



Axalta™ Plastic Polyolefin Adhesion Promoter Low VOC 305



GENERAL

DESCRIPTION

Axalta™ Plastic Polyolefin Adhesion Promoter Low VOC 305 is a universal, one component adhesion promoter for all normal plastic vehicle parts. For use in areas requiring plastic primers with a VOC of 540 g/l.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Axalta™ Plastic Polyolefin Adhesion Promoter Low VOC 305

MIX RATIO

Ready-to-spray

APPLICATION VISCOSITY

Approximately 12 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 8 hours at 68°F/20°C

SPECIAL TIPS

- Shake thoroughly before use
- Axalta™ Plastic Polyolefin Adhesion Promoter 305 must be thoroughly dry before undercoat application (See Dry Times).
- Plastic parts repaired with Axalta™ Plastic Polyolefin Adhesion Promoter 305 may not be washed with a high pressure jet within six weeks of the repair. After this period, the nozzle must be held at a distance of no less than 12 inches from the object.
- Do not apply topcoat directly to Axalta™ Plastic Polyolefin Adhesion Promoter 305.



APPLICATION

SUBSTRATES

All raw plastic parts commonly found on vehicle exteriors (Examples: PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, UP-GF).

Not recommended for pre painted substrates.

SURFACE PREPARATION

Primed Plastic

Perform a solvent test to check if the plastic primer is reversible.

a: **If compliant** in your area, apply solvent to a rag and rub the surface to ensure no color comes off.

b: If color comes off, the primer is reversible

1. If the primer is reversible, then strip and treat as raw plastic.



2. If the primer is not reversible,
 - a. Wash with soap and water, clean all substrates thoroughly with Axalta™ Silicone Remover 200 Slow, Axalta™ Silicone Remover 210 Water or Axalta™ Silicone Remover 220 Low VOC.
 - b. Sand the primer (P600 when dry sanding or with P800 when wet sanding). Make sure to scuff all of the edges and hard to reach areas with a fine scuff pad.
 - c. Re-clean with Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 210 Water or Axalta™ Silicone Remover 220 Low VOC.
 - d. Recoat with adhesion promoter on any cut-throughs, then an appropriate filler, surfacer and/or sealer from Cromax®, Spies Hecker®, or Standox®. Consult undercoat TDS for elastic recommendation.

Raw Plastic

1. Refer to Axalta™ Plastic Cleaning Paste 265 TDS for cleaning instructions.
2. Apply Axalta™ Plastic Polyolefin Adhesion Promoter 300 as per below and recoat with an appropriate 2K filler, 2K surfacer and/or sealer from Cromax®, Spies Hecker®, or Standox®. Consult undercoat TDS for elastic recommendation.

SPRAYGUN SETUP

HVLP	1.3-1.4mm
*Approved Transfer Efficiency	1.2-1.3mm

*Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

1. Apply one tack coat immediately followed by a thin/light closed coat to achieve .5 mils
2. Do not spray to hiding
3. Avoid multiple coats and excessive film build

RECOMMENDED FILM THICKNESS

Approximately 0.5 mil dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C: Approximately 15-30 minutes

RECOAT: NOT REQUIRED

OVERCOAT: With appropriate filler, surfacer and/or sealer from Cromax®, Spies Hecker®, or Standox® within 16 hours. Consult undercoat TDS for elastic recommendation.

TOPCOAT: Do not apply topcoat directly over Axalta™ Plastic Polyolefin Adhesion Promoter 300



PHYSICAL PROPERTIES

Coating Category: Specialty Coating
 Max. VOC (AP): 265 g/l; 2.2 lbs/gal
 Max. VOC (LE): 520 g/l; 4.3 lbs/gal
 Avg. Gallon Weight: 1156.3 g/l; 9.65 lbs/gal
 Avg. Weight % Volatiles: 78.8 %
 Avg. Weight % Water: 0.0%
 Avg. Weight % Exempt Solvent: 55.8%
 Avg. Volume % Water: 0.0%
 Avg. Volume % Exempt Solvent: 49.0%



Theoretical Coverage: 329.5 sq. ft. @ 1 mil

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

Revised: June 2021

In the United States:
1.855.6.AXALTA
axalta.us

In Canada:
1.800.668.6945
axalta.ca

