

Product Code:
522-1410 White

VISCOSITY: 1600 cps at 77°F
FLASH POINT: 27°F (-3°C)
DENSITY (lb/gal): 11.0
SOLID (% by weight): 67%
SOLID (% by volume): 49%
SHELF LIFE (months): 12

Product Description: Plastiprimer 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. Plastiprimer MDF provides an excellent base and is extremely easy to sand.

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

Environmental Data (as supplied):

VOC less exempt lb/gal:	<3.61
VOC lb/gal:	<3.61
VOC less exempt g/l:	<433
VOC g/l:	<433
VOC lb/lb Solid:	<0.49
VHAPs lb/lb Solid:	<0.11

See individual compliance sheets for specific data

Application Data:

SUGGESTED USES:	Wood Primer
MIXING RATIO:	10 parts 522-1410 to 1 part 873-0870
POT LIFE:	12 hours
APPLICATION VISCOSITY:	Zahn #2 signature cup 20–30 seconds
REDUCER:	803-1325
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.

Directions for Use

Surface Preparation: Substrate should be sanded using 120, 150 or 180 grit stearated paper. Plastiprimer MDF cannot be used on metal, old oil or cellulose lacquers. Suitable topcoats are Plasticolor White 117-10XX, ES Lacquer II White 131-11XX, Variset® 131-70XX or Variset Plus 131-71XX.

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

Plastiprimer 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 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 MDF has been catalyzed. To ensure proper uniformity, the material should be agitated at all times. Recommended film build of Plastiprimer MDF is not to exceed 4 mils dry. Total recommended film build of Plastiprimer MDF and topcoat is not to exceed 6 mils dry.

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

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: 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.

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