

**Primer**

**Application:** Water-based synthetic resin primer for plastics and plastic foils.  
**Before use, test for suitability.**

**Characteristics/** **Stir well before use.**

**Directions****for Use:**

**We recommend that all materials coming into contact with the glue are made of high-quality stainless steel (German standard V2A according to DIN EN 10027 – W-No. 1.4301 or better) or of inert plastics, e.g. Teflon, PP, polyamide. Avoid contact with other metals like zinc, brass, copper or aluminium. For more information, contact the equipment manufacturer or our technical service.**

Thin and even application by means of gravure or foam rubber roller.  
 Max. application amount approx. 10 g/m<sup>2</sup> (dry). After application, the primer has to be completely dry; any water remnants may cause flawed bonding. Preliminary testing has to be carried out in order to establish optimum drying conditions. In order to achieve good adhesion results, polyolefin surfaces must be corona-pretreated very thoroughly. Uneven or too thick application as well as the use of insufficiently stirred material (sedimentation) will lead to flawed bonding.

Roll coated foils only after completely drying.

Appearance:	white
under UV light:	blue

Our Application Technology Department and our Application Specialists will provide technical data to assist you in your choice of an appropriate primer-adhesive system for your requirements. Please observe the information in the section "Remarks".

**General coating requirements:** The properties (e.g. surface tension, plasticiser content...) and the conditioning of the substrates, as well as the processing conditions (e.g. ambient temperature, humidity...) will influence the processes of application and coating. Customer tests under consideration of everyday production conditions are therefore absolutely necessary to define stable process parameters and to ensure that the product is fit for purpose. For best coating results, the materials to be coated should be free of dust, oil, and grease, and be dry. Avoid draught.

<b>Specification:</b>	Viscosity at 20 °C [mPas]:	700 ± 200
	(Brookfield, RV, spindle 2, 20 rpm)	
	Density at 20 °C [g/cm <sup>3</sup> ]:	1.08 ± 0.04
	(Jowat test method)	
	Solids content, 2 h at 90 °C [%]:	33.50 ± 2
	(Jowat test method)	
	pH value at 20 °C:	8.00 ± 1.00
	(Jowat test method)	

continued on page 2

**09/18** All data indicated are characteristics represented as average values. Our technical data sheets are periodically revised to represent the latest state of technology. This edition is replacing and superseding all previous ones, and is valid on the date of compilation.  
**Please refer to the last page of this technical data sheet for additional information.**

**Jowat**   
 Klebstoffe

**Cleaning:** Jowat® PUR Cleaner 402.32.

**Storage:** In properly closed original containers, cool and dry (15 – 25 °C). Best-before date, please refer to label on the packaging unit. During transport, the temperatures may be lower, from 6 °C to 14 °C. The material may be exposed to those temperatures for a maximum duration of 14 days. If in doubt, the temperature of the material is to be checked upon receipt of the goods. Cold material may not be processed, but must be previously warmed up slowly by storage at 15 – 25 °C (exposure over 2 to 3 days, depending on the volume of the packaging unit).

**Packaging:** Information about packaging types and units is available upon request.

**Remarks:** **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**

The information on this data sheet is based on test results from our laboratories as well as on reported experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding upon Jowat, nor should it be relied upon in lieu of your own required testing. The information given in this leaflet does not represent a performance guarantee. Unless otherwise agreed with our customers, the values stated in the section "Specification" shall be regarded as the product properties finally agreed. No liability may be derived from the information contained herein nor from the information provided by our free technical advisory service.

## **Jowat Information**

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

The information given in this leaflet is based on practical experience and on results of tests in our laboratory, and does in no way constitute any guarantee of properties. No liability may be derived from these indications nor from the recommendations made by our technical advisory service.