



Permasolid® Elastic Adhesion Promoter 3302



GENERAL

DESCRIPTION

A universal, 2K urethane adhesion promoter that works with Permasolid® Elastic Adhesion Additive 3303 to provide great adhesion to all OEM plastic vehicle parts.

This easy-to-apply, economical, 540 g/l VOC complaint, and productive adhesion promoter can be recoated directly with Permahyd® Hi-TEC 480 or Permacron® Base Coat Series 293/295. Permasolid® Elastic Adhesion Promoter 3302 is available in white and black.

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



MIXING

COMPONENTS

Permasolid® Elastic Adhesion Promoter 3302

PERMASOLID LOW VOC HARDENERS

Permasolid® Low VOC Hardener 3192 Fast, Permasolid® Low VOC Hardener 3194 Medium, or Permasolid® Low VOC Hardener 3196 Slow

For optimum hardener selection, refer to TDS # 062.

ADDITIVES

Permasolid® Surfacer Additive 5409
Permasolid® Surfacer Additive 5410 Slow

For optimum additive selection, refer to TDS # 780.0.

MIX RATIO

Component	Volume
3302	4
3192 / 3194 / 3196	1
5409 / 5410	+15%
3303	+15%

Mixing Chart

Colors	White		Black	
Individual Weights (In grams)				
Pour Size	Half Liter	Liter	Half Liter	Liter
3302	480.3	960.5	435.4	870.9
Low VOC Hardeners	84.5	169.0	84.5	169.0
5409	67.2	134.4	67.2	134.5
or	or	or	or	or
5410	62.1	124.3	62.1	124.3
3303	54.4	108.8	54.4	108.9



APPLICATION VISCOSITY

Approximately 14 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 45 minutes at 68°F/20°C

SPECIAL TIPS

1. Do not allow Permahyd® Plastic Cleaning Paste 7081 to dry on the surface of the plastic substrate.
2. Thoroughly clean and scuff all surfaces of the plastic part, paying special attention to all edges.
3. For hard to reach areas of the plastic part, use the application brush that is included with the Permahyd® Plastic Cleaning Paste 7081.
4. Permahyd® Plastic Cleaning Paste 7081 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. **Aftermarket Parts - repair raw parts with Priomat® Elastic Primer 4190 Gray or Priomat® Elastic Primer 3304 (Spray Can) and recoat with elastic Permasolid® Spectro Sealer 5450.**
9. Permasolid® Elastic Additive 9050 is not necessary when using Permasolid® Elastic Adhesion Promoter 3302.
10. When using ColorNet®, Permasolid® Elastic Adhesion Promoter 3302 can also be easily mixed by weight on the scale.
11. To avoid trapping solvents, follow the recommended flash-off time for Permasolid® Elastic Adhesion Promoter 3302.
12. Minimum 20 minutes and maximum 8 hours recoat time.
13. All products must be stored above 60°F/15°C.
14. Plastic parts repaired with Permasolid® Elastic Adhesion Promoter 3302 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.



APPLICATION

SUBSTRATES

All raw plastic parts commonly found on vehicle exteriors (Examples: ABS, PC, OEM PP, R-TPU, TPO).

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 with Permaloid® Silicone Remover 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096. Sand primer (with 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.
 - b. Re-clean with Permaloid® Silicone Remover 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.



- c. Recoat with an elastic Permasolid® Surfacer or Sealer.

Raw Plastic

The substrate must be free from release agents.

1. Rinse the raw plastic part thoroughly with water and pre-clean it using Permahyd® Plastic Cleaning Paste 7081 and a clean gold scuff pad.
2. Continue to clean the raw plastic part another 2 to 3 times using new Permahyd® Plastic Cleaning Paste 7081 and a clean gold scuff pad. The supplied brush should be used with Permahyd® Plastic Cleaning Paste 7081 in hard to reach areas of the plastic part.
3. Remove all Permahyd® Plastic Cleaning Paste 7081 residue from the plastic by thoroughly rinsing with clean water.
4. Before further treatment, clean the plastic substrate thoroughly with Permaloid® Silicone Remover 7010 Slow, Permahyd® Silicone Remover 7085, or Permahyd® Silicone Remover 7096.
5. Apply Permasolid® Elastic Adhesion Promoter 3302 as per below and recoat with Permacron® Base Coat Series 293/295 or Permahyd® Hi-TEC 480.

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 1-1.5 coats.

RECOMMENDED FILM THICKNESS

Approximately 0.8-1.0 mil dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C: 20 minutes or max. 8 hours

RECOAT

With Permacron® Base Coat Series 293/295 or Permahyd® Hi-TEC 480



PHYSICAL PROPERTIES

Coating Category: Adhesion Promoter

- Max. VOC (AP): 204 g/l; 1.7 lbs/gal
- Max. VOC (LE): 324 g/l; 2.7 lbs/gal
- Avg. Gallon Weight: 1452.9 g/l; 12.12 lbs/gal
- Avg. Weight % Volatiles: 46.6 %
- Avg. Weight % Water: 0.0%
- Avg. Weight % Exempt Solvent: 32.3%
- Avg. Volume % Water: 0.0%
- Avg. Volume % Exempt Solvent: 35.6%

Theoretical Coverage: 651 sq. ft. @ 1 mil
 Theoretical Coverage @ Recommended Film Build: 651 - 814 sq. ft.



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 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.

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