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***From the Stars to your Cars***

Technical Data Sheet

## **Ionic Adhesion Promoter 1350-040, 041, and 042**

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### **Product Description and Purpose**

Ionic Adhesion Promoter is a single component, general purpose, adhesion promoter for use on most OEM plastics including PolyCarbonate, Polypropylene, and Polyethylene, as commonly found on modern vehicles.

### **Quick Start Guide**

Product:	<b>Ionic Adhesion Promoter 040, 041, 042</b>
Mix Ratio:	Ready to spray as packaged
Number of layers:	1 Single coat *see special instructions under substrate preparation for partial panel repairs
Items Needed:	Ionic Adhesion Promoter 1350-040, 041, or 042

### **Acceptable Substrates**

Uncoated OEM plastics

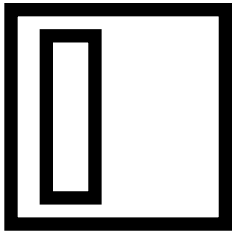
## **Substrate Preparation**

All surfaces shall be cleaned free of any existing paint prior to performing sanding, or spraying activity.

Wash: Thoroughly clean with warm soap and water before any abrasion or solvent cleaning. This is very important.  
Cleaning: 594-30 Wax and Grease Remover  
OEM plastic: Sand with 3M 7448 Pad (or equal)

\*Partial Panel Prepare bare plastic as above while feathering out existing finish with P220-P320 Dry. Apply Ionic Adhesion Promoter to bare plastic areas only. Apply an Orion Brand filling primer over feathered edge blending into the existing finish.

## **Mixing Ratios and Optional**



Ionic Adhesion Promoter  
is packaged ready to spray

\*Unused portion may be kept for future use, however,  
do not return unused portion to original container.

## **Additives**

Orion Automotive Finishes does not offer, or require, any additives for this product.

## **Dry Times/Pot Life @ 77F/25C**

(Dry/Flash times dependent on layer thickness)

Flash time between coats: Single coat recommended

Dry to Sand: Not recommended

Pot Life: Indefinite

## **Application**

Application is achieved in 1 single coat.

Topcoat grade gun 1.3-1.5 FT

The Ionic Adhesion Promoter is to be followed, after flash time, directly with topcoat color. The finish should be smooth to provide suitable surface for solid, metallic, and pearl colors. Sanding is not recommended as, when applied properly, there will not be sufficient film build for sanding.

## **Recoating**

After flash dry Ionic Adhesion Promoter can be followed by Orion 2K DTM Primer, Orion Brand Basecoat, or Single Stage product.

If surface imperfections are severe, and recoating is desired, let dry, sand as recommended, and recoat.

## **Safety and Emissions Data**

Color: Colorless

The appropriate selection of this product is based on many local factors and is ultimately most accurate when made by the customer. To assist in issues with regard to product selection please contact Orion Automotive Finishes.

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

**SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.**

**NOTE: Orion Automotive Finishes products are not recommended for use in temperatures below 65°F. Use below these temperatures will effect dry times and performance.**