




Standard Operating Procedure: Use of 3611 Low VOC Bumper and Cladding Coat™ Adhesion Primer

Steps	Equipment / Materials
<p>1. Clean raw TPO, PP, or TEO part with 1000 Super Prep Plastic Cleaner or 1001-4 EcoPrep Plastic Cleaner. To remove contaminants, wipe with clean dry cloth in one direction only, turning the cloth with each wipe to expose a clean surface to the plastic with each pass. Allow surface to dry. No need to scuff or sand raw TPO, PP, or TEO plastics.</p>	
<p>2. Fill a 0.8 - 1.4 mm HVLP gravity-feed spray gun with 3611, 3612 or 3613 Low VOC Bumper and Cladding Adhesion Primer. Adjust fluid needle and air pressure to achieve fine atomization. Both ambient temperature and surface temperature should be between 60°F (15°C) and 95°F (35°C).</p>	
<p>3. Apply one to two coats of Bumper and Cladding Coat Adhesion Primer to achieve hide. Do not try to “flow out” Bumper and Cladding Coat Adhesion Primer; it will appear slightly rough until dry. Allow 5 minutes of flash time between coats. Allow 60 minutes of dry time at room temperature or 15 minutes at 130°F (54°C) before top-coating.</p>	
<p>4. Bumper and Cladding Coat Adhesion Primer can be top-coated any time after it has completely dried. The top-coat window does not close. Apply approved top-coat system directly over Low VOC Bumper and Cladding Coat Adhesion Primer. Complete list available at www.polyvance.com.</p> <p>*Use proper protective equipment while working around chemicals.*</p>	