



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

1. Axalta Plastic Polyolefin Adhesion Promoter Low VOC 305 must be thoroughly dry before undercoat application (See Dry Times).
2. For raw plastic prep, do not allow Axalta™ Plastic Cleaning Paste 265 to dry on the surface of the plastic substrate.
3. Thoroughly clean and scuff all surfaces of the plastic part, paying special attention to all edges.
4. Axalta™ Plastic Cleaning Paste 265 is designed for raw plastic and is not suitable for cleaning painted surfaces.
5. Always use a clean scuff pad.
6. Soft plastic may require a finer scuff pad.
7. Difficult to clean plastics may need to be cleaned more times, or if applicable the plastic may be baked for a minimum of 15 minutes at 140°F (60°C). Some OEM plastic bumpers do not recommend a bake cycle. Once the plastic has cooled, repeat the procedure below for preparing raw plastics beginning with step 2.
8. Plastic parts repaired with Axalta™ Plastic Polyolefin Adhesion Promoter Low VOC 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.

In the United States:
1.855.6.AXALTA
 axalta.us

In Canada:
1.800.668.6945
 axalta.ca





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 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 (P500-800 when dry sanding or with P600-800 when wet sanding). Make sure to scuff all of the edges and hard to reach areas with a gray or gold scotch 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

The substrate must be free from release agents.

1. Rinse the raw plastic part thoroughly with water and pre-clean it using Axalta 265 Plastic Cleaning Paste and a clean gold scuff pad.
2. Continue to clean the raw plastic part another 2 to 3 times using new Axalta 265 Plastic Cleaning Paste and a clean gold scuff pad.
3. Remove all Axalta 265 Plastic Cleaning Paste residue from the plastic by thoroughly rinsing with clean water.
4. Before further treatment, clean the plastic substrate thoroughly with Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.
5. **Axalta™ Plastic Polyolefin Adhesion Promoter Low VOC 305** as per below and recoat with an appropriate filler, 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

- Apply 1.5 coats.

RECOMMENDED FILM THICKNESS

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Approximately 0.15 mil dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C:

Approximately 15-30 minutes

RECOAT

With appropriate filler, surfacer and/or sealer from Cromax[®], Spies Hecker[®], or Standox[®]. Consult undercoat TDS for elastic recommendation.



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,

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Revised: February 2021

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