

## **A1104 PLASTISOL Primer**

### **DESCRIPTION:**

A-1104 PLASTISOL PRIMER is a clear, air drying, thermo-setting primer for use with plastisols, organosols and vinyl fluidized bed coating. The resulting bond usually exceeds the cohesive strength of the plastisol.

### **PROPERTIES:**

|                           |                        |
|---------------------------|------------------------|
| Color                     | Clear                  |
| Weight per Gallon         | 7.24 lbs.              |
| Percent solids            | 14-16%                 |
| Flash Point               | 44 deg. F.             |
| Average Coverage          | 720 Sq. Ft. (.3 mil.)  |
| Viscosity                 | 10 - 30 cps Brookfield |
| 15 - 20 seconds (Zahn #2) |                        |

**THINNING:** Make up any solvent loss (through evaporation) with QCM Plastisol Primer Thinner or methyl ethyl ketone. Always test before regular production run. Thin to original viscosity (see above). Too thick of a coating of primer may cause entrapment of solvent pockets (skinned over), which will cause bubbling in the plastisol later, during cure.

**APPLICATION INSTRUCTIONS:** Solvent-clean the metal or substrate with acetone, methyl ethyl ketone, toluene or trichloroethylene. Sand blasting or chemical etching is required only when mill scale or rust is present. Dip, spray or brush a thin film of the primer onto the part and allow to dry until free of solvents; approximately 60 to 90 minutes. After the primer has dried, apply the plastisol by conventional methods. The primer needs to be heated to bake onto the substrate, but there is sufficient heating given from the normal Preheat required in Plastisol dipping and coating.

**PREHEATING:** When preheating the primed metal parts -**CAUTION- do not over bake.** Excessive heating of primed metal will destroy the action of the primer. Limit preheating to 10 - 15 minutes @ 375 deg. F for optimum adhesion ( ideally preheat just enough to get the metal up to 375 deg.F).

**SAFETY PRECAUTIONS:** Wear solvent-resistant gloves, protective clothing and chemical splash goggles when using this product. (Contains ketones) If contact with skin, wash with soap and water. Flush with water for 15 minutes. If contact with eyes, flush with water for 15 minutes. Consult physician. See MSDS.

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