

868 1K Plastic Primer

used over flexible parts

Products	868 1K Plastic Primer 851 Prep and Wash 902 Plastic Prep Cleaner 910 Universal Prep Cleaner AM902 Aero-Max Plastic Prep and Cleaner		
Cleaning	See Flexible Parts section “Cleaning & Preparing Vehicle Surface for Undercoating”.		
Pretreatments	N/A		
Mixing Ratio	Ready to Spray		
Application	1 to 2 uniform coats		
Drying	20°C/68°F	Tack Time 5 Minutes	Dry Time 15 to 30 minutes
Sanding/ Polishing	If 868 has been dried for more than 4 hours reapply a uniform coat.		
Notes			



868 1K Plastic Primer

Technical Data



Characteristics

R-M 868 1K Plastic Primer is a multi-purpose adhesion promoter for all paintable plastics on cars. It is supplied ready to spray. No hardeners or reducers are required.

Technical Data

Viscosity	10 sec. #4 Ford cup
Fluid Tip (HE Gravity)	1.3 mm
Fluid Tip (HVLP gravity)	1.3 mm
Air Pressure (HVLP/HE)	8-10 psi at air cap
Number of Coats	1 to 2 uniform coats
Thickness	0.2-0.4 mils
Pot Life	Indefinite
Coverage	496 sq ft/gal @ 0.25 mils
VOC as Applied	805 gms/ltr (6.7 lbs/gal)

Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Apply 1 to 2 light coats of 868 to the entire flexible part.
- Allow 868 to dry for 15 to 30 minutes, but no longer than 4 hours prior to application of primer or color coats.
- Clean flexible parts with 851 Prep and Wash or warm soap and water.
- Clean all flexible parts using 902 Plastic Prep Cleaner, 910 Universal Prep Cleaner or AM902 Aero-Max Plastic Prep and Cleaner. Check local regulations.
- Do shake 868 by hand for a few minutes
- Do use for both raw plastic as well as (non-soluble) primed plastic.