

Excel Autobody Products™

ADHESION PROMOTER

#12301 (Gallon)

#12304 (Quart)

#12316 (Aerosol)

Excel Adhesion Promoter is a clear adhesion promoter for polyolefin or non-polyolefin unprimed automotive plastic parts. When combined with the proper surface preparation, this product enhances the adhesion performance of basecoat and single stage finishes on unprimed automotive plastic parts. It is recommended to prime or seal #12301 prior to top coating for optimum flexibility.

Application

Surface Preparation

Wash the area thoroughly with soap and water to remove contaminants that solvent-based cleaners cannot remove effectively. Clean area with a good grade wax and grease remover such as #91001 and wipe dry with a clean cloth. Once properly cleaned, the plastic part should not have any gloss and should not feel slick. If it does, re-clean with wax and grease remover. Completely sand surface with 1200 grit or finer sandpaper and re-clean with wax and grease remover to remove sanding residue. Wipe area with tack cloth to remove any dust or dirt particles.

Mixing Directions

Ready to Spray.

Application

Apply one medium coat of #12301 immediately after cleaning the plastic with wax and grease remover. Allow #12301 to air dry 20 - 30 minutes before applying sealer. Follow sealer manufacturer's application and dry instructions. Topcoat with basecoat/clear coat, or single stage finishes as instructed by manufacturers technical data sheets. Note: For difficult to clean and textured plastics, temper the substrate for 30 minutes at 140°F after cleaning and sanding. This may be helpful in driving out further mold release agents. Do not sand after tempering. Use 30 - 45 psi at the gun or 6-10 psi at the cap when using an HVLP gun. The surface should have a wet and uniform finish. Allow #12301 to dry 20 - 30 minutes before top coating. Do not apply over body filler or lacquer based products.

Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature.

Air Dry @ 77°F to topcoat

Flash Time 20 - 30 mins

Force Dry

140°F 15 mins

Accelerator

Do not use accelerator in this product.

Fish Eye Eliminator

Do not use fish eye eliminator in this product.

Repairing & Recoating

#12301 may be recoated at any stage of dry or cure. Avoid multiple coats and excessive film build.



Technical Data

Weight Solids		Mixing Ratio	None or up to 2/1
Package	13.7%	Pot life	Indefinite
		Viscosity @ Gun	19 - 24 #2 Zahn
Volume Solids		Recommended Film Thickness	.25 - .50 mil
Package	10.4%	Flash Point	72° FTCC
		Air Pressure @ Gun	45-50 psi
Coverage @ 0.2 mil	230 sq ft/g	VOC @ Gun	6.2 lb/g,

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