

Technical Data Sheet

1K Acrylic 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. May be tinted 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 surface 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: 8.76 #/gal	Shelf Life: 3 years
RTS Solids by Weight: 22%	Approximate Coverage: 225 ft ² /gal @ 1 mil
Color: Light Gray	Size: Gallon (6081), Quart (6084)

REGULATORY

Category: Primer/Primer Sealer	6081, 6084	Weight % of Exempt Compounds	59.79
VOC Actual	1.57#/gal (188 g/l)	Volume % of Exempt Compounds	65.67
VOC Regulatory	4.58#/gal (549 g/l)	Density of Material #/gal	8.76
Weight % of Volatiles	77.76		
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.