

# Technical Data Sheet

2 in 1 Primers are a specialty coating designed for easy and convenient priming of metal and plastic parts. These primers help prevent rust and seal out moisture, while providing a smooth base for topcoat application on metal substrates. 2 in 1 Primers also have excellent flexibility and adhesion properties that enable them to be applied to flexible and rigid parts. 2 in 1 Primers are fast drying, provide superior fill and build, and are easy to sand. They are compatible with virtually all automotive paints.

## 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 Unbroken 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



Mix Ratio: Ready to Spray

Pot Life: N/A

## FLASH TIMES/DRY TIMES



Flash Time 5-10 minutes  
Dry to Sand 15-20 minutes

## SURFACE PREPARATION



Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry. Sand substrate with 240 grit paper and mask off repair area.

## APPLICATION



Shake can well. Hold can upright 8 – 12 inches from surface to be primed. Apply 2 – 3 medium wet coats, allowing 5-10 minutes of flash time between coats. Allow to dry for 15 – 20 minutes before sanding. Sand with 320-400 (dry) or 500-600 (wet) grit sandpaper until a smooth surface is attained. Reclean with SCAT, wipe area with a tack cloth and apply top coat paint per manufacturers instructions.

## PRODUCT SPECIFICATIONS/REGULATORY

Color/Size: 20 oz Aero Gray (4603), Black (4613), Red Oxide (4623), White (4633)	Shelf Life: 3 years
Approximate Coverage: 432 ft <sup>2</sup> /gal @ 1 mil	Category: ABP - MIR <.95

## LIMITATIONS & PRECAUTIONS

- This product provides adhesion & corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded & applied.
  - 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.
  - Before use, read and follow all TDS, label and SDS precautions.
  - All Standard Operating Procedures (SOP) can be found on the Transtar website at [www.tat-co.com](http://www.tat-co.com).
- Visit [www.tat-co.com](http://www.tat-co.com) to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).