

Technical Data Sheet



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Data sheet Nr. 502000

AVKOTE PP 502

Product description	One-Component adhesion promoter (containing solvents) for PP (polypropylene) and many PE types (polyethylene).
Binding Agent	Special synthetic resins
Areas of Application	Adhesion Promoter for PP (polypropylene) and many PE (polyethylene) type surfaces.
Form of Supply Colours	Slightly Yellowish
Packing Coating	1 Litre disposable containers

Technical Data


The data is valid for Avkote PP 502.							
	Coating		Hardener		Mixture		
Specific Gravity (23 °C)	0.86	g/cm ³	g/cm ³		g/cm ³		
Solids content	±	Weight-%	±	Weight-%	Appr	Weight-%	
Organic Solvent Content.	97.5 ± 1	Weight-%	±	Weight-%	Appr	Weight-%	
VOC Content (CH / EU)	97	%		g/lt	%	g/lt	
Shelf life at 20 °C	Approx 6	Months	If stored below freezing crystal will form, which will soluble again in the heat				
Theoretical Coverage	g/m ²	m ² /kg for	µm dry layer thickness				

Safety Data	Coating		Hardener	
Flash point	24 °C		°C	
Transport ADR/RID	Class: 3	VP: III	Class:	VP:
Poison classification (EU)				
VVS disposal code (EU/CH)	08, 08 01, 08 01 11			



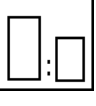
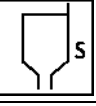





Application Recommendations


Substrate	No. of Coats	Product	Dry Film thickness	Data sheet
Polypropylene & Polyethylene	1 x Adhesion Promoter	Avkote PP 502	5 - 10 µm	502000
	1 x Top Coat	Avkote LE Or Avkote HR Or Avkote KF	30-50 µm	5393/LE 5360 5393/KF
For further application proposals please ask our technical department.				

Preparation

	Substrate	Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences.
	Polypropylene & Polyethylene	Clean with Avkote 153b Cleaner first then with Avkote 154 Cleaner. Apply Avkote PP 502. Leave to dry. Apply Avkote LE.

Processing

	Preventative measures	We recommend the wearing of protective clothing even if not stipulated by law. The national and regional health and safety regulations for work hygiene and equipment are to be observed. Pay attention to our safety data sheet Nos. 502000.				
	Stir	Before use ensure contents are stirred thoroughly before use.				
	Mixing Ratio	N/A				
	Pot life at 20 °C	2 hr.				
	Thinners	Not Required				
	brush	Not recommended				
	Roll	Not recommended				
		Viscosity DIN-4	Thinners	Nozzle	Pressure	Spray coats
	Gravity Feed Spray-gun	10 secs	0 %	1.2 mm	As Required	2
	Suction-spray-gun	10 secs	0 %	1.2 mm	As Required	2
	HVLP paint gun	10 secs	0 %	1.2 mm	As Required	2

	Application	Avkote PP 502 should be applied in thin, even and straight wetting layers. After having completed the drying process the over-painting is immediately possible. Due to the different kind of plastics a trial coating to check the adherence should be made.		
	Drying time	For µm dry coating at % of relative humidity		
	At 20 °C	Tack-Dry	after:	1 Minutes
		Touch – Dry	after:	3 Minutes
		Suitable for re-coating	after:	5 Minutes

Important references

Specific restrictions	Relative humidity max. 80 %		
Minimum application- and drying temperature	5	°C	Do not apply at temperatures below the dew point
Equipment cleaning	Clean immediately after use with Gun Wash Thinners.		

Important Recommendations

	Please observe our Material Safety Data Sheets for all products used as well as the instructions on the tin label.
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