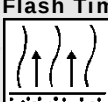


AL418_V

1K Primer for Plastics

Description	AUTOLUX®1K Primer for Plastics, AL418, is a fast, transparent 1 pack primer suitable for use on all paintable plastic substrates and avoids the need to identify the plastic prior to spraying.					
Products	Primer:	AL418 Autolux 1K Primer for Plastics				
Substrates	Most plastics found in automotive use. Note: Some grades of PE are considered unpaintable. These primers are not suitable for use on very solvent sensitive substrates such as Polystyrene (PS).					
Surface Preparation	 Thorough preparation and cleaning are essential for the successful refinishing of plastic parts. The Autolux Plastic Pre-cleaner, AL642, is designed to produce the best performance from the primer and topcoat systems.					
Mixing	 Supplied ready for use.					
Application	 <table><tr><td>Conventional gun:</td><td>Fluid Tip 1.3 – 1.5mm, Air pressure 40 - 45 psi (2.8 – 3.1 bar) at the gun</td></tr><tr><td>HVLP/Compliant gun:</td><td>Fluid Tip 1.3 – 1.5mm, Air pressure – refer to spraygun manufacturers information</td></tr></table> Lower pressures, 30-35 psi can be used when painting awkwardly shaped plastic parts		Conventional gun:	Fluid Tip 1.3 – 1.5mm, Air pressure 40 - 45 psi (2.8 – 3.1 bar) at the gun	HVLP/Compliant gun:	Fluid Tip 1.3 – 1.5mm, Air pressure – refer to spraygun manufacturers information
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HVLP/Compliant gun:	Fluid Tip 1.3 – 1.5mm, Air pressure – refer to spraygun manufacturers information					
Coats	 1 double coat					
Flash Time	 10 minutes at 20°C					
Drying	 10 minutes at 20°C					
Recoat	 Autolux 1K Primer for Plastics can be directly overcoated with 2K topcoat systems. Where higher build is required, use a Autolux 2K Primer Surfacer or Epoxy Primer.					
Process Notes Clean up equipment immediately after use, using Autolux Thinner or another suitable solvent. Dispose of waste in accordance with applicable regulations.						
VOC Information This product falls outside of the scope of EU Directive 2004/42 and therefore does not have a VOC product category classification. This product can be used by professional motor vehicle repairers.						

These products are for professional painting only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the Material Safety Data Sheet. March 2014.

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