

# 491-50™ Plastic Adhesion Promoter



## GENERAL

### DESCRIPTION

A clear adhesion promoter formulated to enhance the adhesion of Nason® products on unprimed polyolefin or non-polyolefin unprimed plastic parts.

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



## MIXING

### COMPONENTS

Nason® 491-50™ Plastic Adhesion Promoter

### MIX RATIO

Ready to Spray. Shake well prior to use

### POT LIFE

Indefinite

### ADDITIVES

None recommended



## APPLICATION

### SUBSTRATES

Unprimed automotive plastic parts

### TOPCOATS

Must be primed or sealed prior to application of topcoat.

### SURFACE PREPARATION AND PAINTING

1. Clean the unprimed plastic surface with mild soap and hot water.
2. Rinse thoroughly with hot water.
3. Liberally apply 441-75™ Plastic Cleaner to the unprimed plastic surface. Using a saturated lint free cloth to wipe the surface works well. Use a clean dry cloth to dry the surface. When complete, the surface should have no gloss and not feel slick. If the surface has gloss or feels slick, repeat the step.
4. Sand the surface thoroughly. Using one of these options:
  - a) Hand sand using a gray or gold Scotch-Brite™ or 800 grit sandpaper.
  - b) DA sand with 500 grit paper.
5. Clean again with 441-75™ per step 3. The surface must be clean before moving to the next step.
6. Apply one medium coat of Nason® 491-50™ Plastic Adhesion Promoter.
7. Allow Nason® 491-50™ Plastic Adhesion Promoter to flash 30minutes before applying primer or sealer.
8. Apply primer or sealer.
9. Apply Nason® topcoat.

### GUN SETUP

#### Compliant

Siphon Feed:	1.4-1.6 mm
Gravity Feed:	1.3-1.6 mm

#### HVLP

Siphon Feed:	1.6-1.8 mm
Gravity Feed:	1.3-1.4 mm

### SPRAY PRESSURE

#### Compliant

Siphon Feed:	35-40 psi
Gravity Feed:	30-35 psi at the gun

#### HVLP

Siphon Feed:	6-8 psi at the gun cap
Gravity Feed:	6-8 psi at the gun cap

### APPLICATION

Spray one medium wet coat.

### CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with lacquer thinner or Low VOC Gun & Equipment Cleaner in VOC regulated markets.



### DRY TIMES

#### AIR DRY

To prime or seal:	30 minutes at 70-80°F (21-27°C)
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#### TIPS FOR SUCCESS

Nason® 491-50™ Plastic Adhesion Promoter must be primed or sealed within 24 hours to ensure proper adhesion.



### PHYSICAL PROPERTIES

#### All Values Ready To Spray

Max. VOC (LE):	536 g/L (4.5 lbs./gal)
Max. VOC (AP):	261 g/L (2.2 lbs./gal)
Avg. Gal. Wt.:	1135 g/L (9.47 lbs./gal)
Avg. Wt.% Volatiles:	82.0%
Avg. Wt.% Exempt Solvent:	59.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	51.2%
Avg. Vol.% Water:	0.0%
Recommended Dry Film Thickness:	0.8-1.2 mils
Flash Point:	See SDS/MSDS
Theoretical Coverage, RTS:	303 ft <sup>2</sup> (31.9 m <sup>2</sup> ) at 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.

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## 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/MSDS 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.

**Revised: December 2014**

In the United States:  
**1.855.6.AXALTA**  
**nasonfinishes.com**

In Canada:  
**1.800.668.6945**  
**nasonfinishes.ca**

