

## Technical Data Sheet

# Indokote IK-70

## Solventborne Adhesion Promoter

### Product Description

This is a one component fast air drying chlorinated polyolefins based adhesion promoter for difficult to adhere to substrates. It promotes adhesion to polypropylene, TPO and other plastics.

### Recommended Use

This product is recommended to apply directly over various plastic surfaces to enhance adhesion to subsequent paint/ ink or coatings. It is highly recommended to be used over polypropylene, thermoplastic polyolefins (TPO) plastics used in applications such as automotive parts, toys, appliances, containers etc to protect or to provide aesthetic looks to plastic parts.

### Physical Data

Colour	: Colourless Liquid/ Grey
Finish	: Matt
Soild by Volume	: 04 ± 1%
Supply Weight (Kg/ Ltr)	: 0.90±0.02
Flash Point	: 27° C
Dry Heat Resistance	: Intermittent : 100°C
Shelf Life	: 12 months

### Film Thickness

#### Recommended film thickness per coat

Dry Film Thickness	: 05-10µ in single coat
Theoretical Coverage Rate	: 5.00 sq.mt / lit at recommended DFT of 10µ

### Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent (Isopropyl Alcohol) cleaning.

**New Surface:** The fresh or New Plastic surface should be dry and free from all contamination and Indokote IK-70 should be applied immediately after Isopropyl Alcohol cleaning. Topcoat should be applied within the overcoating intervals specified.

**Repair Cases:** Used or old plastic should be clean with appropriate degreasers to remove oil, grease, dust or any other contamination. Later surface should be cleaned IPA before applying IK-70. Topcoat should be applied within the overcoating intervals specified and maximum in 10 minutes.

## Application Data

Application Method	: Conventional Spray Only
Mixing Ratio	: One Component Coating
Pot Life	: NA
Thinner and Cleaner	: Ready to Use
Gravity Fed Spray Gun Nozzle Orifice	: 1.3 - 1.5mm
Nozzle Pressure	: 25-28 psi

**Working Precautions:** Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommence with freshly mixed units.

**Maintenance:** Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

## Drying Characteristics

Surface Dry	: 5 mins
Touch Dry (to Handle)	: 10 mins

Overcoating Interval : Minimum 5 mins, Maximum 10 minutes

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

## Compatibility

Previous Coating	: None. Only Cleaning with IPA
Subsequent Coating	: Acrylic, Polyurethane, Modified Alkyd, Alkyd

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## Product Features

The adhesion level enhancement is subject to application method, dry film thickness and environmental conditions within a controlled OEM painting facility. Adhesion level achieved may differ if there is excessive variation in cure temperature and application thickness. The best results in terms of adhesion will always be obtained by air spray application and at recommended DFT level.

This product must not be thinned and is a ready to use product. The use of alternative solvent cleaners, might contain different chemicals, can severely affect the curing or adhesion mechanism of the coating. Topcoat over IK-70 should be applied within overcoating recommendations for best results.

## Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

## Precaution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be used under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

### Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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