



CUS AP-401-GL & CUS AP-404-QT

Adhesion Promoter (Gal, Qt Liquid)

CUS-AP-401 GL & CUS-404-QT is a premier adhesion promoter for the auto body collision repair market. It is a single-component product that combines an adhesion promoter, flex agent and blending aid in one. It is fast-drying and provides superior adhesion on all flexible and rigid plastic parts.

- Provides superior adhesion
- Works on pre-painted metal, plastic (TPO, polypropylene and SMC) and aluminum
- Single component, ready to spray – no mixing required
- Dries clear in 5 minutes
- Adhesion Promoter and Flex Agent in one
- Unused product can be poured back into the can
- Tint with basecoat for visible color coverage
- Improves flake orientation and color consistency
- Improves melt-in and edge wetting

**Not recommended for use over bare metal*

Compatible Coatings: All solvent-based urethane, epoxy, or acrylic lacquers, primers, sealers and basecoats.

Compatible Surfaces: All common automotive plastics, as well as glass, aluminum, fiberglass, rubber, vinyl and painted surfaces. It is suitable for ground effects, new flexible and rigid bumpers, as well as plastic interior and exterior parts. (Always test in an inconspicuous area, as every surface is different.)

Always apply basecoats and clearcoats according to manufacturer's instructions.

DIRECTIONS FOR USE - PLASTIC:

Carefully read all cautions and directions on the product label and SDS prior to use. Proper preparation is critical to the success of all repairs. Follow these steps to achieve maximum performance.

1. Clean all areas to be painted with a quality Pre Clean using a gray scuff pad.
2. Rinse thoroughly with clean water, and blow dry the surface.
3. Tack dry surface thoroughly with a clean tack cloth. Do not press tack cloth firmly against surface, as tack material may transfer to bumper and cause defects.
4. If noticeable static remains on surface after blow drying and tacking, please use an Anti-Static Panel Wipe as final wipe. Spray surface or pour on clean towel. Use wipe-on, wipe-off method, using clean towels in each hand to dry surface. Allow 3-5 minutes flash time before proceeding to next step.
5. Shake well and filter before each use to secure a uniform mixture. Apply a single, medium closed coat of ADP-100 Adhesion Promoter over entire plastic surface. A properly applied film should appear uniform, continuous and free of any voids.



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6. Allow 5 to 10 minutes before applying the next coating, or when tack free. *Dry times may vary based on temperature and humidity.*
7. Once tack free, proceed with normal basecoat/clearcoat process, according to manufacturer's instructions.

It has a 24-hour open time. If the part is left longer than 24 hours, tack, and apply 1 even light coat of CUS-AP-401 and 404 before applying the next coating. It covers 400 grit scratches and above.

DIRECTIONS FOR USES – PRE-PAINTED METAL SURFACES Carefully read all cautions and directions on the product label and SDS before use. Proper preparation is critical to the success of all repairs. Follow these steps to achieve maximum performance.

1. Remove all contaminants from the surface with a quality Pre Clean.
2. If the painted surface has been broken through to metal, then apply corrosion inhibitor or etch-primer, following manufacturer's instructions for application and dry times. **DO NOT** use on bare metal.
3. Clean the repair area with a quality Pre Clean, using a gray scuff pad. Rinse well with clean water and blow dry the surface.
4. Tack dry surface thoroughly with a clean tack cloth. Do not press cloth firmly against surface, as tack material may transfer to surface and cause defects.
5. If noticeable static remains on surface after blow drying and tacking, please use an Anti-Static Panel Wipe as final wipe. Spray surface or pour on clean towel. Use wipe-on, wipe-off method, using clean towels in each hand to dry surface. Allow 3-5 minutes flash time before proceeding to next step**.
6. Shake well and filter before each use to secure a uniform mixture. Apply a single, medium closed coat of CUS-AP-404 & 404 Adhesion Promoter over entire pre-painted metal surface. A properly applied film should appear uniform, continuous and free of any voids.
7. Allow 5 to 10 minutes before applying next coating, or when tack free. *Dry time may vary based on temperature and humidity.*
8. Once tack free, proceed with normal basecoat/clearcoat finishing process, according to manufacturer's instructions.

Technical Data

Recommended Gun Setup:

HVLP Tip Size 1.2mm – 1.4mm HVLP Tip Size 1.2mm – 1.4mm

Air Pressure:

Refer to spray gun specs

Apply:

1 medium closed coat

Dry Film Thickness:

1 coat: 0.4 – 0.6 mils

5-10 minutes @70F, or tack free

**Dry times vary depending on temperature and humidity

Tinting:

Mix 90% CUS-AP-401 & 404 with 10% basecoat for visible color coverage.

Flex Agent:

Ratio 1:4 with basecoat

Ratio 1:3 with clearcoat



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Cleanup:

All tools and spills should be cleaned immediately with a quality Gun Cleaner. Clean spray gun according to manufacturer's instructions. Use VOC Compliant products in restricted areas.

Notes:

This product may not be compatible with all surfaces and all conditions surrounding application. Before applying to any surface, always test in an inconspicuous area to ensure no damage will result.

Not compatible with waterborne coatings.

Appearance	Liquid, hazy, light pink to light yellow, mobile, dries to Class A water-white finish
Percent Volatile	82.75% by weight Store between 32F and 95F, in the original container
Flash Point	32F
CPSC Flammability	32F
Classification	Flammable
Storage	Store between 32F and 95F
Density	84.2% by weight 7.5 lbs/gal
VOC Category (Max Allowable VOC)	Specialty Coatings (840 gm/liter)
Actual VOC	768 gm/liter 6.2 lbs/gal 84.2% by weight
Shelf Life	2 years from date of manufacture, in an unopened container
DOT	UN 1866, Resin Solution, 3, PGII, Ltd. Qty
Prop 65	This product can expose you to chemicals including Ethylbenzene and Styrene, which are known to the State of California to cause cancer and Toluene, which is known to the State of California to cause birth defects or other reproductive harm. For more information, go to www.p65warnings.ca.gov .

Additional Tips for Using CUS-AP-401-GL and CUS-AP-404-QT Adhesion Promoter

1. Use as a mid-coat adhesion promoter, effectively "tying" multiple layers of paint together. Great for use when doing special paint effects, such as flames, two-tone paint jobs, etc. It will also improve the flop alignment of metallic pigments in blend-out areas.
2. When using as an added flex agent in a clear, be sure to add after the clear has been catalyzed. (Ratio 1:3 to mixed clear)
3. It can be added to primer in a ratio of up to 1:3.



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4. CUS-AP-401 & 404 cannot be *mixed* with waterborne paint. However, it can be used in a waterborne system, as long as it is applied underneath the primer-sealer.
5. Treat bare metal to prevent corrosion. Bare metal and body filler must be primed and dry or wet-sanded with 400 grit sandpaper prior to applying CUS-AP-401&404
6. Metal primer overspray onto plastic surfaces should be removed, as it can cause paint failure. Overspray onto plastic is not an issue.
7. CUS-AP-404 & 404 can be used on interior parts, such as dashboards, kick panels, visors, etc., prior to dyeing or painting. Solvent-based dyes can be mixed with (up to 50%) before application.
8. It should not be used on Lexan® or polyethylene surfaces.
9. Abrading of the substrate is essential for successful coating application. We recommend the use of a quality Pre Clean on plastics, but even gentle scuffing with a red or grey scuff pad will greatly increase the bite of the coating. Bare metals, OEM painted surfaces, and previous repair coats should all be abraded prior to repainting.