

# Standex<sup>®</sup> PF Plastic Adhesion Promoter



## Ordering Information:

1 Liter	PF Plastic Adhesion Promoter - White	020 16232
1 Liter	PF Plastic Adhesion Promoter - Black	020 16233
2.5 Liter	PF Reaction Agent	020 16224
2.5 Liter	PF Reaction Agent Slow	020 16225
1 Liter	PF Plastic Adhesion Agent	020 16234

## Features:

- ✧ **2K Plastic System for new, unprimed, or primed plastic parts**
- ✧ **Excellent adhesion to OEM plastic parts**
- ✧ **Wet-on-wet working process with Standox Basecoats**
- ✧ **Available in White and Black**

Working Process: 2K Plastic Priming for new, unprimed or primed plastic parts	
<b>Substrates:</b> ✓ For a list of paintable plastic substrates, see page 18. <b>Standex</b> does not recommend the refinishing of any plastic that is identified as not paintable by the OEM supplier. <b>New or unprimed aftermarket parts require Standoflex 1K Plastic Primer or Standoflex Plastic Primer Silver Aerosol overcoated with Standox VOC Compliant plasticised sealer.</b>	
	For substrate preparation information see <b>Standex</b> Painting System S1!
	4:1 with <b>Standex</b> PFH Hardeners (16212, 16213, 16214)
	15% <b>Standex</b> PF Reaction Agent (16224) or <b>Standex</b> PF Reaction Agent Slow (16225) and then 15% <b>Standex</b> PF Plastic Adhesion Agent (16234)
	14 s/DIN 4 mm/ 68°F (20°C) Potlife 45 min @ 68°F (20°C)
	1.3 - 1.4 mm 1-1.5 coats = 0.8 – 1.0 mil Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
	1.2- 1.3 mm 1-1.5 coats = 0.8 – 1.0 mil Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
	Wet-on-wet application Minimum 20 min/68°F (20°C) 30 min when overcoating with <b>Standoblue<sup>®</sup></b> Basecoat
	<b>Standex</b> Basecoats

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## Important Technical Remarks:

- Do not apply beyond recommended film thickness.
- Use only PFH Hardeners with this product.
- **Standox** PF Reaction Agent (16224) or **Standox** PF Reaction Agent Slow (16225) must not be stored below 50°F (10°C).
- **Standox** does not recommend the refinishing of any plastic that is identified as not paintable by the OEM supplier. Do not apply to aftermarket PP plastics.
- If higher film build is desired for repairs and for California regulations, apply 1 coat of **Standoflex** 1K Plastic Primer or **Standoflex** Plastic Primer over bare plastic. Flash off 30 minutes. Follow with plasticised PF Filler.
- It is very important to make sure that the **Standox** PF Plastic Adhesion Promoter has thorough flash-off. Do not trap solvents.
- Maximum time before top coating is 8 hours at 68°F (20°C).
- For minor imperfections, lightly sand or denib.
- Do not add 2K Plasticiser to this product.

**Standox** PF Plastic Adhesion Promoter is mixed 4:1 with **Standox** PFH Hardeners (16212, 16213, 16214) plus 15% **Standox** PF Reaction Agent (16224) or **Standox** PF Reaction Agent Slow (16225) and 15% **Standox** PF Plastic Adhesion Agent (16234). See tables below for mix ratios by gram weights.

<b>Mixing Table with PF Reaction Agent (16224)</b>		
	<b>PF Plastic Adhesion Promoter - White (16232) (Pint - Cumulative)</b>	<b>PF Plastic Adhesion Promoter - Black (16233) (Pint - Cumulative)</b>
<b>PF Plastic Adhesion Promoter</b>	480.3	435.4
<b>PFH Hardener</b>	564.8	519.9
<b>PF Reaction Agent (16224)</b>	632.0	587.2
<b>PF Plastic Adhesion Agent</b>	686.4	641.6

<b>Mixing Table with PF Reaction Agent Slow (16225)</b>		
	<b>PF Plastic Adhesion Promoter - White (16232) (Pint - Cumulative)</b>	<b>PF Plastic Adhesion Promoter - Black (16233) (Pint - Cumulative)</b>
<b>PF Plastic Adhesion Promoter</b>	480.4	435.5
<b>PFH Hardener</b>	564.7	519.8
<b>PF Reaction Agent Slow (16225)</b>	626.9	582.0
<b>PF Plastic Adhesion Agent</b>	681.3	636.4

**Important Legislative Remarks:**

- Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “ready to spray”.

VOC Category	VOC (ap/le)	Vol % Solids	Wt% Volatiles, Water & Exempts	Gallon Weight (lbs/gal)
Adhesion Promoter	237/367 g/l	37.6%	52.2%, 0,002%, 34.6%	11.22

- **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 MSDS precautions. If mixed with other components, mixture will have hazards of all components. 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.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.