



# 340 PLASTOFIX 1K PLASTIC ADHESION PROMOTER

Technical Data Sheet No 109



VOC compliant with the regulations

1K Plastic adhesion promoter

Excellent filling properties

Easy to apply

Excellent mechanical properties

## General Technical Description



Ready to use  
No thinner addition



Air dry  
10 min / 23°C (73°F)

## Surface

Exterior plastic parts of a car

HB Body Polyester Fillers

BODY 950 UNDERBODY COATING

U 951 AUTO FLEX

Excluding PE (Polyethylene)

## Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and BODY 770 ANTISIL NORMAL / BODY 771 ANTISIL FAST.

Make sure the surface is first wiped dry and then air dried.



Make sure you always use appropriate face protection and good ventilation

## Product Application: An Adhesion promoter

2 passes »»» Apply in thin layers over sanded areas plastic surfaces to enhance primer adhesion



Compliant Spray gun  
1.2 – 1.4 mm  
2-3 bar (29-44psi)  
inlet pressure  
2x coats = 5-10µm  
(0.2 - 0.4mil)



Follow the application instructions mentioned in this TDS

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with the recommended solvents
- It can also be used by countries that do not adopt the VOC legislation.
- Do not use at temperatures below 15°C (59°F).



HVLP Spray gun  
1.3 mm  
2 bar (29psi)  
inlet pressure

**Flash Point:**  
4°C / 40°F

**Specific Gravity:**  
0.90 g/cm<sup>3</sup>



5-10 min @ 23°C (73°F)  
Flash off time

**Solid Content (No thinner):**  
12% Weight

### VOC (2004/42/EC)

This product is a special refinishing product based on its ingredients and its properties. The maximum VOC content in this category is 850 g/L. The VOC content in the ready for use form of this product is 800 g/L.  
2004/42/IB(a)(850)800

### Storage Shelf life:

- Store in a cool place (+5°C - 25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers



Air dry  
10 min / 23°C (73°F)

### Theoretical Coverage:

30 - 35 m<sup>2</sup> / l at 10 micron (0.4mil) dry film thickness



HB BODY Fillers  
HB BODY Top Coats

### Cleaning of equipment:

Clean after final use with Body 740 ACRYL NORMAL



Always wear protective equipment

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