

21-20 1K Plastic Primer

1. Properties / Information





- 21-20 1K Plastic Primer is an adhesion promoter in an aerosol can that is suitable for all paintable plastics on cars.
- Can be used for both raw plastic as well as (non-soluble) primed plastic.
- Shake 21-20 for 2 minutes before each use.
- Spray distance is 4"-6" from panel.
- Contents under pressure. Do not puncture, crush or incinerate aerosol containers.

2. Surface Preparation

Substrate/Pretreatment:	Cleaning	Sanding	Second Cleaning
Flexible plastic parts	70U-20 Cleaner	P220 grit	70U-10 Cleaner
Fiberglass, rigid plastic parts (without gelcoat)	70U-15 Degreaser	Coarse scuff pad	70U-15 Degreaser

NOTES: With the second cleaning, make sure all residue is removed.







3. Application

	Mixing ratio	Ready for use
	Pot life at 68°F / 20°C	N/A
	Spray viscosity Ford 4 at 68°F / 20°C	N/A
	Spray gun HVLP	N/A
	Spray pressure HVLP at the cap	N/A
	Application	1 - 2 (entire part should be covered with medium wet coats)
	Film thickness	0.2 - 0.4 mil
	Coverage	N/A

Undercoat Technical Information

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4. Flash off / Drying / Sanding

	Flash-off at 68°F / 20°C	10 - 15 minutes prior to filler or topcoat application
	Drying at 68°F / 20°C at 140°F / 60°C	N/A N/A
	Infrared short wave medium wave	N/A N/A
	Wet sand by Hand	N/A
	Dry sand by Hand	N/A
	Dry sand by Machine	N/A

5. VOC / Comments

VOC as applied	688 gms/liter (5.7 lbs/gal)
PWMIR limit	2.50
Comments	

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use — read product label and Safety Data Sheet (SDS) for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.