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## Prime Adhesion Promoter - Tech Sheet

# 350 - G/Q

Introducing the 350 solvent based adhesion promoter for all types of plastics ( rigid and flexible ), metals including aluminum, stainless steel, Non Ferris metals, fiberglass, glass, chrome, vinyl, E-Coat substrates, galvanized metals and painted surfaces. The 350 acts as a bonding coat by allowing several different surfaces to be painted at the same time to assure a smooth and durable finish. If the 350 is added to the paint, it will perform as a flex agent, promoting more flexibility on plastic surfaces.



### Features and Benefits

- Provides superior adhesion.
- Single component, ready to spray
- Dries clear in 5 minutes
- Unused product can be used again
- Improves flake orientation & color consistency
- Improves melt-in and edge wetting
- Tint with basecoat for visible color coverage

### Reducer

Not Recommended

### Compatible Substrates

All common automotive plastics as wells a metals, glass, alluminum, fiberglass, rubber, vinyl and painted surfaces. The 350 is suitable for ground effects, new flexible and rigid bumpers,as well as plastic and interior exterior parts. Compatible coatings include solvent based urethane,epoxy or acrylic laquers, primers, sealers and basecoats.

### Hardeners

Do not use Hardener in the 350. Not Recommended

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### Preparations for Plastics:



1. Clean all areas to be painted with 350 Adhesion Promoter. Sand and clean using a gray scuff pad.
2. Rinse thoroughly with clean water and blow dry the surface and Tack cloth. Do not press tack cloth firmly against surface due to cloth flint may transfer to bumper causing defects.
3. If noticeable static remains on surface after blow drying and tacking, please use a waterbased Anti-Static cleaner as a final wipe by spraying surface or pour on clean towel. Allow 3-5 minutes flash time before proceeding to next step.
4. Shake well and filter before each use to secure a uniform mixture. Apply a single, medium closed coat of 350 Adhesion Promoter over entire plastic surface. A properly applied film should appear uniform, continuous and free of any voids.
5. Allow 5 - 10 minute before applying the next coating or when tack free. Dry times may vary based on temperature and humidity.
6. Once tack free, you may proceed with normal basecoat/clearcoat process.

### Preparations for Pre - Painted Metal Surfaces :



1. Remove all contaminants from the surface with a high grade quality wax & grease remover.
2. If the painted surface has been broken through to metal, the apply a corrosion inhibitor or or self etch-primer, following that manufactures instructions for application and dry times. DO NOT use 350 Adhesion Promoter on Bare Metal.
3. Clean all areas to be painted with 350 Adhesion Promoter. Sand and clean using a gray scuff pad. Rinse well with clean water and blow dry the surface.
4. Tack dry surface thoroughly with a clean tack cloth. Do not press tack cloth firmly against surface due to cloth flint may transfer to surface causing defects.
5. If noticeable static remains on surface after blow drying and tacking, please use a waterbased Anti-Static cleaner as a final wipe by spraying surface or pour on clean towel. Allow 3-5 minutes flash time before proceeding to next step.
6. Shake well and filter before each use to secure a uniform mixture. Apply a single, medium closed coat of 350 Adhesion Promoter over entire plastic surface. A properly applied film should appear uniform, continuous and free of any voids.
7. Allow 5 - 10 minute before applying the next coating or when tack free. Dry times may vary based on temperature and humidity.
8. Once tack free, you may proceed with normal basecoat/clearcoat process.

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### Air Pressure & Gun Setup



HVLP	8 -15 psi at the air cap
Compliant	29 - 45 psi at the gun
Gun Setup	1.2 - 1.5 mm or equivalent
Approx. Distance	5" - 7"
Inlet PSI	16 - 22 psi

### Application



Apply	1 Medium Closed Coat
Total Recommended Dry Film :	1 coat at 0.2 - 0.4 mils



Dry times at 70°F (21°C) 5 - 10 Minutes depending on temperature **DO NOT Force Dry**



### Recoat

TopCoat 350 Adhesion Promoter within 1 hour, avoid heavy or multiple coats, which can cause wrinkling issues when applying your basecoat. Re-apply another light coat after 1 hour before applying topcoat.

### Tinting and Flex Agent Usage :

Tinting with Basecoat :	Mix 90 % of 350 Adhesion Promoter with 10 % Basecoat for visible color coverage
Flex Agent Basecoat :	Mix 1 part of 350 adhesion Promoter with 4 parts Basecoat
Flex Agent ClearCoat:	Mix 1 part of 350 adhesion Promoter with 3 parts catalyzed ClearCoat

### Additional Usage and Instructions :

- 350 Adhesion Promoter can be used as a mid-coat adhesion promoter, essentially tying & bonding multiple layers of paint together such as paint effects, flames and 2-tones.
- 350 Adhesion Promoter CANNOT be mixed with waterborne paint. 350 can be used in a waterborne system, as long as it is applied underneath the primer / sealer.
- Treat and prepare bare metal to prevent corrosion. Bare metal and body fillers must be primed and dry or wet sanded with 400 grit sandpaper prior to applying the 350 Adhesion Promoter.
- 350 can be used on interior parts, such as dashboards, kick panels, visors and other plastic interior parts prior to dyeing or painting. Solvent based dyes can be mixed with the 350 up to 50% before application.
- 350 should not be used on Lexan or polyethylene surfaces.

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### Technical Information:

Mixing Ratio:	Ready to Spray
Weight Solids (RTS):	16 %
Film Build:	0.2 - 0.4 mils per full coat
VOC as Mixed	4.5 lbs per gal
Color	Clear

see SDS for this product

### Disposal/Safety:

FOR INDUSTRY USE ONLY

Read SDS Before Use

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.

The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.