

# Technical Data Sheet

OEM Flex Primer is a specialty coating designed for priming flexible automotive parts. It is fast-drying, offers excellent adhesion, superior fill and build, and sands easily. Because of its unique formula, it has good low temperature crack resistance.

## 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  
 Thinning is not necessary.  
 Pot Life Unlimited in a sealed container

## FLASH TIMES/DRY TIMES



Flash between coats: 5-10 minutes  
 To sand: 20-30 minutes

## SURFACE PREPARATION



Depending on surface, see surface preparation for sanding recommendations.  
 Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.  
 \* 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	1.4 - 1.6	1.4 - 1.6
Air Pressure	10 PSI @ aircap	40 - 50 PSI @ regulator
Mil Thickness: 2.5 mils film build (dry film thickness)		

## 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.

# Technical Data Sheet

## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.5 - 1.6	1.4 - 1.6	1.4 - 1.5	1.4 - 1.6
Air Pressure	40 - 55 PSI	40 - 50 PSI	40 - 50 PSI	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10 - 14 PSI	N/A

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

## SURFACE PREPARATION

**Cleaning:** Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

**Sanding:** Sand with 320-500 grit wet or dry.

## TINTING & ADDITIVES

**Tinting:** Not recommended.

**Additives:** Fisheye Remover (6737) - Do not use.  
Kicker (6417) - Do not use.

Universal Urethane Flex Additive (9194) - Do not use.

## APPLICATION & FILM BUILD

Mask and sand as necessary. Ready to use gallons need no thinning. Apply 2-3 medium wet coats and allow a 5-10 minute flash time between coats, and 20 - 30 minutes before sanding.

**Film Build:** 2.5 mils total film build

## PRODUCT SPECIFICATIONS

Color: Black	Shelf Life: 3 years
RTS Solids by Weight: 24%	Weight per gallon: 8.07 #/gal
Size: Gallon	Approximate Coverage: 206 ft <sup>2</sup> /gal @ 0.5 mil

## REGULATORY

Category: Specialty Coating			
VOC Actual	4.71#/gal (564 g/l)	Weight % of Exempt Compounds	17.47
VOC Regulatory	6.00#/gal (719 g/l)	Volume % of Exempt Compounds	21.5
Weight % of Volatiles	75.86	Density of Material #/gal	8.07
Weight % of Water	0		