaser.
- Degrease again with the appropriate cleaner and clean rags.
- Allow 30 minutes for the plastic part to dry before the application of the Lesonal™ All Plastic Primer.



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- MIXING RATIO:** The product is ready to spray.
- VISCOSITY:** 13–14 seconds DIN Cup #4 at 70°F (20°C).
- POT LIFE:** None
- SPRAY GUN
& PRESSURE:**

	Fluid Tip	Spraying Pressure
Siphon Feed	1.6–1.8mm 0.063"– 0.071"	40–50 psi (3–4 bar)
Gravity Feed	1.3–1.4mm 0.051"– 0.055"	40–50 psi (3–4 bar)
Siphon HVLP	1.8–2.2 mm 0.071"–0.087"	max 10 psi (max 0.8 bar)
Gravity HVLP	1.3–1.5 mm 0.051"– 0.059"	max 10 psi (max 0.8 bar)

- APPLICATION METHOD:** Spray one medium coat.
- FLASH TIME:** 5–10 minutes at 70°F (20°C).
- RECOATING:** May be recoated with **Lesonal™** 2.1-3.8 Urethane Surfacer, **Lesonal™** 2.8-4.6 Epoxy Primer Sealer, **Lesonal™** 1K Basecoat, **Lesonal™** enamels and polyurethane systems without sanding up to a maximum of 16 hours at 70°F (20°C). When using these products over plastic parts, Flex Additive must be used. (See Flex Additive technical data sheet for details.)
- NOTE:** After 16 hours at 70°F (20°C), abrade with the gray pad and reapply **Lesonal™** All Plastic Primer.
- FILM THICKNESS:** 0.8 – 1.0 mil per single coat
- COVERAGE RATE:** Approximately 70 sq. ft./liter over all plastic surfaces per single coat.
- SHELF LIFE:** 2 years if stored unopened at room temperature.



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SAFETY ASPECTS:

**FLASH POINT
(CLOSED CUP):** 73°F (23°C)

**READY TO
SPRAY VOC:** 7.0 lb/gal (840 g/liter)

NOTICE: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for which they come in contact. The manufacturer recommends the use of an organic vapor respirator or air-supplied respirator when exposed vapors or spray mist.

