



TECHNICAL DATA SHEET No 820

## SPRAY P340 PLASTOFIX

### GENERAL TECHNICAL DESCRIPTION

High-quality aerosol adhesion promoter for plastic parts.

Suitable for metallic substrates as well.

Easy to use.

Fast drying time.

### SURFACE

Plastic parts excluding pure PE (Polyethylene)

HB BODY Polyester Fillers

HB BODY 950 STONE CHIP & U951 AUTOFLEX

Metallic (Stainless steel, Aluminium, Bare metal, Galvanized)

### PRETREATMENT/CLEANING OF SUBSTRATE

The surface to be coated must be dry, clean, and free of grease and other contaminants. Ensure all substrates are thoroughly cleaned and dried at every step of the preparation process.



Sand substrate with an appropriate grit paper.



Clean the surface with 770 NORMAL / 771 FAST ANTISIL Degreaser.

Use 2 clothes wipe on, wipe off. Always wipe cleaner off the surface as long as is wet, with a clean, dry cloth.

Remove dust by air blowing and a tack cloth.

### PRODUCT APPLICATION:



Shake well before using:  
2 - 3 min



Spray at a distance of  
20 - 30 cm, thinly applied  
coats



2 - 3 coats  
10 - 15 µm



5 min / 23°C (73°F)  
Flash off time between  
coats



10 min / 23°C (73°F)



Overcoat with any  
HB BODY Primer and  
Topcoat



After use turn bottle  
upside down and spray  
out a small quantity,  
for the cleaning of the  
nozzle

### SPECIFIC GRAVITY

$0.7 \pm 0.02 \text{ g/cm}^3$

### SOLID CONTENT

$2.5 \pm 0.5\%$  Weight

### VOC (2004/42/EC)

This is an aerosol product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 840g/L.  
2004/42/IIB(e)(840)840

### REMARKS

- Shake for 2 - 3 min after agitator ball has started to rattle.
- Optimum operating temperature range 10 - 25°C (50 - 77°F).
- Do not use at temperatures below 10°C (50°F).

### STORAGE SHELF LIFE

Guaranteed shelf-life 36 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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