

Duoprime[®] P (DPP1)

► Product description

Duoprime P is a hard yet flexible UV cured primer with immediate adhesion to many plastic surfaces, fully compatible with high performing UV-acrylate lacquers and roll-to-roll application. It has a high energy absorbing capability which adds durability and robustness to the coating.

► Areas of application

Products	Adhesion primer for flexible plastic substrates
Substrates	PET, Mylar, Kapton, PVC and LVT-flooring

► Preparations

Primer	Mix A and B components of Duoprime P in proportion specified on the buckets. Stir manually.
Substrate surface	Dust free surface, plasma treatment typically not required.

► Application

Roller	30-50 Shore A
Application amount	5-12 g/m ²

► Times

Curing	Gelling: 200-500 mJ/cm ² UV-curing: 1500 mJ/cm ²
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Comments on curing	The first UV dose has to be sufficient to gel the primer enough so the layer is not damaged when the top coat is applied. A too high dose may lead to problems with interlayer adhesion between the primer and the next lacquer layer. After the top layer is applied, a UV dose large enough for the final cure has to be applied. How much energy is required will depend on how thick layers are put on the primer, and the UV absorbance of these. 1500 mJ/cm ² is a start indication.
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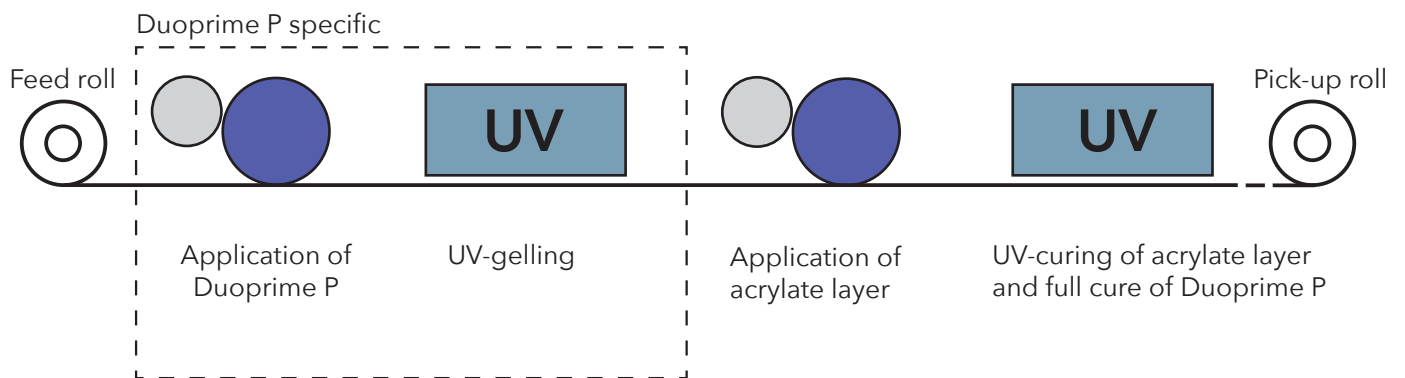
► Technical data

Pot life	24 hrs in machine after mixing the components at 25 °C.
Shelf life in weeks	26
Appearance	colorless when cured
Viscosity of mixed primer	Approx 1000 mPa.s
Content	100% solid, 0% solvents, 0% isocyanates, 0% water
Storage temperature	5-25 °C
Safety markings	Comp A: irritant, Comp B: irritant, hazardous for aquatic life

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► Sample process / line specifications

The coating process and the precise treatment parameters are adapted to the respective application and substrate, but general line characteristics are presented below, Duoprime P can be applied in a roll-to-roll line or in a conveyor belt line. After the Duoprime P specific application process the subsequent acrylate layer(s) are applied according to specifications from the supplier, taking into account that Duoprime P must be fully cured in the subsequent UV curing steps.



► Ordering information

Order number	DPP 201
Container size	Component A: 5 kg, 20 kg Component B: 5 kg, 20 kg