

Bumper & Cladding Coat

3601, 3602, 3604

Adhesion Primer

Bumper & Cladding Coat Adhesion Primer is an advanced solvent-based coating designed to help your automotive base-clear topcoat system stick to unprimed TPO plastic bumpers.

Bumper & Cladding Coat Adhesion Primer sticks tenaciously to unsanded, unscuffed raw TPO plastic. Once the Adhesion Primer is dry, it can be topcoated without sanding or scuffing.

Benefits:

- Sticks to smooth or textured TPO plastics. Ideal for easy refinishing of new, unprimed OEM replacement bumpers from Toyota, Nissan, Kia, Subaru, etc.
- No sweat! Quit “sweating” your bumpers in the paint booth. No need to clean, sweat, re-clean, and so on.
- Sticks to TPO plastic without sanding or scuffing. Just clean the bumper with our 1000 Super Clean plastic cleaner and shoot the Bumper & Cladding Adhesion Primer on!
- Simple, ready-to-spray, 1K formulation means there’s no waste. What you don’t use, pour back into the can!
- Compatible with most urethane and polyester-based base-clear topcoat systems. Bumper & Cladding Adhesion Primer does not have to be scuffed or sanded prior to topcoating, and it may be topcoated at any time after application.
- A proven labor-saver since its introduction in 2003.

See SDS and product label for additional safety information. SDS, S.O.P., and technical data sheet may be downloaded at www.polyvance.com.



Customer Support:
Toll Free: 800-633-3047
Phone: 256-638-4103
www.polyvance.com



DRIES FAST AND SMOOTH!

Part Numbers

Size / Color	Light Gray	Dark gray	White
Quart	3601-4	3602-4	3604-4
Gallon	3601-1	3602-1	3604-1

Specifications

Size	Shipping Weight	Dimensions
Quart	2.1 lbs	4.2" dia x 4.8"h
Gallon	7.9 lbs	6.5" dia x 7.5"h

Properties

Recommended Nozzle Size	0.8 - 1.3 mm
Spray Temperature	50°F - 90°F
Dry Time @ 72°F (°21C)	60 min
Dry Time @130°F (54°C)	15 min
Dilution with Laquer Thinner	none
Density	7.3 lb/gal (875 g/L)
VOC	6.3 lb/gal (755 g/L)
Brookfield Viscosity	600 cps
Flash Point	>40°F (>4.4°C)
Film Build per Coat	.03-.05 mils (8 - 12 μ)

Bumper & Cladding Coat Adhesion Primer is classified as a specialty coating (elastomeric material) and is compliant under the EPA's National VOC Emission Standard.

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Application:



Step 1. Clean plastic with 1000 Super Prep or 1001 EcoPrep Plastic Cleaner. Spray on a heavy, wet coat in an area about one foot square, wait a few seconds, then wipe in one direction with a clean cloth. On raw TPO plastic surfaces, no sanding or scuffing of surface required.

If part is used, or anytime ultimate adhesion is desired, wash first with 1020 Scuff Magic Prep Soap and water using a gray scuff pad. This will clean the surface and create fine sandscratches that will further improve coating adhesion. Rinse thoroughly with water and allow to dry completely. After this, clean with 1000 Super Prep or 1001 EcoPrep as described above.



Step 2. Agitate Bumper & Cladding Coat Adhesion Primer and strain into a paint gun. No reducer or activator is required. Apply with a 0.8-1.3mm basecoat gun for fine atomization. Both ambient and surface temperatures should be between 65°F (18°C) and 95°F (35°C). Apply one or two light to medium coats using 25-35 psi at the gun to achieve hide. Do not try to flow Bumper & Cladding Coat out; it will appear slightly rough until dry. Allow five minutes of flash time between coats.

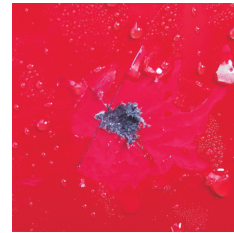
Test Results:



The paint film on the bumper can be crosshatched with a razor blade, tape tested, and pressure washed with no evidence of basecoat or primer peeling.



Step 3. Allow Bumper & Cladding Coat Adhesion Primer to dry 60 min. at 72°F (21°C) or 15 min. at 130°F (54°C). No sanding or scuffing of primer required. The primer can be topcoated at any time after it has dried completely. In other words, the “window does not close.” Apply basecoat directly over Bumper & Cladding Coat Adhesion Primer, then clearcoat. Topcoat only with approved base-clear paint system. Do NOT topcoat with catalyzed basecoats, single-stage urethane paint, 2K primer surfacers, 2K sealers, or waterbornes. Our low VOC formula has much improved topcoat compatibility for these systems.



As you can see, the pressure washer will actually drill a hole into the TPO plastic before the paint peels! This photo shows the clear coat delaminating from the basecoat, but neither the basecoat nor the primer is peeling.

WARNING: DO NOT USE CATALYZED TOPCOAT SYSTEMS!

Approved* Base-Clear Topcoat Systems:

Manufacturer	Brand	Description	Approved
Akzo Nobel	Lesonal	1K Basecoat	YES
Akzo Nobel	Sikkens	Autobase	YES
Akzo Nobel	Sikkens	Autowave (waterborne)	YES
BASF	Glasurit	Series 55 polyester basecoat	YES
BASF	Glasurit	Series 90 Waterborne	NO
BASF	Limco	Supreme Acrylic Enamel basecoat	YES
BASF	R-M	Diamont polyester basecoat	YES
BASF	R-M	Onyx HD Waterborne basecoat	NO
Axalta	Axalta	Cromax Pro Waterborne basecoat	NO
Axalta	Axalta	ChromaBase	YES
Axalta	Axalta	ChromaPremier	YES
Axalta	Nason	Ful-Base base-clear system	NO
Axalta	Spies Hecker	Permahyd Waterborne Series 280	NO
Axalta	Spies Hecker	Permacron Solvent-based Series 293	YES
Axalta	Standex	Basecoat MSB System	YES
Nexa	Autocolor	Aquabase Plus	YES
PPG	Envirobase	Waterborne basecoat	YES
PPG	ICI/Nexa	Autocolor 2K Base/Clear	YES
PPG	Omni	Omni AU	YES
PPG	PPG	Deltron 2000 DBC	YES
PPG	PPG	Deltron DBU w/ reactive reducer	YES
PPG	PPG	Global BC	YES
Sherwin-Williams	AWX	Waterborne basecoat	NO
Sherwin-Williams	Martin Senour	Tec/Base	YES
Sherwin-Williams	Sherwin-Williams	Ultra 7000	YES
Valspar	De Beer	Waterbase 900 series	YES

* If your paint system is not on this list, please call 800-633-3047 or visit www.polyvance.com for the latest compatibility information.

Technical Information:

Compatible Substrates:

Bumper & Cladding Coat Adhesion Primer is optimized for adhesion to TPO (TEO, PP blend) plastics. Bumper & Cladding coat may be sprayed on TPO plastic surfaces without first sanding or scuffing the surface.

Bumper & Cladding Coat Adhesion Primer is not recommended over other substrates such as raw polyurethane (PUR) or OEM primed bumpers. Bumper & Cladding Coat Adhesion Primer has adequate adhesion to these substrates only if they are scuffed or sanded and the adhesion will only be comparable to other primers. Polyvance will guarantee adhesion only to raw TPO.

Compatible Topcoats:

Bumper & Cladding Coat Adhesion Primer may be topcoated with one of the approved base/clear refinishing systems listed here. We recommend that the basecoat be sprayed directly over the Bumper & Cladding Coat. It may *not* be topcoated with any catalyzed basecoat, 2K primer surfacer, 2K sealer, or single stage urethane topcoat system. These topcoats will break down the Bumper & Cladding Coat's adhesive qualities.

Additional Notes:

- Bumper & Cladding Coat Adhesion Primer is ready to spray, but it may be thinned if needed with lacquer thinner (up to 5% by volume).
- The highest quality control measures are taken during the production of Bumper & Cladding Coat Adhesion Primer. However, it is highly recommended a 25 micron filter be used to filter the paint immediately before use.