

Technical Data Sheet

Transtar's Self-Etch Primer is a two part, self-etching and passivating primer. This system provides excellent protection against corrosion to bare metal, thereby eliminating the need for metal conditioning. Self Etch Primer features an easy mix ratio and requires no induction time prior to using. Mixing 6111/6121-F/Acetone @ 1:1:2 complies with SCAQMD Rule 1151 for Group 1 and Group II vehicles for use as a pre-treatment/wash primer*.

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	

+ Due to the diverse nature of plastic resins, test substrate for acceptable adhesion prior to use in production.

++ 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 1:1 1 part 6111/6114 Primer and 1 part 6121-F/6124-F Activator
 *1:1:2 1 part 6111/6114 Primer, 1 part 6121-F/6124-F Activator, 2 parts Acetone
 Pot Life Up to 5 days @70°F (21°C) and 50% R.H.

FLASH TIMES/DRY TIMES



Flash Between Coats 10-15 minutes
 Dry to Touch 15 minutes
 Dry to Sand 60 minutes
 Rcoat w/o sanding 45 minutes
 Force Drying 30 minutes after air drying for 15 minutes @ 140°F (60°C)

SURFACE PREPARATION



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

* 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 1.2 - 1.4 1.2 - 1.6
 Air Pressure 10 PSI @ aircap 25 - 35 PSI @ regulator
 Mil Thickness: 0.5 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.
- 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	1.4 - 1.6	1.2 - 1.6	1.0 - 1.2	1.2 - 1.4
Air Pressure	35 - 45 PSI	25 - 35 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: Wash surfaces thoroughly with soap and water. Rinse well and wipe dry with clean cloth. Solvent wash entire surface with a wax and grease remover, such as SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry.

Sanding: Finish sand all areas to be sealed with 400-600 grit wet or dry. For galvanized steel panels, sand with 80-120 grit. For aluminum and fiberglass, sand with 150-180 grit.

TINTING & ADDITIVES

Tinting: Not recommended.
Additives: Fisheye Remover (6737) - Do not use.
 Universal Urethane Flex Additive (9194) - Do not use.
 Kicker (6417) - Do not use.

APPLICATION & FILM BUILD

Mixing: Mix 1:1 or 1:1:2 per instructions on previous page. For best results apply 2-3 medium wet coats. Can also be recoated with topcoats (basecoat/clearcoat or single stage) after 45 minute flash time without sanding.

Priming and Painting of OEM E-Coated Panels: Transtar's Self Etch Primer performs as an excellent tie coat for any top coat system when applied over unsanded E-Coat panels. Clean E-Coated part with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Prime with a minimum of two coats of Self Etch Primer 6111/6114. Flash for 30 minutes and apply topcoat wet-on-wet. Optional: Parts can be scuffed with a scuff pad prior to priming for improved adhesion.

Film Build: 0.5 mils per coat (dry film thickness)

PRODUCT SPECIFICATIONS

Weight per gallon: 9.40 #/gal	Shelf Life: 3 years
RTS Solids by Weight:	Approximate Coverage: 213 ft ² /gal @ 1 mil
Color: Olive Green	Size: Primer - Gallon (6111), Quart (6114) Activator - Gallon (6121-F), Quart (6124-F)

REGULATORY

Category: Pretreatment Coating	6111/6114	6121-F/6124-F	RTU VOC Actual (1:1)	3.20#/gal (384 g/l)
VOC Actual	5.31#/gal (636 g/l)	1.09#/gal (131 g/l)	RTU VOC Regulatory (1:1)	5.50#/gal (659 g/l)
VOC Regulatory	5.31#/gal (636 g/l)	6.64#/gal (796 g/l)	RTU VOC Actual (1:1:2) Rule 1151	1.60#/gal (192 g/l)
Weight % of Volatiles	56.52	97.93	RTU VOC Regulatory (1:1:2) Rule 1151	5.50#/gal (659 g/l)
Weight % of Water	0	0.4		
Weight % of Exempt Compounds	0	83.82		
Volume % of Exempt Compounds	0	83.17		
Density of Material #/gal	9.40	7.97		

Recommendations:

- Primer must be shaken for a minimum of 10 minutes.
- Do not use under polyester body filler.