

Technical Data Sheet

1K Low VOC Speed Sealer is a ready-to-spray acrylic sealer with good holdout properties and excellent adhesion. This non-sanding sealer is ideal for spot and panel refinishing and is designed to provide excellent DOI under a wide range of topcoats. 1K Low VOC Speed Sealer can be applied over sanded factory primers on replacement parts and panels. This product is tintable with solvent basecoat toners.

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	✓

+ Due to the diverse nature of plastic resins, test substrate for acceptable adhesion prior to use in production.

++ 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
Reduction is not required.
Pot Life Unlimited in a sealed cup

FLASH TIMES/DRY TIMES



Flash Between Coats 10-15 minutes
Flash before Topcoat 10-20 minutes
Dry to Sand 10-20 minutes
Max recoat w/o sanding 8 hours
Force Drying N/A

SURFACE PREPARATION



Solvent wash entire surface with a wax and grease remover, such as Transtar's SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry. Sand with 400-600 grit paper.
* 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 1.2 - 1.4 1.2 - 1.6
Air Pressure 10 PSI @ aircap 30 - 40 PSI @ regulator
Mil Thickness: 0.75-1.0 mils per coat (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	1.4 - 1.6	1.2 - 1.6	1.0 - 1.2	1.2 - 1.4
Air Pressure	40 - 50 PSI	30 - 40 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: Solvent wash entire surface with a wax and grease remover, such as SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry.

Sanding: Finish sand all areas to be sealed with 400 - 600 grit or finer sandpaper.

TINTING & ADDITIVES

Tinting: May be tinted up to 10% by volume using solvent based basecoat mixing toners.

Additives: Fisheye Remover (6737) - Do not use.
Universal Urethane Flex Additive (9194) - Do not use.
Kicker (6417) - Do not use.

APPLICATION & FILM BUILD

The product is supplied ready-to-spray. Reduction is not required. Stir or agitate thoroughly and filter before using.

Wet-on-wet: Apply one to two full wet coats to achieve hiding (.75 to 1.0 mil film build). Avoid heavy applications. Allow sealer to flash for 10-15 minutes (@75°F (24°C)) prior to top coating.

Recoat/Repair: If sealer is not top coated within 8 hours, clean, scuff (with 600 grit or finer sandpaper) before topcoating.

Note: If sanding is required to remove any imperfections, wet or dry sand using 600 - 1000 grit sandpaper. Use light pressure to avoid cutting through sealer.

Film Build: 0.75-1.0 mils per coat (dry film thickness)

PRODUCT SPECIFICATIONS

Weight per gallon: 9.35 #/gal	Shelf Life: 3 years
RTS Solids by Weight: 22.13%	Approximate Coverage: 218 ft ² /gal @ 1 mil
Color: Light Gray	Size: Gallon (6091), Quart (6094)

REGULATORY

Category: Primer/Primer Sealer	6091, 6094	Weight % of Exempt Compounds	73.58
VOC Actual	0.4#/gal (48 g/l)	Volume % of Exempt Compounds	80.77
VOC Regulatory	2.07#/gal (248 g/l)	Density of Material #/gal	9.35
Weight % of Volatiles	77.87		
Weight % of Water	0		

Recommendations:

- Sealer must be shaken for a minimum of 10 minutes.
- Provides good adhesion and corrosion protection when applied directly to bare metal. For areas larger than 1' X 1', apply one of Transtar's direct to metal primers (Self-Etch 6111/6114, Epoxy Primer 6100 Series or Kwik Prime 6441/6444) per instructions indicated on product data sheet.