

Technical Data Sheet

2K Acrylic Urethane Primer is a premium lead/chrome free two component acrylic urethane primer surfacer. 6561/6564 provides exceptional fill and build and provides a base which yields excellent top coat hold out, gloss and D.O.I. (Distinctness of Image). 2K Acrylic Urethane Primer sands easily wet or dry and can be directly topcoated with alkyd enamels, acrylic enamels, lacquers, acrylic urethane enamels and basecoat/clearcoat systems.

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 may be 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



Primer 4 parts Primer (6561/6564)
By Volume: 1 part Activator (6584/6587)

Sealer: 4 parts Primer (6561/6564)
By Volume: 1 part Activator (6584/6587)
½ up to 2 parts Urethane Grade Reducer (6700 or 6700-F Series)

Pot Life 2-3 hours (@70°F (21°C) and 50% relative humidity)

* Use reducer according to shop conditions. Using urethane grade reducer will increase VOC's. For tinting instructions and the use of additives, please refer to next page.

FLASH TIMES/DRY TIMES



Flash Between Coats 10-15 minutes
Dry to Sand 1-3 hours
(As a Sealer) To Recoat 20 minutes Denib: 20-30 minutes Max Recoat w/o Sanding: 2 hours
Force Drying 30 minutes @140°F (60°C)

SURFACE PREPARATION



Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry and sand with 80-180 grit.
* 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 1.6 - 1.8 mm 1.6 - 1.8 mm
Air Pressure 10 PSI @ aircap 35-45 PSI @ gun
Mil Thickness: 2.0 - 2.5 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.
- If mixed with other components, mixture may be hazards of all combined components.
- See next page for more detailed product 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	1.6-2.0 mm	1.6-1.8 mm	1.0-1.2 mm	1.6-1.8 mm
Air Pressure	40-50 PSI (@gun)	35-45 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	8-10 PSI	N/A

Always refer to gun manufacturer's recommendation for proper set up and spray pressure.

SURFACE PREPARATION

Cleaning: Clean surfaces using standard refinish techniques to avoid contamination. Wash surfaces thoroughly with soap and water. Rinse well and wipe dry with a clean cloth. Solvent clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry with clean cloth.

Sanding: Bare Steel, Aluminum and galvanized metal: Must be primed with Self Etch Primer 6111/6114 or Epoxy Primer 6100 Series.
OEM and Refinish Paints and Lacquers: Must be cured and sanded. Refinish lacquers require entire panel repair.
Body Filler, Fiberglass, SMC: Must be sanded.

As a Sealer Sanded and degreased existing finish and primers.

TINTING & ADDITIVES

Tinting: Not recommended.

Additives: Fisheye Remover (6737) - Can be used at a rate of ¼ to ½ oz per sprayable quart.

Universal Urethane Flex Additive (9194) - May be used, refer to TDS for mixing recommendations.

Kicker (6417): Can be used at a rate of ½ oz per sprayable quart. Accelerated products should never be used direct-to-metal.

APPLICATION & FILM BUILD

Primer: Stir 2K Acrylic Urethane Primer thoroughly before use. Mix 4 parts primer to 1 part activator. Apply 2 -3 medium wet coats, allowing 10 - 15 minutes flash time between coats.

Non-Sanding Sealer: Mix 4 parts primer to 1 part activator to ½ part reducer or up to 2 parts zero VOC reducer. Apply 1 medium wet coat. Flash for 20 minutes before topcoating. If applying 2 coats of 6561, flash for 30 minutes before topcoating. Denib with 600 wet or dry. After two hours, it will be necessary to sand the sealer with 500-600 grit sandpaper to ensure good basecoat adhesion.

Film Build: 2.0 - 2.5 mils per coat (dry film thickness). For best results, do not exceed 6 mils dry film thickness total.

PRODUCT SPECIFICATIONS

Weight per gallon: 12.17	Shelf Life: 1 year
RTS Solids by Weight: Primer: 58% Sealer: 55%	Approximate Coverage @1 mil: Primer: 717 ft ² /gal Sealer: 665 ft ² /gal
Color: Light Gray	Size: Primer - Gallon (6561), Quart (6564) Activator - Quart (6584), ½ Pint (6587)

REGULATORY

Category: Primer	6561/6564	6584/6587	RTU VOC Actual (4:1)	1.18#/gal (141 g/l)
VOC Actual	1.39#/gal (167 g/l)	0.34#/gal (41 g/l)	RTU VOC Regulatory (4:1)	2.07#/gal (248 g/l)
VOC Regulatory	2.25#/gal (268 g/l)	0.94#/gal (113 g/l)	RTU VOC Actual (4:1:½) (6700 Series)	1.75#/gal (210 g/l)
Weight % of Volatiles	35.34	70.72	RTU VOC Regulatory (4:1:½) (6700 Series)	2.88#/gal (345 g/l)
Weight % of Water	0	0	RTU VOC Actual (4:1:1) (6700-F Series)	0.98#/gal (118 g/l)
Weight % of Exempt Compounds	23.92	67.47	RTU VOC Regulatory (4:1:1) (6700-F Series)	2.07#/gal (248 g/l)
Volume % of Exempt Compounds	37.79	63.73		
Density of Material #/gal	12.17	10.52		

Recommendations:

- Primer must be shaken for a minimum of 10 minutes.
- Observe flash times to provide good cure times to reduce shrinkage.
- Best adhesion results are achieved if topcoated within 8 hours, best holdout is achieved if primer is allowed to cure overnight.
- When using over lacquer, always complete the entire panel. Spot repairs may lift around the repair.

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