

Technical Data Sheet

Acrylic Urethane Primer is an acrylic urethane primer surfacer. It sands easily wet or dry and can be directly topcoated with alkyd enamels, acrylic enamels, lacquers, acrylic urethane enamels and base coat/clear coat 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



By Volume: 4 parts Primer (4951-01)
1 part Activator (5911-04)
1 part 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 5 minutes
Dry to Sand 1-3 hours
Dry to Recoat 45 minutes
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 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: 1.5 - 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	1.6-1.8 mm	1.6-1.8 mm	1.6-1.8 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: Aluminum and galvanized metal: Must be pretreated with an etching or epoxy primer.
OEM and Refinish Paints: Must be cured and sanded. Sand with 180 grit.
OEM and Refinish Lacquers: Must be sanded. Not recommended for spot repairs over lacquers, as lifting may occur.
Body Filler: Must be sanded. Sand with 180 grit.
Fiberglass and SMC: Must be sanded. Sand with 180 grit

TINTING & ADDITIVES

Tinting: Can be tinted up to 10% with basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels.

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, for use as a specialty coating for elastomeric substrates, 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

Apply 2-3 medium wet coats, allowing 5 minute flash between coats.

Film Build: 1.5 - 2.5 mils per coat (dry film thickness)

PRODUCT SPECIFICATIONS

Weight per gallon: 11.53	Shelf Life: 1 year
RTS Solids by Weight: 51.67/50.62	Approximate Coverage: 511 ft ² /gal @ 1 mil
Color: Light Gray	Size: Gallon

REGULATORY

Category: Primer	4951-01	5911-04	RTU VOC Actual (6700 Series Reducers)	4.36#/gal (523 g/l)
VOC Actual	3.36#/gal (403 g/l)	5.24#/gal (628 g/l)	RTU VOC Regulatory (6700 Series Reducers)	4.77#/gal (572 g/l)
VOC Regulatory	3.86#/gal (463 g/l)	5.24#/gal (628 g/l)	RTU VOC Actual (6700-F Series Reducers)	3.12#/gal (374 g/l)
Weight % of Volatiles	36.57	68.75	RTU VOC Regulatory (6700-F Series Reducers)	4.17#/gal (500 g/l)
Weight % of Water	0	0		
Weight % of Exempt Compounds	7.38	0		
Volume % of Exempt Compounds	12.87	0		
Density of Material #/gal	11.53	7.63		

Recommendations:

- This product provides adhesion and corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded and applied.
- When priming over lacquer, it is recommended to coat the complete panel.

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