TRANSTAR®

4970-01
True Finish Low VOC Primer

Technical Data Sheet

True Finish Low VOC Primer is a lead/chrome free two component acrylic urethane primer surfacer. It provides fill, build, and a base which yields good topcoat hold out and gloss. It sands easily wet or dry and can be directly topcoated with alkyd and 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 (4970-01)
By Volume:	1 part Activator (5970-04)
Pot Life	2-3 hours (@70°F (21°C) and 50% relative humidity)

FLASH TIMES/DRY TIMES

Flash Between Coats	10-15 minutes
Dry to Sand	1-3 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

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

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.

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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.

Surface Prep: OEM and Refinish Paints and Lacquers: Must be cured and sanded. Refinish lacquers require entire panel repair.
Body Filler, Fiberglass, SMC: Must be sanded.

TINTING & ADDITIVES

Tinting: Not recommended.

Additives: Fisheye Remover (6737) - Do not use.
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: Mix 4 parts primer to 1 part activator. Apply 2 -3 medium wet coats, allowing 10 - 15 minutes flash time between coats.
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: 12.22	Shelf Life: 3 years
RTS Solids by Weight: 58%	Approximate Coverage @1 mil: 647
Color: Buff	Size: Primer - Gallon (4970-01), Activator - Quart (5970-04)

REGULATORY

Category: Primer	4970-01	5970-04
VOC Actual	1.38#/gal (165 g/l)	0.34#/gal (41 g/l)
VOC Regulatory	2.22#/gal (266 g/l)	0.94#/gal (113 g/l)
Weight % of Volatiles	35.18	70.72
Weight % of Water	0	0
Weight % of Exempt Compounds	23.90	67.47
Volume % of Exempt Compounds	37.89	63.73
Density of Material #/gal	12.22	10.52
RTU VOC Actual (4:1)	1.17#gal (140 g/l)	
RTU VOC Regulatory (4:1)	2.06 #/gal (246 g/l)	

Recommendations:

- Primer must be shaken for a minimum of 10 minutes.
- Observe flash times to provide good solvent evaporation to reduce shrinkage and avoid solvent entrapment.
- 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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