

Technical Data Sheet

This unique combination of adhesion promoter and primer provides significant labor and cost savings and now is available in a Low VOC version. It can save up to 2 hours of labor when prepping a raw or previously primed bumper or plastic part. Adhesion Primer is a single component non-sanding primer suitable for TPO & RIM substrates. It is fast drying and offers excellent adhesion. It is available in 3 colors to best suit your needs. No need for two steps, adhesion promoter and primer all in the same step!

SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Bare Steel		Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching	
Bare Galvanized		Raw Plastic - Flexible (ABD, PPO) +	✓	Primer - 1K	✓
Bare Aluminum		Raw Plastic - Soft (PUR) +	✓	Primer - 2K	✓
OEM E-Coat**		Plastic Part - Primed ++	✓	OEM Finish & Old Paint Work - Reversible	
Fiberglass/SMC Gel Coat	✓	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible	✓

** Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

MIXING



By Volume: Ready to Spray
Thinning is not necessary.
Pot Life Unlimited in a sealed container

FLASH TIMES/DRY TIMES



To topcoat: 30 minutes
Force dry: 5 minutes @ 120°F (49°C)

SURFACE PREPARATION



Clean surface with Aqua SCAT 2 1391/1394. Wipe dry with clean cloth.
* For more information on surface prep and application refer to next page.

SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.2 - 1.4	1.4 - 1.6
Air Pressure	10 PSI @ aircap	40 - 50 PSI @ regulator
Mil Thickness: 0.2 - 0.4 mils (dry film thickness)		

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	HVLP/LVLP
Fluid Tip	1.4 - 1.6	1.4 - 1.6	1.2-1.4 mm
Air Pressure	40 - 50 PSI	40 - 50 PSI	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	N/A
<i>Always refer to gun manufacturer's recommendation for proper set up and spray pressure.</i>			

SURFACE PREPARATION

Cleaning: Wash with warm water and soap (silicone & oil free). Rinse with water. If water does not sheet off, wash again. Assure all silicones are removed. Wash surfaces thoroughly with Aqua SCAT 2 1391/1394. Rinse well and dry with a clean cloth. For best results we recommend that the part be cleaned twice using Aqua SCAT 2 to assure that substrate is free of any contamination such as grease, oil or dirt for optimum performance and adhesion. Remove dust from surface with clean tack cloth.

Note: This product is acceptable for use with waterborne primers such as Hydroflex 1221/1225/1235.

TINTING & ADDITIVES

Tinting: Not recommended.
Additives: Fisheye Remover (6737) - Do not use. Universal Urethane Flex Additive (9194) - Do not use.
 Kicker (6417) - Do not use.

APPLICATION & FILM BUILD

Mixing: Agitate thoroughly before use. Thinning is not necessary. Apply 1 – 2 medium wet coats. Allow 5 minutes flash time between coats. Good air movement is recommended to facilitate removal of evaporating solvent. Allow to dry 30 minutes before topcoating. It can be re-coated up to 24 hours from the time of application. After 24 hours, lightly scuff with a gray scuff pad and clean with Aqua SCAT 2 1391/1394 before application of topcoat.

Film Build: 0.2 - 0.4 mils per coat (dry film thickness)

FOR OEM PRIMED BUMPERS - When using Adhesion Primer as a sealer over OEM primed bumpers, sand the bumper with 400-600 grit sandpaper. Thoroughly degrease with Aqua SCAT 2 1391/1394. Apply one coat of Adhesion Primer and allow it to dry 30 minutes before topcoating.

WHEN APPLYING BASECOAT COLOR - If spraying a solvent basecoat, Adhesion Primer can be directly topcoated, wet on wet, and then clearcoated. If spraying a waterborne basecoat, Adhesion Primer must be sealed with a 2K sealer for proper adhesion!

Note: Waterborne basecoats do not adhere well when applied over a 1K sealer product. We recommend the use of Transtar's 6200 Series 2K Kwik Seal or Signature Series Low VOC Sealer 9500 Series.

PRODUCT SPECIFICATIONS

Color: White (1074-F), Gray (1084-F), Black (1094-F)	Shelf Life: 1 year
RTS Solids by Weight: 22.5-25.5%	Weight per gallon: 7.50 - 8.50 #/gal
Size: Quart	Approximate Coverage: 450 ft ² /gal @ 0.5 mil

REGULATORY

Category: Adhesion Promoter	1074-F	1084-F	1094-F
VOC Actual	1.76#/gal (211 g/l)	1.65#/gal (197 g/l)	1.72#/gal (206 g/l)
VOC Regulatory	4.45#/gal (533 g/l)	4.42#/gal (530 g/l)	4.48#/gal (537 g/l)
Weight % of Volatiles	75.94	77.15	78.30
Weight % of Water	0	0	0
Weight % of Exempt Compounds	53.65	55.69	56
Volume % of Exempt Compounds	60.41	62.72	61.60
Density of Material #/gal	7.91	7.68	7.71