Technical Data Sheet

Super Sand is a premium high quality, acrylic primer-surfacer that offers outstanding build characteristics for fast filling, without shrinkage. It is compatible for use under all conventional paint systems. This lead free primer-surfacer is a "true" acrylic. It's unique formulation combines excellent adhesion and hold out with superior sandability.

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	1: 1 with Acetone
	Do not use Wash Thinner.
Pot Life	4 hours in a vented cup @70°F (21°C) and 50% RH
	Unlimited in a sealed cup

FLASH TIMES/DRY TIMES

Flash Between Coats	5-10 minutes
Dry to Sand	20-30 minutes
Max recoat w/o sanding	Must sand/seal
Force Drying	20 minutes @ 140°F (60°C)

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 to be primed with 180-240 grit.
* For more information on surface prep and application refer to next page.

SPRAY GUN SET-UP/APPLICATION

	HVLP/LVLP	Gravity Feed
Gun Type		
Fluid Tip	1.2 - 1.6	1.2 - 1.6
Air Pressure	10 PSI @ aircap	40 - 45 PSI @ regulator

Mil Thickness: 1.5 - 2.0 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.

Visit 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).
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Rev 10/20

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 - 1.6
Air Pressure	40 - 55 PSI	40 - 45 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. Sand all painted areas, feather edging broken spots. Bare steel and aluminum should be treated with epoxy or self etch primer. If large areas of zinc coated or hot rolled steel are involved, use a self etch primer such as Transtar's Self Etch Primer 6111/6114.
Sanding: Sand with 180-240 grit paper.

TINTING & ADDITIVES

Tinting: Not recommended.
Additives: Fisheye Remover (6737) - Do not use.
Universal Urethane Flex Additive (9194) - For use as a specialty coating on elastomeric substrate, add 20% after reduction.
Kicker (6417) - Do not use.

APPLICATION & FILM BUILD

Mixing: Reduce 1 part primer with 1 part acetone. DO NOT USE WASH THINNER AS THIS MAY CAUSE RESIN "KICK OUT". Apply 2 medium wet coats allowing 5-10 minutes between coats for flash off. Do not apply heavy wet coats. Allow 20-30 minutes drying time before sanding. Super Sand Primer must be sanded before topcoating. Sand with 320 grit followed by 500 grit until a smooth primer surface is obtained. Follow manufacturer's topcoat instructions. If topcoating with an enamel, recoat entire surface with a non-sanding sealer to provide uniform holdout between primed and unprimed areas.
Film Build: 2.0 mils per coat (dry film thickness) Do not exceed 8.0 mils dry film thickness.

PRODUCT SPECIFICATIONS

Weight per gallon: 10.85 #/gal	Shelf Life: 3 years
RTS Solids by Weight: 35.54	Approximate Coverage: 417 ft^2/gal @ 1 mil
Color: Gray	Size: Gallon

REGULATORY

Category: Primer	6051
VOC Actual	4.64#/gal (556 g/l)
VOC Regulatory	4.64#/gal (556 g/l)
Weight % of Volatiles	42.81
Weight % of Water	0
Weight % of Exempt Compounds	0
Volume % of Exempt Compounds	0
Density of Material #/gal	10.85

Recommendations:
- Primer must be shaken for a minimum of 10 minutes.
- If priming over large areas of zinc coated and hot rolled steel, use a self etch primer such as Transtar's Self Etch Primer 6111/6114.
- Super Sand Primer must be sanded prior to topcoating. If topcoating with an enamel, recoat entire surface with a non-sanding sealer to provide uniform holdout between primed and unprimed areas.

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