



# Mul-TIE Adhesion Promoter

Recommended procedure for clear coating aluminum, polished aluminum, and diamond plate Aluminum.

As there may be different grades and types of aluminum substrates, it is recommended to test a piece with the following procedure to ensure adhesion.

1. Clean part thoroughly with warm water and soap, followed by SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.
2. Apply 2 coats of 1033 Mul-Tie Adhesion Promoter, allowing 2-4 minute flash between coats.
3. Allow 1033 Mul-Tie Adhesion Promoter to dry for 20 minutes minimum before topcoating. Allowing more than 20 minutes will greatly improve the adhesion properties of the 1033. 1033 can be recoated up to 24 hr. from the time of application.
4. Apply 2 coats of any Transtar Clearcoat, follow all mixing and flash time recommendations. The use of additives such as accelerators is strongly discouraged.

\*Failure to adhere to the above procedure will result in poor adhesion\*

Allow the test piece to cure for 24 hours before performing the adhesion test regardless of the “cure” time specified on the data sheet of the particular clearcoat you have chosen.

**Adhesion test procedure:**

1. Make a cross hatch ( # ) on the test piece with a razor knife.
2. Apply a piece of masking tape on the cross hatched area, rub the tape thoroughly to ensure good surface contact of the tape adhesive.
3. Remove the tape quickly pulling at a 90° angle to the panel surface.
4. Check the tape and the panel, if the clear pulled from the panel and is stuck to the tape the grade of aluminum may not be a good candidate for clearcoating.



**Product Availability:**

1031	Mul-TIE Adhesion Promoter	Gallon, 2/case
1033	Mul-TIE Adhesion Promoter	16 oz. Aero, 6/case
1034	Mul-TIE Adhesion Promoter	Quart, 4/case