

Product Information

Plastiprimer 900 MDF – 522-1410

PRODUCT DESCRIPTION

Plastiprimer 900 MDF 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.

This product is designed **only** for MDF and offers excellent filling capabilities due to its high solid content (50% volume).

FEATURES

Plastiprimer 900 MDF provides an excellent base and is extremely easy to sand. After sanding, it may be topcoated with Plasticolor 900 White 117-10XX.

Note: Plastiprimer 900 MDF must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.

Plastiprimer 900 MDF must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors.

Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

SPECIFICATION VALUES

Gloss:	N/A
Flash Point:	0°C (31°F)
Specific Gravity:	1.32
Weight per Gallon:	11.0
Solids by Weight:	66%
Solids by Volume:	50%
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity at 25°C (77°F):	1600 cps
VOC:	432 g/l (3.60 lb/gal)
Lbs. VOC/Gallon:	3.6 lb/gal
Lbs. VOC/Lbs. Solids:	0.49
Lbs. VHAPs/Lbs. Solids:	0.1

Values at Application if Catalyzed:

Lbs VOC/Lbs solid:	0.89
Lbs VHaps/Lbs solid:	0.09

If additional reducers or additives are used, compliance values must be recalculated.

SPECIFICATION INFORMATION

Shelf Life: Twelve months recommended if unopened between 15°C - 25°C (59°F – 77°F). Always rotate stock.

Pot Life: Mix only enough for one day's use for optimum product performance. Use of material which has been catalyzed for more than 12 hours may cause failure in film integrity.

Coverage: Coverage is 802 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: 10 parts volume by Plastiprimer 900 MDF 522-1410: 1 part by volume of Catalyst 873-0870.

Reduction: Use up to 30% by volume of Reducer 803-1325 to obtain recommended viscosity. Use Chemcraft Retarder 800-5328 to slow the cure and keep the film open longer.

DIRECTIONS FOR USE

Surface Preparation: Substrate should be sanded using 120, 150, or 180 grit steared paper. Plastiprimer 900 MDF cannot be used on metal, old oil or cellulose lacquers. Suitable topcoats are Plasticolor 900 White 117-10XX or Optiset White 131-90XX.

Directions for Use: Mix Plastiprimer 900 MDF thoroughly, then catalyze and reduce material as recommended. Plastiprimer 900 MDF must be well mixed while adding catalyst and reducers and must be agitated at all times to ensure product consistency.

Plastiprimer 900 MDF is applied in one to two coats and can be used as a primer over MDF or HDF type products. A thorough sanding using 240/320 grit steared 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 900 MDF has been catalyzed. To ensure proper uniformity, the material should be agitated at all times. Recommended film build of Plastiprimer 900 MDF is not to exceed 4 mils dry. Total recommended film build of Plastiprimer 900 MDF and topcoat is not to exceed 6 mils dry.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure. The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION**Application:**

Method	Viscosity	Recommended	
		Wet Film	Dry Film
Spray – Conventional}	Z #2/20-30"	4-5 mils	1.8-2.2 mils
- Airless}	Z #2/18-22"	4-5 mils	1.8-2.2 mils
- HVLP }	Z #2/17-20"	4-5 mils	1.8-2.2 mils

Note: All measurements recommended are based on results at temperatures of 68°F. Viscosity will vary depending on the temperature of the liquid.

Drying Times:

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity.

At 68°F	(Minimum Required)	At 122°F	(Minimum Required)
Tack Free:	10-15 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	1 hour	Dry to Sand:	30 minutes
Dry to Stack:	4 hours	Dry to Stack:	60 minutes

Note: 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.

Clean-Up: Use 803-1298.

Chemcraft International Inc. views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

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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.