

Technical Data Sheet

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 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 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.

PRODUCT SPECIFICATIONS

Color: White (1074), Gray (1084), Black (1094)	Shelf Life: 3 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	1084	1094
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