

PRODUCT HIGHLIGHTS

6111, 6114, 6121-F, 6124-F Self Etching Primer

DESCRIPTION:

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.*

PRODUCTS:

6111 Self Etching Primer, Gallon (3.78 L), 2/case
6114 Self Etching Primer, Quart (0.946 L), 6/case
6121-F Self Etching Activator, Gallon (3.78 L), 2/case
6124-F Self Etching Activator, Quart (0.946 L), 6/case



SURFACE PREP:

Depending on surface, see surface preparation for sanding recommendations
Clean with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT (TDS225).



MIX RATIO:

1:1, by volume using 6121-F (1 part 6111 to 1 part 6121-F)
***1:1:2**, (1 part 6111 to 1 part 6121-F to 2 parts Acetone)
Pot life: Up to 5 days @ 70°F and 50% relative humidity



HVLP/LVLP:

1.2 - 1.4 mm
2 - 3 medium wet coats



45 minute flash

0.5 mils per coat (dry film thickness)



Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

30 minutes



SANDING:

DA (Dry): #360 - 400

Hand (Wet): #500 - 600

See next page for more detailed product application. See website for this document in other languages.
Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

6111, 6114, 6121-F, 6124-F Self Etching Primer

SUITABLE SUBSTRATES:

Degreased and sanded existing finishes; galvanized steel; steel and aluminum, hot rolled steel, fiberglass; body filler (fully cured). Not recommended for use over lacquer finishes.

SURFACE PREPARATION:

Wash surfaces thoroughly with soap and water. Rinse well and wipe dry with clean cloth. Degrease and wipe dry. Remember to remove plastic insert on 6124-F activator quart before using.

- Galvanized Steel: Degrease surface, sand with 80-120 grit sandpaper.
 Degrease again with before priming.
- Aluminum and Fiberglass: Degrease surface, sand with 150-180 grit sandpaper.
 Degrease again before priming.



APPLICATION & MIXING:

For best results apply 2-3 medium wet coats. On bare metal, apply 2-3 medium wet coats. Under primer fillers, apply 2-3 medium wet coats. Can also be recoated with topcoats (basecoat/clearcoat or single stage) after 45 minute flash time without sanding. **Note: Do not use under Polyester Body Filler.**

APPLICATION NOTES:

- Force Drying: Can be force dried at 140°F (60°C) for up to 30 minutes then air dried for 15 minutes.
- Sanding: 60 minutes
- Wet Sand: 500 - 600 sandpaper wet.
- Dry Sand: 360 - 400 sandpaper dry.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.4 - 1.6 mm	40 - 50 PSI (at gun)	n/a
Gravity Feed	1.2 - 1.6 mm	30 - 40 PSI (at gun)	n/a
Pressure Feed	1.0 - 1.2 mm	40 - 50 PSI (at gun)	10 - 14 PSI
HVLP/LVLP	1.2 - 1.4 mm	10 PSI max. (at aircap)	n/a

PRIMING AND PAINTING OF E-COATED BODY PANELS:

Transtar's Research and Development Team has performed extensive testing on OEM and Aftermarket replacement parts which were coated with various E-Coat systems. The objective was to apply Self Etch Primer directly over the replacement parts without sanding then, evaluate its performance.

The results are that Transtar's Self Etch Primer #6111/6121-F performs as an excellent tie coat for any top coat system when applied over unsanded E-Coat panels.

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PRIMING AND PAINTING OF E-COATED BODY PANELS CONTINUED:

The recommendations for use are:

1. Clean E-Coated part with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225).
2. Prime with a minimum of two coats of Self Etch #6111/6114.
3. 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.

TECHNICAL DATA:

APPEARANCE:	Olive Green
% SOLIDS:	6111/6121-F - 27.92% Ready to Use *6111/6121-F/Acetone - 15.60% Ready to Use
SHELF LIFE:	One year (unopened)
SPRAYABLE VISCOSITY:	17-20 seconds (Zahn #2 Cup)
MIX RATIO:	1:1 , by volume using 6121-F (1 part 6111 to 1 part 6121-F) *1:1:2 , (1 part 6111 to 1 part 6121-F to 2 parts Acetone)
POT LIFE:	Up to 5 days @ 70°F and 50% relative humidity Note: Store activated primer in a closed plastic container to avoid etching metal spray gun cups. * For compliance with Rule 1151.

REGULATORY:

Category: Primer 6111 & 6114	Individual Component	Ready to Use
VOC Actual	5.08#/gal (609g/l)	
VOC Regulatory	5.08#/gal (609g/l)	5.9 #/gal (708 g/l)
Weight % of Volatiles	52.92	
Weight % of Water	0	
Weight % of Exempt Compounds	0	
Volume % of Exempt Compounds	0	
Density of Material	9.6	
Category: Primer 6121-F & 6124-F	Individual Component	
VOC Actual	1.41#/gal (169g/l)	
VOC Regulatory	6.74#/gal (807g/l)	
Weight % of Volatiles	97.56	
Weight % of Water	0.4	
Weight % of Exempt Compounds	79.82	
Volume % of Exempt Compounds	78.69	
Density of Material	7.96	

COMPETITION:

DuPont Chroma Systems 615S/625S	Lesonal 072244	5 Star 5412/5413	Sikkens 680
Glasurit 283-150	Marhyde 5113	Valspar Sunlock II 88G016	Rubberseal RS786
Nex Autocolor (ICI) P565-713	Martin Senour 8847	Standex 11158	Nason 491-30
PPG Deltron/Concept DX1793	Matrix MP550	Spies Hecker 3688	SEM SE58
PPG Global D8099	Montana PS5625	DeBeer 1-15	RM Diamont DE17
Sherwin Williams E2G983			

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