







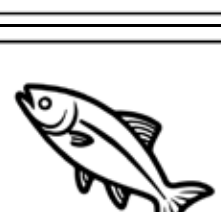


## Technical Data Sheet

# ADHESION PROMOTER

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|    | <p><b>Description</b></p> <p>70031 ADHESION PROMOTER 1GL.<br/>70034 ADHESION PROMOTER 1QT.</p> <p>Hoseki Adhesion Promoter greatly enhances the adhesion and durability of virtually all types of automotive finishes and a variety of substrates; including problem plastics, such as TPO and polypropylene. It can be used under primers on flexible and rigid plastic parts, as a tie-coat between fresh or existing primer and color (single stage or base-coat), and for painting aluminum or steel.</p>  |
|  | <p><b>Surface Preparation</b></p> <p><i>Plastic Parts:</i> Clean parts thoroughly using a plastic cleaner or scuff paste with a scuff pad to enhance the performance of the repair material. Rinse with water and wipe dry with a clean cloth.</p> <p><i>Over Fresh, Aged Primer, or Existing Finishes:</i> Sand primer with 400-500 grit paper by hand block or with a DA. Clean parts thoroughly using a quality degreaser or Wax &amp; Grease Remover.</p> <p><i>Note on Plastics:</i> Due to the diverse nature of plastics, always test the plastic substrate for acceptable adhesion</p> |
|  | <p><b>Mixing Directions</b></p> <p>This product is supplied completely ready to use. No reduction or activation is required</p>  |

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|    | <p><b>Application</b></p> <p>Gun Setup: Equip your spray gun with the appropriate fluid tip and adjust your pressures according to the following specifications: HVLP / LVLP: 1.2-1.5 mm fluid tip   10 PSI at the aircap. Gravity Feed: 1.2-1.4 mm fluid tip   25-35 PSI at the regulator. Siphon Feed: 1.2-1.6 mm fluid tip   35-45 PSI at the gun. Pressure Feed: 1.0-1.2 mm fluid tip   40-50 PSI at the gun (Set fluid pressure to 8-10 PSI).</p>   |
|    | <p><i>For Plastic Parts:</i> Apply 1 medium coat. Allow a 20-30 minute flash before topcoating or priming. Apply primer, color, or clearcoat directly to the adhesion promoter.</p> <p><i>Over Fresh, Aged Primer, or Existing Finishes:</i> Apply 1 medium coat. (Note: Apply 2 medium coats with a 5-10 minute flash if using over polyester primer). Allow a 20-30 minute flash before topcoating or priming.</p> <p><i>For Aluminum or Steel:</i> Apply 2 coats, allowing a 5-10 minute flash between coats. Allow to dry for a minimum of 20-30 minutes before topcoating.</p> <p><i>(Note: Allowing more than 30 minutes will greatly improve adhesion properties, and it can be recoated up to 24 hours from application)</i></p> |
|    | <p><b>Dry Time</b></p> <p><i>Flash Time (Between Coats):</i> 5-10 minutes.</p> <p><i>Time to Prime / Topcoat:</i> 20-30 minutes</p>  |
|   | <p><b>Pot Life</b></p> <p>N/A</p>  |
|  | <p><b>Suitable Substrates</b></p> <p>Raw plastic (rigid SMC/BMC, flex ABD/PPO, soft PUR).</p> <p>Primed plastic parts.</p> <p>1K, 2K, and self-etching primers.</p> <p>Body filler.</p> <p>OEM finishes and old paint work.</p> <p>Bare steel and bare aluminum.</p> <p>Fiberglass / SMC gel coat</p>  |
|  | <p><b>Additives</b></p> <p>Caution: The use of additives such as accelerators is strongly discouraged.</p>   |



### Personal Protection

For use only by professional, trained painters. Not for sale to or use by the general public. Before use, read and follow all TDS, label, and Safety Data Sheet (SDS) precautions. This product contains hazardous materials and must be used with appropriate personal protective equipment (PPE), including a NIOSH-approved respirator, safety glasses, and chemical-resistant gloves. If mixed with other components, the resulting mixture will have the hazards of all combined components. Ensure adequate ventilation during mixing, application, and curing processes.



### Technical Data

Color: Amber.  
Shelf Life: 3 years.  
Mix Ratio: Ready to Use.  
Weight % of Volatiles: 88.29%.  
Weight % of Water: 0%.  
Actual VOC: 4.78 lbs./gal. (573 g/L) .  
Regulatory VOC: 6.58 lbs./gal. (788 g/L) .  
Density: 7.29 lbs./gal..  
Product Category: Adhesion Promoter