



## Mul-TIE Adhesion Promoter

### 1031, 1033, 1034

**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.**



#### Mix Ratio

Ready to use



#### Suitable Substrates

- Raw plastic - rigid (SMC, BMC)
- Raw plastic - flex (ABD, PPO)
- Raw plastic - soft (PUR)
- Plastic part - primed
- OEM finish & old paint work - non-reversible
- 1K primer
- 2K primer
- Primer - self-etching
- Body filler
- Bare steel
- Bare aluminum
- Fiberglass/SMC gel coat

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

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



#### Surface Prep & Application

**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.

**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.



### Flash Times/Dry Times

Flash between coats.....5 - 10 min  
To prime/topcoat.....20 - 30 min



### Gun Set-up

|                                 |                               |
|---------------------------------|-------------------------------|
| Siphon feed.....1.2 - 1.6 mm    | Gravity feed.....1.2 - 1.4 mm |
| Pressure feed .....1.0 - 1.2 mm | HVLP/LVLP .....1.2 - 1.5 mm   |



### Air Pressure

|                                |  |
|--------------------------------|--|
| Siphon feed.....35 - 45 psi    | Gravity feed (@ regulator).....25 - 35 psi |
| Pressure feed .....40 - 50 psi | HVLP/LVLP (@ aircap).....10 psi            |

### Fluid Pressure

Pressure feed .....8 - 10 psi



### Product Specifications

|                        |                        |
|------------------------|------------------------|
| Color.....Amber        | Size (1031).....Gallon |
| Shelf life.....3 years | (1033).....16 oz aero  |
|                        | (1034).....Quart       |

### Regulatory

|  |                                    |
|--|------------------------------------|
| Category.....Adhesion promoter         | Wt % of volatiles.....88.29        |
| VOC actual.....4.78#/gal (573 g/l)     | Wt % of water.....0                |
| VOC regulatory.....6.58#/gal (788 g/l) | Wt % of exempt compound.....22.76  |
| Density.....7.29 #/gal                 | Vol % of exempt compound.....27.36 |

### 1033

Category.....PAP  
MIR.....<2.50



### Limitations & Precautions

- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://www.tat-co.com)) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

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### LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.

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