

2K Polyester primer for aromatic nylon substrate

PANUCO PA

(N894- series)

Introduction

For its excellence in flexural rigidity and hardness, Nylon(PA) substrate is recently popular used as a substrate for cellular phone, and laptop etc. Especially aromatic type of Nylon substrate has low water absorption, yet solvent resistant, and it has been developed in various grades like composite type of plastics such as carbon fiber-reinforced, glass fiber-reinforced, and filler-reinforced. PANUCO PA is a primer developed for above purposes, and it is applicable for a variety of usage on aromatic type of Nylon substrates, and has a potential to be a major engineering plastic to be utilized.

Features

1. Good concealment
2. Good adhesion with various grades of substrates
3. Good adhesion with HAIUREX P series
4. Tough film performance.
5. Excellent designability

Product code

N894- PANUCO PA Various colors

Recommended thinner & hardener

(Thinner)

Z-L163 PANUCO PA THINNER(quick-dry)
 Z-L165 PANUCO PA THINNER(moderate)
 Z-L167 PANUCO PA THINNER(slow-dry)

(Hardener)

Z-H-430(moderate)

Applicable substrate

Aromatic nylon substrates
 (The Mitsubishi engineering plastics company make RENY etc.)
 SPCC-SB Polish steel plate
 SPCC-SB Zinc phosphate coated steel plate
 Aluminum(A1050P), Aluminum alloy(A5052P)
 Stainless(SUS-304)
 Zinc coated steel plate

Precautions

1. Clean the substrate surface before spraying. Poor adhesion and craters may be caused by contaminant, such as release agents on the substrate.
2. If thinner other than recommended thinner used for PANUCO PA, it will cause solubility issue, so please use recommended thinner to dilute a paint, and for washing utensils as well.
3. Check adhesion, solvent resistance of the substrate, curability etc. before use, since a variety of resin grades have been developed.
4. Make sure to stir paint thoroughly before use. Pour the diluted paint into a stirred tank, and spray while stirring.
5. Avoid direct sunlight and store it in a cool and dark place (-20°C to 40°C).
6. As this is 2k paint, please dilute minimal amount when use. Pot life time of this paint is 4 hours at 20 degrees. If exceeded more than pot life time, paint may not perform as expected.
7. Please refer to SDS etc for further precautions.

Please contact below if any enquiry upon this product

Musashi Paint Co., Ltd. Iruma Factory

11-2, Sayamagahara, Irumashi, Saitama 358-0032
 Sales Dept : Tel.+81-4-2908-7634 Fax.04-2935-0273
 R&D Dept : Tel.+81-4-2934-4138 Fax.04-2935-2736

Osaka Office

1-17-13 Mizuhai, Higashi-Osakashi, Osaka 578-0921
 Tel.+81-72-963-1133 Fax.+81-72-963-0606

Nagoya Office

Komaki Gas Building 3F, 1-267 Chuo, Komaki, Aichi 485-0029
 Tel.+81-568-54-2113 Fax.+81-568-54-2117

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Standard spray specifications		
Terms		Specifications
Mixing ratio Paint:Hardener:Thinner (by weight)		10:1:8±1
Spraying viscosity(IWATA VISCOMETER NK-2 at 20°C)		10±2 sec
Spraying method	Orifice diameter	1.3±0.3mm φ
	Spray gun pressure	0.3±0.1MPa
Spray distance		25±5cm
Drying condition	Flash off	25°C × 5min
	Drying	80°C × 30min
DFT		10±2 μ m

■ Film performance

Test item		Test conditions	Result
Adhesion		1mm Cross Hatch Adhesion Test (10x10)	100/100
Hardness		Mitsubishi pencil UNI 1kg of load	2H
Scratch resistance	Eraser	Sony eraser testing equipment, 1.64kgf, 300rounds, no substrate exposure	Pass
	Jeans	Rubbing tester, 500g/cm ² , 2000cycles, no substrate exposure	Pass
Alcohol resistance		99.5%ethanol rubbing, 500g/cm ² , 500rounds, no substrate exposure	Pass
Thermal resistance		1mm cross-cut adhesion test after 85°C × 96hr	100/100
Low temp resistance		Adhesion test after -40°C × 96hr	100/100
Thermal resistance		1mm cross-cut adhesion test after 85°C × 96hr	100/100
Humidity resistance		1mm cross-cut adhesion test after 40°C × 98%RH × 48hr	100/100
Heat cycle resistance		1mm cross-cut adhesion test after 10cycles of -20°C × 3hr⇔60°C × 3hr	100/100
Print resistance		Polyethylene foam, 80g/cm ² , 60°C, 48hr, No change in appearance	Pass
Spraying condition		Substrate: Aromatic nylon (The Mitsubishi engineering plastics company make RENY NXG5945S) <u>Under coat</u> N89400 PANUCO PA MAT CLEAR Paint: Hardener(Z-H-430) : Thinner(Z-L165)=10 : 1 : 8(by weight) Flash off 25°C × 5min Drying 80°C × 30min Dry film 10±1 μ m <u>Middle coat</u> GP79- HAIUREX P GRANDE BONUL Silver Paint: Hardener(Z-H-250) : Thinner(Z-K245)=10 : 1 : 10(by weight) Flash off 25°C × 5min Drying 80°C × 30min Dry film 9±1 μ m <u>Top coat</u> UV7205KF ULTRA VIN HALF MAT CLEAR Paint: Thinner(Z-27095)=100: 120(by weight) Preheating 60°C × 5min UV irradiation Lamp High pressure mercury(Hg) lamp Peak illumination 100mW/cm Light quantity 800mj/cm ² DFT 10±1 μ m (Test after exposing in RT for 7days)	
*The listed property value is for your reference only which based on our test result and does not indicate the spec value. Please purchase the product after considering thoroughly.			
*Please be aware that for improvement purposes, product spec details may change without prior notice.			