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Quick drying, one-pack adhesion primer for plastic car body parts.

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**MIXING RATIO**  
Ready for Use**EQUIPMENT**  
Spray gun set-up: 1.2-1.4 mm  
Application pressure: 1.7-2.0 bar at the air inlet\*

\*See user manual spray gun

**APPLICATION**  
1 x 1 coat**FLASH-OFF**  
20 minutes at 20°C**RECOATABLE WITH**  
All Dynacoat primers, basecoats and topcoats**PROTECTION**  
Use suitable respiratory protection. AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

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|---|--|---------------------------------|--|
| <b>PRODUCT AND ADDITIVES</b>                    | Dynacoat 1K Plastics Primer  |                                 |  |
| <b>BASIC RAW MATERIALS</b>                      | Dynacoat 1K Plastics Primer: Polyolefin resins   |                                 |  |
| <b>SUITABLE SUBSTRATES</b>                      | All plastic car body parts currently available in the automotive industry except for those made of pure PE (polyethylene)<br><br><i>Note: Do <b>not</b> apply 1K Plastics Primer to plastic parts that are already pre-treated with OEM primer</i>       |                                 |  |
| <b>SURFACE PREPARATION</b>                      | Pre-clean the surface with warm water and detergent and rinse sufficiently with clean water.<br>Remove surface contamination with Uni-degreaser  |                                 |  |
| <b>MIXING</b>                                   | Dynacoat 1K Plastics Primer is ready for use<br>(shake 5 seconds before use)   |                                 |  |
| <b>VISCOSITY</b>                                | 15-17s (DIN Cup 4 at 20°C)   |                                 |  |
| <b>SPRAY GUN FLUID TIP AND WORKING PRESSURE</b> | <b>Spray gun:</b><br>Gravity feed:   | <b>Fluid tip:</b><br>1.2-1.4 mm | <b>Pressure:</b><br>1.7 – 2.0 bar (at the air inlet*)<br>HVLP max 0.7 at aircap<br><small>*See user manual spray gun</small> |
| <b>APPLICATION</b>                              | Apply 1 single coat, allowing for 20 minutes flash off time before applying Dynacoat fillers / topcoats.   |                                 |  |
| <b>CLEANING OF EQUIPMENT</b>                    | Dynacoat thinners or cellulose thinner   |                                 |  |
| <b>FILM THICKNESS</b>                           | 1-4 µm   |                                 |  |
| <b>THEORETICAL COVER RATE</b>                   | 11 m <sup>2</sup> / liter at a layer thickness of 1 µm.<br><br><b>Note:</b> The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application |                                 |  |
| <b>RECOAT TIME</b>                              | Allow for a minimum of 20 minutes flash-off time at 20°C before recoating.<br>Apply filler or topcoat within 24 hours at 20°C  |                                 |  |

**RECOATABILITY**            Dynacoat fillers, basecoats and topcoats

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**PRODUCT STORAGE**      Product shelf-life is determined when products are stored unopened at 20°C.  
 Avoid extreme temperature fluctuation.

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**SHELF LIFE**                2 years at 20°C

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**VOC**                         **2004/42/IIb(e)(840)780**  
 The EU limit value for this product (product category: IIb(e)) in ready to use form is  
 840 gram/liter of VOC.  
 The VOC content of this product in ready to use form is max. 780 gram/liter.

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#### **FOR PROFESSIONAL USE ONLY**

**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 fulfil 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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