



STARDUSTCOLORS SAS

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Series : PRIMER

LEXAN HYDRO PRIMER

Reference : HRC110

TECHNICAL DATA SHEET

Version : 21/05/2022

TYPE OF PRODUCT AND APPLICATIONS

LEXAN HRC110 primer is a new generation UHS single-component waterborne clear coat. Its innovative acrylic / aliphatic urethane formula allows it to grip on a variety of substrates, and in particular on Polycarbonate type plastics (including Lexan®). It can be applied without sanding on polycarbonate surfaces.

FIELD OF APPLICATION

Adhesion primer for model making, plastics industry, architecture.

Preparation :

On Lexan without sanding, dusted, degreased, dry, clean

COMPONENTS AND MIX

One-component, ready-to-use product

If necessary, dilute with distilled water, or our S6 thinners.

From 5 to 10%

be careful, in hot temperatures the viscosity drops rapidly, and excessive dilution can lead to a drop in adhesion power

PHYSICAL AND CHEMICAL CHARACTERISTICS

Aspect	Colorless, shiny, smooth
Product density	1.02 Grs/cm ³ ± 0.05
Solids rate calculated by weight :	38% ± 4
Degree of gloss :	+ 85°
Delivery viscosity NF4 :	80' ±8
Mixture Viscosity NF4 :	-
Pot Life Mix :	-
Theoretical yield	10 M2/L/Layer
VOC	<35g/L
pH	8 / 8.5

APPLICATION SYSTEMS

HVLP gun from 1.2 to 1.5mm

Gun pressure : according to manufacturer's recommendations

Airbrush : Nozzle 0.3 - 0.5 mm

INSTRUCTIONS FOR USE

Application

±50Grs./M2.

Suggested thickness: 20 µm dry (i.e. 1 coat)

Apply With pneumatic gun or airbrush with 1 or 1.5 coats*

- a half coat followed after 5 min by 1 normal coat

It is recommended to coat the primer for LEXAN within 30 minutes up to 1 hour to obtain the best cohesion and adhesion between the primer and the paint.

Overcoating without sanding is possible for up to 48 hours with HRC paints, however the level of adhesion gradually decreases as the primer dries.

DRYING

At a temperature of 20°C :

- out of dust : 15 min,
- out of touch : 25 min,
- apparent complete : 40 min

STORAGE AND PACKAGING AVAILABLE

69ml / 250 ml / 1 L / 5 L / 20 L

Maximum storage time :

6 MONTHS IN A TIGHTLY CLOSED CONTAINER