

Technical Data Sheet

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.

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	

** 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 maybe 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



By Volume: Ready to Spray
Thinning is not necessary.

Pot Life Unlimited in a sealed container

FLASH TIMES/DRY TIMES



Flash between coats: 5-10 minutes
To sand: 20-30 minutes

SURFACE PREPARATION



Depending on surface, see surface preparation for sanding recommendations.
Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

* 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	1.4 - 1.6	1.4 - 1.6
Air Pressure	10 PSI @ aircap	40 - 50 PSI @ regulator
Mil Thickness: 2.5 mils film build (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.

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SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.5 - 1.6	1.4 - 1.6	1.4 - 1.5	1.4 - 1.6
Air Pressure	40 - 55 PSI	40 - 50 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: Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

Sanding: Sand with 320-500 grit wet or dry.

TINTING & ADDITIVES

Tinting: Not recommended.

Additives: Fisheye Remover (6737) - Do not use.
 Kicker (6417) - Do not use.

Universal Urethane Flex Additive (9194) - Do not use.

APPLICATION & FILM BUILD

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

PRODUCT SPECIFICATIONS

Color: Black	Shelf Life: 1 year
RTS Solids by Weight: 24%	Weight per gallon: 8.07 #/gal
Size: Gallon	Approximate Coverage: 206 ft ² /gal @ 0.5 mil

REGULATORY

Category: Specialty Coating			
VOC Actual	4.71#/gal (564 g/l)	Weight % of Exempt Compounds	17.47
VOC Regulatory	6.00#/gal (719 g/l)	Volume % of Exempt Compounds	21.5
Weight % of Volatiles	75.86	Density of Material #/gal	8.07
Weight % of Water	0		