

TRANSTAR[®]

AUTOBODY TECHNOLOGIES, INC.

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, Transtar's Adhesion Primer combines adhesion promoter and primer in one easy step!

All 3 colors available in a National Rule Compliant version and a Low VOC Version for regulated markets!!!

BENEFITS

- Significant cost savings - save up to 2 hours of labor time when prepping parts
- Eliminates the need for prep paste and scuff pads
- Reduces damage to new bumpers caused by abrading of plastic substrates
- Ready to use with 1 coat coverage
- Mix using the Star Shade System to get the perfect color for ideal hiding
- Quick dry time allows for fast application of topcoat color



Adhesion Primer Instructions

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!

TECHNICAL DATA (1074/1084/1094):

APPEARANCE: White, Gray, Black

% SOLIDS: 22%

SHELF LIFE: 1 year unopened

MIX RATIO: RTU

FILM BUILD: 0.2 - 0.4 mils per coat

FORCE DRYING: 5 minutes @ 120°F (49°C)

COVERAGE: 422 sq ft/gallon @ 0.5 mils

TECHNICAL DATA (1074-F/1084-F/1094-F):

APPEARANCE: White, Gray, Black

% SOLIDS: 22.5-25.5%

SHELF LIFE: 1 year unopened

MIX RATIO: RTU

FILM BUILD: 0.2 - 0.4 mils per coat

FORCE DRYING: 5 minutes @ 120°F (49°C)

COVERAGE: 450 sq ft/gallon @ 0.5 mils

SUITABLE SUBSTRATES:

RIM, TPO and Other Plastics: Prior to use in production, tests for acceptable adhesion should be carried out because of the diverse nature of plastic substrates.

SURFACE PREPARATION:

Wash with warm water & soap (silicone & oil free). Rinse with water. If water does not sheet off, wash again. Assure all silicones are removed. Clean thoroughly with plastic degreaser such as Aqua SCAT 2 1391/1394. Wipe dry with 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.

FOR OEM PRIMED BUMPER

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.

REGULATORY:

Category: Specialty Coating/ Adhesion Promoter	1074	1084	1094	1074-F	1084-F	1094-F
VOC Actual	5.38#/gal (644 g/l)	5.40#/gal (647 g/l)	5.42#/gal (649 g/l)	1.76#/gal (211 g/l)	1.65#/gal (197 g/l)	1.72#/gal (206 g/l)
VOC Regulatory	6.12#/gal (733 g/l)	6.16#/gal (738 g/l)	6.16#/gal (738 g/l)	4.45#/gal (533 g/l)	4.42#/gal (530 g/l)	4.48#/gal (537 g/l)
Weight % of Volatiles	78.05	79.58	80.97	75.94	77.15	78.3
Weight % of Water	0	0	0	0	0	0
Weight % of Exempt Compounds	10.15	10.38	10.37	53.65	55.69	56
Volume % of Exempt Compounds	12.16	12.26	12.03	60.41	62.72	61.6
Density of Material #/gal	7.92	7.81	7.67	7.91	7.68	7.71

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! 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 9500 Series Signature Series 2.1 Low VOC Sealer.

MIXING & APPLICATION:

Agitate thoroughly before use. Thinning is not necessary. Apply 1 – 2 coats (at 0.2 – 0.4 mil dry film per 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.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.4 - 1.6 mm	40 - 50 PSI	n/a
Gravity Feed	1.4 - 1.6 mm	40 - 50 PSI	n/a
HVLP/LVLP	1.2 - 1.4 mm	10 PSI max (@ aircap)	n/a

DRY TIMES:

Allow 30 minutes before topcoating.

FORCE DRYING

Allow 2-5 minute flash prior to force drying. Product can be force dried at 120°F (49°C) for 5 minutes. Allow primer to cool before application of topcoat.

TECHNICAL TIPS:

PERFORMANCE ADDITIVES

6417 Kicker – Do not use.

6737 Fisheye Remover – Do not use.

9194 Universal Urethane Flex Additive – Do not use.

OTHER RECOMMENDED SYSTEM PRODUCTS:

Aqua SCAT 2 1391/1394 must be used to insure proper adhesion when using Adhesion Primer; most other prep solvents just are not adequate to do the job.

6200 Series 2K Kwik Seal or 9500 Series Signature Series 2.1 Low VOC Sealer must be used if applying over a waterborne basecoat.

No Mix Basecoat System is a great replacement if the shop is using a waterborne basecoat.

AVAILABILITY:

1074 Adhesion Primer - White, Quart (0.946 L), 6/case

1084 Adhesion Primer - Gray, Quart (0.946 L), 6/case

1094 Adhesion Primer - Black, Quart (0.946 L), 6/case

1074-F Low VOC Adhesion Primer - White, Quart (0.946 L), 6/case

1084-F Low VOC Adhesion Primer - Gray, Quart (0.946 L), 6/case

1094-F Low VOC Adhesion Primer - Black, Quart (0.946 L), 6/case