

# Technical Data Sheet

Transtar's Mul-TIE Adhesion Promoter greatly enhances the adhesion and durability of virtually all types of automotive finishes and a variety of substrates; including problem plastics, such as TPO and polypropylene. Mul-TIE can be used under primers on flexible and rigid plastic parts, as a tie-coat between fresh or existing primer and color (single stage or basecoat) and for painting aluminum or steel.

## SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Bare Steel	✓	Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching	✓
Bare Galvanized		Raw Plastic - Flexible (ABD, PPO) +	✓	Primer - 1K	✓
Bare Aluminum	✓	Raw Plastic - Soft (PUR) +	✓	Primer - 2K	✓
OEM E-Coat**		Plastic Part - Primed ++	✓	OEM Finish & Old Paint Work - Reversible	
Fiberglass/SMC Gel Coat	✓	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible	✓

\*\* Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

## MIXING



By Volume: Ready to Spray

## FLASH TIMES/DRY TIMES



Flash between coats: 5-10 minutes between coats  
To prime/topcoat: 20-30 minutes

## SURFACE PREPARATION



Clean with SCAT 6311, Speedi SCAT 6321, Aqua SCAT 2 1391/1394 or Scuff & Prep Paste 6338 with a scuff pad.

\* For more information on surface prep and application refer to next page.

## SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.2 - 1.6	1.2 - 1.4
Air Pressure	10 PSI @ aircap	25 - 35 PSI @ regulator

## LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.2 - 1.6	1.2 - 1.4	1.0 - 1.2	1.2 - 1.5 mm
Air Pressure	35 - 45 PSI	25 - 35 PSI	40 - 50 PSI	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	8 - 10 PSI	N/A

*Always refer to gun manufacturer's recommendation for proper set up and spray pressure.*

## SURFACE PREPARATION

**Cleaning:** Clean parts thoroughly using a plastic cleaner such as Aqua SCAT 2 1391/1394 or Scuff & Prep Paste 6338 with a scuff pad to enhance the performance of the repair material. Rinse with water and wipe dry with a clean cloth.

**Sanding: *Over fresh, aged primer or existing finishes:*** Sand primer with 400-500 grit paper by hand block or with a DA. Clean parts thoroughly using a degreaser such as SCAT 6311, Speedi SCAT 6321, or Aqua Scat 2 1391/1394.

## APPLICATION & FILM BUILD

**For Plastic Parts:** Apply 1 medium coat of Mul-TIE. Allow 20 - 30 minute flash before topcoating or priming. Apply primer, color or clearcoat directly to the Mul-TIE.

**For aluminum or steel:** As there may be different grades and types of aluminum and steel substrates, it is recommended to test a piece with the following procedure to ensure adhesion. Apply 2 coats of Mul-TIE Adhesion Promoter, allowing 5 - 10 minute flash between coats. Allow Mul-TIE to dry for 20 - 30 minutes minimum before topcoating. Allowing more than 30 minutes will greatly improve the adhesion properties. It can be recoated up to 24 hours from the time of application. Apply 2 coats of any Transtar clearcoat, follow all mixing and flash time recommendations. The use of additives such as accelerators are strongly discouraged. Allow the test piece to cure for 24 hours before performing the adhesion test regardless of the "cure" time specified on the datasheet of the particular clearcoat you have chosen.

*Test Procedure: Make a cross hatch (#) on the test piece with a razor knife. Apply a piece of masking tape on the cross hatched area, rub the tape thoroughly to ensure good surface contact of the tape adhesive. Remove the tape quickly, pulling at a 180° angle to the panel surface. Check the tape and the panel, if the clear pulled from the panel and is stuck to the tape, the grade of aluminum or steel may not be a good candidate for clearcoating.*

**Over fresh, aged primer or existing finishes:** Apply 1 medium coat of Mul-TIE (apply 2 medium coats with 5 - 10 minute flash for use over polyester primer). Allow 20 - 30 minute flash before topcoating or priming.

## PRODUCT SPECIFICATIONS

Color: Amber	Shelf Life: 1 year
Size: Gallon (1031), 16 oz Aero (1033), Quart (1034)	

## REGULATORY

Category: Adhesion Promoter	1031, 1034		
VOC Actual	4.78#/gal (573 g/l)	Weight % of Exempt Compounds	22.76
VOC Regulatory	6.58#/gal (788 g/l)	Volume % of Exempt Compounds	27.36
Weight % of Volatiles	88.29	Density of Material #/gal	7.29
Weight % of Water	0		
1033			
Category: PAP	MIR<2.50		