

Technical Data Sheet

Universal Primer is a fast drying, easy sanding primer surfacer, which has excellent adhesion and filling properties. It sands to a fine featheredge while providing excellent color hold out.

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: 1½ - 2 - 1 part primer to 1½ - 2 parts acetone
1½ - 2 parts 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 10-15 minutes
Dry to Sand 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.

* 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 - 1.6	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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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 steel are involved, use a self etch primer such as Transtar's Self Etch Primer 6111/6114.

Sanding: Sand with 400 grit sandpaper until a smooth primer surface is obtained.

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 1½ - 2 parts with acetone. DO NOT USE WASH THINNER AS THIS MAY CAUSE RESIN "KICK OUT". Apply 2 or more medium wet coats allowing 10 – 15 minutes between coats for flash off. Do not apply heavy wet coats. Allow 30 minutes drying time before sanding. Sand with 400 grit sandpaper until a smooth primer surface is obtained. Universal Primer must be sanded before topcoating. 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: 1.0 - 1.5 mils per coat (dry film thickness)

PRODUCT SPECIFICATIONS

Weight per gallon: 9.01 #/gal	Shelf Life: 3 years
RTS Solids by Weight: 18.15%	RTS Solids by Volume: 8.94%
Color: Gray (6001, 6004, 6005), Black (6021, 6024)	Sprayable Viscosity: 8 seconds (#3 Zahn Cup)
Approximate Coverage: Gray 388 ft ² /gal @ 1 mil Black 358 ft ² /gal @ 1 mil	Size: Gallon (6001, 6021), Quart (6004, 6024), 5 Gallon (6005)

REGULATORY

Category: Primer	6001, 6004, 6009	6021, 6024
VOC Actual	3.30#/gal (395 g/l)	3.26#/gal (391 g/l)
g/l)VOC Regulatory	4.61#/gal (553 g/l)	4.71#/gal (565 g/l)
Weight % of Volatiles	57.51	61.09
Weight % of Water	0.1	0
Weight % of Exempt Compounds	20.84	23.40
Volume % of Exempt Compounds	28.41	30.68
Density of Material #/gal	9.01	8.67

Recommendations:

- Primer must be shaken for a minimum of 10 minutes.
- If priming over large areas of zinc coated steel, use a self etch primer such as Transtar's Self Etch Primer 6111/6114.
- Universal 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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