



Low VOC Adhesion Primer

1074, 1084, 1094

This unique combination of adhesion promoter and primer provides significant labor and cost savings. 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 available in 3 colors to best suit your needs. No need for two steps, adhesion promoter and primer all in the same step!



Mix Ratio

Ready to use, thinning is not necessary.
Pot life: unlimited in a sealer container.



Suitable Substrates

- Raw plastic - rigid (SMC, BMC)
- Raw plastic - flex (ABD, PPO)
- Raw plastic - soft (PUR)
- OEM finish & old paint work - non-reversible
- 1K primer
- 2K primer
- Plastic part - primed
- Body filler
- Fiberglass/ SMC gel coat

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

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



Surface Prep & Application

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.

Mixing: Agitate thoroughly before use. Thinning is not necessary. Apply 1 medium wet coat. 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 recoated 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.

Tinting & Additives

Tinting Not recommended.
 Kicker (6417) Do not use.
 Fisheye Remover (6737) .. Do not use.
 Flex Additive (9194) Do not use.



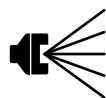
Flash Times/Dry Times

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



Gun Set-up

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|--------------------------------|---------------------------------|
| Siphon feed 1.4 - 1.6 mm | Gravity feed 1.4 - 1.6 mm |
| HVLP/LVLP 1.2 - 1.4 mm | |



Air Pressure

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|-----------------------------------|--|
| Siphon feed 40 - 50 psi | Gravity feed (@ regulator) 40 - 50 psi |
| HVLP/LVLP (@ aircap) 10 psi | |



Product Specifications

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|---|---|
| Color (1074) White | Size Quart |
| (1084) Gray | Shelf life 3 years |
| (1094) Black | RTS solids by weight 22.5 - 25.5% |
| Approx. coverage 450 ft ² /gal @ 0.5 mil | |

Regulatory

1074

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|--|--------------------------------------|
| Category Adhesion promoter | Wt % of volatiles 75.94 |
| VOC actual 1.76#/gal (211 g/l) | Wt % of water 0 |
| VOC regulatory 4.45#/gal (533 g/l) | Wt % of exempt compound 53.65 |
| Density 7.91 #/gal | Vol % of exempt compound 60.41 |

1084

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| Category Adhesion promoter | Wt % of volatiles 77.15 |
| VOC actual 1.65#/gal (197 g/l) | Wt % of water 0 |
| VOC regulatory 4.42#/gal (530 g/l) | Wt % of exempt compound 55.69 |
| Density 7.68 #/gal | Vol % of exempt compound 62.72 |

1094

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| Category Adhesion promoter | Wt % of volatiles 78.30 |
| VOC actual 1.72#/gal (206 g/l) | Wt % of water 0 |
| VOC regulatory 4.48#/gal (537 g/l) | Wt % of exempt compound 56 |
| Density 7.71 #/gal | Vol % of exempt compound 61.60 |



Limitations & Precautions

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

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