

# Bumper & Cladding Coat p/n: 3611, 3612, 3613

Low VOC Adhesion Primer for raw TPO, PP and TEO plastics.

**Bumper & Cladding Coat Adhesion Primer** is an advanced, low-VOC, solvent-based, non-sandable primer that is designed to stick to “problem plastics” like TEO, TPO and PP without sanding or pretreatment. Bumper and Cladding Coat Adhesion Primer may be topcoated with most solvent or waterborne base/clear topcoats and single stage systems without sanding. The low VOC formula sprays smoother and has improved topcoat compatibility over the previous formula. There is no close on the window for topcoating, plus the lower VOCs means its legal in all 50 states and Canada. For the most up to date compatibility chart, visit [www.polyvance.com](http://www.polyvance.com).



## Benefits:

- Sticks to smooth or textured TPO, TEO, and Polypropylene plastics. Ideal for easy refinishing of new, unprimed OEM replacement bumpers.
- Quit “sweating” your bumpers in the paint booth. No need to clean, sand, sweat, re-clean, and so on.
- Sticks to TPO, TEO, and PP plastic without sanding or scuffing. Just clean the bumper with our 1000 Super Prep or 1001 LOW VOC Eco-Prep plastic cleaner then spray on the Bumper & Cladding Adhesion Primer!
- Simple, ready-to-spray, 1K formulation means there’s no waste. What you don’t use, pour back into the can!
- Compatible with all urethane and polyester-based base-clear topcoat systems and most 2K products as well. 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.
- Mix shades to match desired tint to reduce the amount of topcoat required to achieve hide and improve the final color match.

**VOCs: 2.09 lb/gal (250 g/L)**

## Part Numbers:

	Gallon	Quart
Light Gray	3611-1	3611-4
Dark Gray	3612-1	3612-4
White	3613-1	3613-4



Customer Support:  
Toll Free: 800-633-3047  
Phone: 256-638-4103  
[www.polyvance.com](http://www.polyvance.com)



## Directions for Use:

**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, TEO, and PP plastic surfaces, no sanding or scuffing of surface required.

If part is used, painted or anytime ultimate adhesion is desired, wash first with 1020 Scuff Magic Prep Soap and water using a red or 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, then clean with plastic cleaner as described above.

**Step 2.** Agitate Bumper and Cladding Coat Adhesion Primer and strain into paint gun, no reducer or activator is required. Apply with a 0.8-1.4mm basecoat gun for fine atomization. Both ambient and surface temperatures should be between 60°F (15°C) and 95°F (35°C). Apply one or two coats 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.

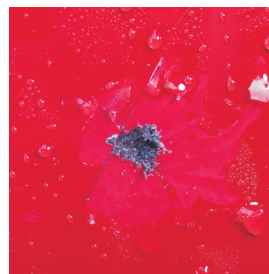
**Step 3.** Allow Bumper and Cladding Coat Adhesion Primer to dry 60 min. at 72°F (21°C) or 15 min. at 130°F (54°C) before topcoating. No sanding or scuffing of primer required. The primer can be topcoated at any time after it has dried completely. In other words, the “window does not close.”

Apply basecoat directly over Bumper & Cladding Coat Adhesion Primer, then clearcoat. Topcoat only with approved paint systems.

## Test Results:



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



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.

## Technical Information:

### Compatible Substrates:

Bumper & Cladding Coat Adhesion Primer is optimized for adhesion to TPO, TEO, and PP plastics. Bumper & Cladding coat may be sprayed on TPO, TEO and PP plastic surfaces without 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 will have adequate adhesion to these substrates as long as they are scuffed or sanded, but it will offer no particular advantage over any other type of primer or sealer in such an application. Polyvance will not guarantee adhesion to any substrate other than raw TPO, TEO, or PP.

### Compatible Topcoats:

Bumper & Cladding Coat 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. Topcoat with approved paints only.

### Additional Notes:

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

### VOCs:

VOCs (ready to spray) 2.09 lb/U.S. gal (250 g/L)

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

### Test Properties:

Brookfield Viscosity	600 cps
Flash Point	> 40°F (>4.4°C)
Film Build Per Coat	0.3 - 0.5 mils (8 - 12 µ)
Specific Gravity	1.092

See MSDS and product label for additional safety information. MSDS and technical data sheet may be downloaded from [www.polyvance.com](http://www.polyvance.com). Emergency medical or spill control information: 800-424-9300 or 703-527-3887.

## Approved Base-Clear Topcoat Systems:

Manufacturer	Brand	Description	Approved
Akzo Nobel	Lesonal	1K Basecoat	<b>YES</b>
Akzo Nobel	Sikkens	Autobase	<b>YES</b>
Akzo Nobel	Sikkens	Autowave (waterborne)	<b>YES</b>
BASF	Glasurit	Series 55 polyester basecoat	<b>YES</b>
BASF	Glasurit	Series 90 Waterborne	<b>YES</b>
BASF	Limco	Supreme Acrylic Enamel basecoat	<b>YES</b>
BASF	R-M	Diamond polyester basecoat	<b>YES</b>
BASF	R-M	Onyx HD Waterborne basecoat	<b>YES</b>
DuPont	DuPont	Cromax Pro Waterborne basecoat	<b>YES</b>
DuPont	DuPont	ChromaBase	<b>YES</b>
DuPont	DuPont	ChromaPremier	<b>YES</b>
DuPont	Nason	Ful-Base base-clear system	<b>YES</b>
DuPont	Spies Hecker	Permahyd Waterborne Series 280	<b>YES</b>
DuPont	Spies Hecker	Permacron Solvent-based Series 293	<b>YES</b>
DuPont	Standox	Basecoat MSB System	<b>YES</b>
Nexa	Autocolor	Aquabase Plus	<b>YES</b>
PPG	Envirobase	Waterborne basecoat	<b>YES</b>
PPG	ICI/Nexa	Autocolor 2K Base/Clear	<b>YES</b>
PPG	Omni	Omni AU	<b>YES</b>
PPG	PPG	Deltron 2000 DBC	<b>YES</b>
PPG	PPG	Deltron DBU w/ reactive reducer	<b>YES</b>
PPG	PPG	Global BC	<b>YES</b>
Sherwin-Williams	AWX	Waterborne basecoat	<b>YES</b>
Sherwin-Williams	Martin Senour	Tec/Base	<b>YES</b>
Sherwin-Williams	Sherwin-Williams	Ultra 7000	<b>YES</b>
Valspar	De Beer	Waterbase 900 series	<b>YES</b>

If your paint system is not on this list, please call 800-633-3047 or visit [www.polyvance.com](http://www.polyvance.com) for the latest compatibility information.