

522-1413 Plastiprimer MDF Black Post-Cat Pigmented Primer

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| Product codes: 522-1413 | Viscosity: 2700 cps at 77°F |
| | Flash Point: 26°F (-3°C) |
| | Density (lb/gal): 10.5 |
| | Solid (% by weight): 65% |
| | Solid (% by volume): 48% |
| | Shelf Life (months): 12 |

Product Description:

Plastiprimer Black is a fast drying, acid curing primer for interior use that gives a smooth, dense finish suitable for topcoating to produce very high quality pieces. Plastiprimer Black adheres well to wood and wood products and is extremely easy to sand.

Uses:

This product offers excellent filling capabilities on MDF substrate due to its high solid content (50% volume).

Environmental Data (as supplied):

| | |
|--------------------------------|-------|
| VOC less exempt lb/gal: | <3.65 |
| VOC lb/gal: | <3.65 |
| VOC less exempt g/l: | <450 |
| VOC g/l: | <450 |
| VOC lb/lb Solid: | <0.55 |
| VHAPs lb/lb Solid: | <0.15 |

Note:

N/A

Application Data

| | |
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| Suggested Uses: | Wood Primer |
| Mixing Ratio: | 10 parts 522-1413 to 1 part 873-0870 |
| Pot Life: | 12 hours |
| Application Viscosity: | Zahn #2 signature cup 20 – 25 seconds |
| Reducer: | 803-1325 or 803-1329 |
| Retarder: | 800-5328 |
| Clean-up Solvent: | 803-1298 |
| Recommended Wet Film: | 4 – 5 mils |
| Coverage: | 802 sq. ft/gal At 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness. |

Note:

N/A

Directions for use:

Surface Preparation:

Substrate should be sanded using 120, 150 or 180 grit stearated paper. Plastiprimer Black cannot be used on metal, old oil or cellulose lacquers. Suitable topcoats are Plasticolor Black 117-10XX, Danspeed II 424-45XX, Plastofix Light 421-48XX, Chemlife® 24 - 421-63XX and E-Var 421-80XX.

General Information:

Mix Plastiprimer Black thoroughly, then catalyze and reduce material as recommended. Plastiprimer Black must be well mixed while adding hardeners and reducers and must be agitated at all times to ensure product consistency. Plastiprimer Black is applied in one to two coats and can be used as a primer for most wood and wood products meant for indoor use. A thorough sanding using 240/320 grit stearated paper between coats is essential for adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded. Care should be taken to avoid sanding through the primer coat. With profiled edges, care must be taken with sanding of primer to avoid sanding through sharp edges. Complex profiles or profiles with sharp corners may cause difficulties in obtaining an effective primer coat of even thickness. In these cases, profile design must be discussed with your technical representative. Contact with metal surfaces should be avoided once the Plastiprimer Black has been catalyzed. To ensure proper uniformity, the material should be agitated at all times. Recommended film build of Plastiprimer Black is not to exceed 4 mils dry. Total recommended film build of Plastiprimer Black and topcoat is not to exceed 6 mils dry.

Plastiprimer Black must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats. Plastiprimer Black must not be used and dried at temperatures below 64°F or relative humidity above 65%. During hardening the enamel must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:

| | Room Temperature (68°F) | Forced Drying Schedule (122°F) |
|------------------------|-------------------------|--------------------------------|
| Tack Free Time: | 10 – 15 minutes | Flash off before entering oven |
| Dry to Sand: | 1 hour | 30 minutes |
| Dry to Stack: | 4 hours | 1 hour |

Note:

N/A

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

Akzo Nobel Coatings, Inc
 1431 Progress Ave
 High Point, NC 27260
 336-841-5111

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