



# Axalta™ Plastic Primer Surfacer Black 320 and Plastic Primer Surfacer Gray 330



## GENERAL

### DESCRIPTION

A universal 2K Primer Surfacer for all plastic parts commonly found on passenger vehicle exteriors.

This economical primer surfacer can be recoated directly with an elastic base coat. It is characterized by good adhesion, high elasticity, and easy application. Axalta™ Plastic Primer Surfacer is available in black (320) and gray (330).

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Axalta™ Plastic Primer Surfacer Black 320  
Axalta™ Plastic Primer Surfacer Gray 330

### PERMACRON ELASTIC HARDENER

Axalta™ Plastic Primer Surfacer Hardener 331

### MIX RATIO

Component	Volume
Axalta™ Plastic Primer Surfacer	1
Axalta™ Plastic Primer Surfacer Hardener 331	1

### APPLICATION VISCOSITY

Approximately 17 – 21 seconds at 68°F/20°C, DIN 4

### POT LIFE

Approximately 8 hours at 68°F/20°C

### SPECIAL TIPS

1. For raw plastic prep, do not allow Axalta™ Plastic Cleaning Paste 265 to dry on the surface of the plastic substrate.
2. Thoroughly clean and scuff all surfaces of the plastic part, paying special attention to all edges.
3. Axalta™ Plastic Cleaning Paste 265 is designed for raw plastic and is not suitable for cleaning painted surfaces.
4. Always use a clean scuff pad.
5. Soft plastic may require a finer scuff pad.
6. Difficult to clean plastics may need to be cleaned more times, or if applicable the plastic may be baked for a minimum of 15 minutes at 140°F (60°C). Some OEM plastic bumpers do not recommend a bake cycle. Once the plastic has cooled, repeat the procedure below for preparing raw plastics beginning with step 2.

In the United States:  
**1.855.6.AXALTA**  
axalta.us

In Canada:  
**1.800.668.6945**  
axalta.ca





7. Plastic parts repaired with Axalta Plastic Primer Surfacer may not be washed with a high pressure jet within six weeks of the repair. After this period, the nozzle must be held at a distance of no less than 12 inches from the object.



## APPLICATION

### SUBSTRATES

All raw plastic parts commonly found on vehicle exteriors (Examples: PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, UP-GF).

Not recommended for pre painted substrates.

### SURFACE PREPARATION

#### Primed Plastic

Perform a solvent test to check if primer is reversible.

1. If the primer is reversible, then strip and treat as raw plastic.
2. If the primer is not reversible,
  - a. Wash with soap and water, clean all substrates thoroughly with Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.
  - b. Sand the primer (P500-800 when dry sanding or with P600-800 when wet sanding). Make sure to scuff all of the edges and hard to reach areas with a gray or gold scotch pad.
  - c. Re-clean with Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.
  - d. Recoat with an appropriate filler, surfacer and/or sealer from Cromax®, Spies Hecker®, or Standox®. Consult undercoat TDS for elastic recommendation.

#### Raw Plastic

The substrate must be free from release agents.

1. Rinse the raw plastic part thoroughly with water and pre-clean it using Axalta 265 Plastic Cleaning Paste and a clean gold scuff pad.
2. Continue to clean the raw plastic part another 2 to 3 times using new Axalta 265 Plastic Cleaning Paste and a clean gold scuff pad.
3. Remove all Axalta 265 Plastic Cleaning Paste residue from the plastic by thoroughly rinsing with clean water.
4. Before further treatment, clean the plastic substrate thoroughly with Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.
5. Apply **Axalta™ Plastic Primer Surfacer** as per below and recoat with an appropriate basecoat from Cromax®, Spies Hecker®, or Standox®.

### SPRAYGUN SETUP

HVLP	1.3-1.4mm
Approved Transfer Efficiency	1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

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- Apply 1.5 coats. (one tack coat followed by one full coat to obtain opacity).

**RECOMMENDED FILM THICKNESS**

Approximately 1.2 mil dry film thickness



**DRY TIMES**

**AIR DRYING**

Drying time at 68°F/20°C: 15-20 min. or max. 8 hrs. prior to solventborne basecoat  
 20-30 min. prior to waterborne basecoat  
 2 hours prior to sanding

**LOW BAKE**

Drying time at 140°F/60°C metal temp.: 30 minutes

**WET SANDING**

Initial sanding: P320  
 Final sanding: P600 – 800

**RECOAT**

With an appropriate basecoat from Cromax®, Spies Hecker®, or Standox®



**PHYSICAL PROPERTIES**

**Coating Category:** Specialty Coating  
**Axalta™ Plastic Primer Surfacer Black 320**

Max. VOC (AP): 675 g/l; 5.6 lbs/gal  
 Max. VOC (LE): 675 g/l; 5.6 lbs/gal  
 Avg. Gallon Weight: 1034.2 g/l; 8.63 lbs/gal  
 Avg. Weight % Volatiles: 65.28%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0%  
 Avg. Volume % Water: 0.0%  
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage @ 1 mil: 355.1 sq/ ft.

**Coating Category:** Specialty Coating  
**Axalta™ Plastic Primer Surfacer Gray 330**

Max. VOC (AP): 663 g/l; 5.5 lbs/gal  
 Max. VOC (LE): 663 g/l; 5.5 lbs/gal  
 Avg. Gallon Weight: 1046.9 g/l; 8.74 lbs/gal  
 Avg. Weight % Volatiles: 63.29%  
 Avg. Weight % Water: 0.0%  
 Avg. Weight % Exempt Solvent: 0.0%  
 Avg. Volume % Water: 0.0%

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Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage @ 1 mil: 377.6 sq/ ft.

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## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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