

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	