



2 in 1 Primer

4603, 4613, 4623, 4633

2 in 1 Primers are a specialty coating designed for easy and convenient priming of metal and plastic parts. These primers help prevent rust and seal out moisture, while providing a smooth base for topcoat application on metal substrates. They have excellent flexibility and adhesion properties that enable them to be applied to flexible and rigid parts.



Mix Ratio

Ready to use.



Suitable Substrates

- Raw plastic - rigid (SMC, BMC)
- Raw plastic - flex (ABD, PPO)
- Raw plastic - soft (PUR)
- Plastic part- primed
- OEM finish & old paint work - non-reversible
- Bare steel
- Bare galvanized
- Bare aluminum
- OEM E-coat
- 1K primer
- 2K primer
- Self etch primer
- Body filler

Note: 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.

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

Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry. Sand substrate with 240 grit paper and mask off repair area. Shake can well. Hold can upright 8 – 12 inches from surface to be primed. Apply 2 – 3 medium wet coats, allowing 5-10 minutes of flash time between coats. Allow to dry for 15 – 20 minutes before sanding. Sand with 320-400 (dry) or 500-600 (wet) grit sandpaper until a smooth surface is attained. Re-clean with SCAT, wipe area with a tack cloth and apply top coat paint per manufacturers instructions.



Flash Times/Dry Times

Flash time5 - 10 min
 Dry to sand.....15 - 20 min

**Product Specifications**

Color (4603).....	Gray	Size.....	20 oz aero
(4613).....	Black	Shelf life.....	3 years
(4623).....	Red oxide	Approx. coverage @ 1 mil.....	432 ft ² /gal
(4633).....	White		

Regulatory

Category.....	ABP
MIR.....	<0.95

**Limitations & Precautions**

- This product provides adhesion & corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded & applied.
- 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.
- Before use, read and follow all TDS, label and SDS precautions.
- If mixed with other components, mixture may be hazards of all combined components.
- All Standard Operating Procedures (SOP) can be found on the Transtar website at www.tat-co.com.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.