

PRODUCT HIGHLIGHTS

1074, 1084, 1094 Adhesion Primer

DESCRIPTION:

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!

- 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



SURFACE PREP:

Clean with Aqua SCAT 2 1391/1394 and tack cloth.



MIX RATIO:

Ready to use



HVLP/LVLP:

1.2 - 1.4 mm
1 - 2 medium wet coat (0.2 - 0.4 mil per coat)
5 minute flash



DRY TIMES:

To topcoat: 30 minutes

PRODUCT DATA

1074, 1084, 1094 Adhesion Primer

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:

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 1221/1231.



APPLICATION & MIXING:

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.

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!

*Waterborne basecoats do not adhere well when applied over a 1K sealer product. We recommend the use of Transstar's 6200 Series 2K Kwik Seal or Signature Series 2.1 Low VOC Sealer 9531/9534.

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 (at aircap)	n/a

TECHNICAL DATA:

WEIGHT PER GALLON:	7.67 #/gal
% SOLIDS:	22%
COLOR:	White, Gray, Black
FILM BUILD:	0.2 – 0.4 mils per coat
FORCE DRYING:	5 minutes @ 120°F (49°C)
SHELF LIFE:	1 year
COVERAGE:	422 sq ft/ gallon @ 0.5 mils

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REGULATORY:

Category: Adhesion Promoter	1074	1084	1094
VOC Actual	5.38#/gal (644 g/l)	5.40#/gal (647 g/l)	5.42#/gal (649 g/l)
VOC Regulatory (less water, less exempt compounds)	6.12#/gal (733 g/l)	6.16#/gal (738 g/l)	6.16#/gal (738 g/l)
Weight % of Volatiles	78.05	79.58	80.97
Weight % of Water	0	0	0
Weight % of Exempt Compounds	10.15	10.38	10.37
Volume % of Exempt Compounds	12.16	12.26	12.03
Density of Material #/gal	7.92	7.81	7.67

TECHNICAL TIPS:

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.

PERFORMANCE ADDITIVES

6417 Kicker – Do not use.

6737 Fisheye Remover – Do not use.

9194 Universal Urethane Flex Additive – Do not use.

ADVANTAGES:

- 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
- Quick dry time allows for fast application of topcoat color
- 1 coat coverage
- Mix using the Star Shade System to get the perfect color for ideal hiding
- Combines adhesion promoter and primer in one step