



OEM Flex Primer

1161

OEM Flex Primer is a specialty coating designed for priming flexible automotive parts. It is fast-drying, offers excellent adhesion, superior fill and build, and sands easily. Because of its unique formula, it has good low temperature crack resistance.



Mix Ratio

Ready to use, thinning is not necessary.
Pot life: unlimited in a sealer container.



Suitable Substrates

- Raw plastic - rigid (SMC, BMC)
 - Plastic part - primed
 - Fiberglass/SMC gel coat
 - Raw plastic - flex (ABD, PPO)
 - Raw plastic - soft (PUR)
- Note: Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.*
Note: Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.



Surface Prep & Application

Cleaning: Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.
Sanding: Sand with 320-500 grit wet or dry.
Application: Mask and sand as necessary. Ready to use gallons need no thinning. Apply 2-3 medium wet coats and allow a 5-10 minute flash time between coats, and 20 - 30 minutes before sanding. Film Build: 2.5 mils total film build.

Tinting & Additives

TintingNot recommended.
Kicker (6417)Do not use.
Fisheye Remover (6737) ..Do not use.
Flex Additive (9194)Do not use.



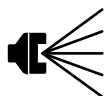
Flash Times/Dry Times

Flash time 5 - 10 min between coats
To sand.....20 - 30 min



Gun Set-up

Siphon feed.....	1.5 - 1.6 mm	Gravity feed.....	1.4 - 1.6 mm
Pressure feed	1.4 - 1.5 mm	HVLP/LVLP	1.4 - 1.6 mm



Air Pressure

Siphon feed.....	40 - 55 psi	Gravity feed (@ regulator).....	40 - 50 psi
Pressure feed	40 - 50 psi	HVLP/LVLP (@ aircap).....	10 psi

Fluid Pressure

Pressure feed 10 - 14 psi



Product Specifications

Color.....	Black	Size	Gallon
Shelf life.....	3 years	RTS solids by weight.....	24%
Approx. coverage.....	206 ft ² /gal @ 0.5 mil	Weight per gallon.....	8.07 #/gal

Regulatory

Category.....	Specialty coating	Wt % of volatiles.....	75.86
VOC actual	4.71#/gal (564 g/l)	Wt % of water	0
VOC regulatory.....	6.00#/gal (719 g/l)	Wt % of exempt compound	17.47
Density.....	8.07 #/gal	Vol % of exempt compound	21.5



Limitations & Precautions

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

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