

TECHNICAL DATA SHEET

PRODUCT

BC333 PLASTIC PRIMER/ FLEXIBLE SEALER.

DESCRIPTION

BC333 Plastic Primer is specifically formulated to be used in conjunction with a range of plastic substrates to seal the surface and enhance the adhesion properties of the final decorative topcoat.

As plastics vary greatly in their chemical make-up and resistance properties, special attention should be paid to the preparation of the substrate and the suitability of this product for the intended end use.

PROPERTIES

BC333 Plastic Primer is a one pack low viscosity transparent sealer that is slightly honey coloured in the can.

It has no particularly great resistance to chemicals or solvents and so should be applied as lightly as possible (much the same as conventional metal etch systems) to achieve a thin film of resin which will act as a tie component between the topcoat and the substrate.

TECHNICAL DATA

RECOMMENDED FILM

BUILD: 50 - 80 (wet) 3-5 (dry)

VOLUME SOLIDS: 5% (approx)

THEORETICAL

COVERAGE: Approx. 14 - 16 square metres per litre at 80 microns wet.

COMPONENTS: One

MIXING RATIO: Ready for use.

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DRYING AT 25 °C: Touch dry : 5 minutes
 Re-coat able : 10 minutes

POT LIFE AT 25 °C: Not Applicable

APPLICATION

METHODS: Brush, roller, air or airless spray, although for best results a spray application is strongly recommended.

FLASHPOINT: 23° C
SHELF LIFE: 24 months
PACKAGING: 1, 4 and 20 litre containers

SYSTEM RECOMMENDATIONS

<u>SUBSTRATE</u>	<u>PREPARATION</u>	<u>COATING SEQUENCE</u>	<u>FILM BUILD</u> WET (DRY)
ABS,PC,PVC, AAS	See below, all degreasing to be with alcohol based solvents. (eg. VC1000)	1 st Coat : BC333 2 nd Coat: UT100 or UT150 Topcoat	80 microns (5) 100microns(40)
PBTP, PP/EPDM, SMC, PA.	See below. Wax & grease remover may be used.	1 st Coat: BC333 2 nd Coat: UT100 or UT150 Topcoat	80 microns (5) 100microns(40)

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SURFACE PREPARATION:

As the variety of plastic substrates available to paint is ever increasing, it is most important that the correct sequence of preparation steps is maintained for each particular generic family.

Generally though the following sequence is recommended when processes such as vapour degreasing are not practicable

- (1) Initial clean with hot (60 °C) detergent water.
- (2) Fresh water rinse and dry off.
- (3) Degrease with appropriate thinner. (consult supplier)
- (4) Towel dry with lint free cloth.
- (5) Lightly abrade surface with scourers.
- (6) Repeat steps 3 &4.
- (7) Apply BC333 Plastic Primer in accordance with manufacturers instructions.

NOTE :

With PP or PE type substrates, maximum adhesion is afforded by flame treatment in corona discharge.

APPLICATION:

MIXING: This is a one component system.

THINNING: This material is supplied, ready for use.

**BRUSH /
ROLLER:** Use brush for small or difficult areas or when spraying is impractical.
Short nap **OR** roller is recommended.
Wash up with UT100 U-thane Thinner or BC Gunwash.

SPRAYING: Conventional pressure pot: 1.5 mm Fluid orifice using 385 kPa (50 psi).
Pressure at pot : 65 kPa (10 psi)
Pressure at Gun: 385 kPa (50 psi)

EQUIPMENT CLEANUP:

All equipment should be thoroughly cleaned with UT100 U-thane Thinner or BC Gun Wash.

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GENERAL

Do not apply this product at temperatures below 10° C or relative humidity's above 85%.
Shelf life is normally 24 months in original containers, but depends on storage conditions.

DANGEROUS GOODS: Class 3.1 UN1263 PAINT HFP

This data sheet is based on information in BC Coatings possession at date of issue.
BC Coatings supplies its products only on condition that the consumer is satisfied as to the performance of the product in meeting his particular requirements.