

Technical Data Sheet

Kwik Seal 2K Urethane Sealer has been specifically formulated as a premium quality sealer to be used over a variety of substrates. Kwik Seal offers excellent adhesion to SMC, fiberglass, old paint finishes and all Transtar primers. Kwik Seal has excellent leveling and gloss hold out properties and is compatible with most basecoat/clearcoat and single stage systems. It is one of the most innovative products on the market today! Utilizing Transtar's "Star Shade" system, these colors can be intermixed at established ratios to create a wide variety of color offerings for optimum basecoat coverage.

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 maybe 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 Kwik Seal (6221/6224/6231/6234/6241/6244)
1 part 6254/6257 Kwik Seal Activator
1 part 6700 or 6700-F Series Urethane Grade Reducer*

Pot Life 2.5 hours (@70°F 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 5-10 minutes
Dry to Topcoat 20 minutes
Dry to Tape 30-45 minutes
Dry to Sand 45-60 minutes
Max recoat w/o sanding 3 hours

SURFACE PREPARATION



Finish sand all areas to be sealed with 400-600 grit.

Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry.

* 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 - 1.6	1.4 - 1.6
Air Pressure	10 PSI @ aircap	30 - 40 PSI @ gun inlet
Mil Thickness: 1.0 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 production 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	1.4-1.6 mm	1.4-1.6 mm	1.0-1.2 mm	1.2-1.6 mm
Air Pressure	40-50 PSI (@gun)	30-40 PSI (@ gun)	40-50 PSI (@ gun)	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: Solvent clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry with clean cloth.

Sanding: Steel*: Degreased and sanded with 80 - 120 grit dry. Aluminum*: Degreased and sanded with 180 - 200 grit dry. Existing Finishes: Degreased and sanded with 320 - 400 grit dry. Fiberglass & Gelcoat: Degreased and sanded with 220 - 320 grit dry. If the Gelcoat is broken use a polyester primer like Transtar's Kwik Fill 6451-G. All Transtar Primers: Degreased and sanded with 320 - 400 dry, 500 - 600 grit wet. OEM E-coats: Degreased and sanded with 320 - 400 grit dry.

*Kwik Seal will provide adequate adhesion to steel and aluminum. For areas larger than 1' x 1', Kwik Seal should be applied over Self Etching Primer 6111/6114 or Epoxy Primer 6100 Series.

TINTING & ADDITIVES

Tinting: Can be tinted up to 10% by volume with basecoat mixing toners. Or, use Transtar's "Star Shade" tint system for optimal hiding capabilities. This system utilizes white, black and gray sealers.

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 refer to TDS for mixing instructions.
DO NOT USE: Kicker (6417).

APPLICATION & FILM BUILD

Mixing: Mix 4 parts Sealer 6200 Series with 1 part activator 6254/6257 and 1 part of Urethane Grade Reducer 6700 or 6700-F Series suitable for shop conditions. Mix and strain before using.

Wet-on-wet application: Apply one full even wet coat to achieve 1.0 mils. Sealer should be topcoated within three hours to avoid adhesion problems. After three hours, scuff sand the sealer with a gray scuff pad or sand with 400-600 grit wet or dry, before applying sealer or basecoat color.

As a barrier coat: Kwik Seal can be used as a barrier coat to seal over troublesome substrates (ie old finishes). The barrier coat helps prevent lifting of existing finish by the basecoat upon base coat application. Apply 2-3 medium coats, allowing each coat to flash 5-10 minutes before applying the next coat. Allow to dry thoroughly and scuff or sand before applying topcoat. Note: For best results in temperatures above 85°F (29°C) or in high air flow spray booths, a narrow spray gun pattern will help prevent dry spray. Clean spray gun immediately after use.

Film Build: 1.0 mils per coat (dry film thickness)

Critical Recoat Time: Sealer should be topcoated within 3 hours to avoid adhesion problems. After 3 hours, scuff sand the sealer with gray scuff pad or sand (wet or dry) with 400-600 grit before applying more sealer or basecoat color. Topcoating without sufficient dry times may result in die-back. Denib with 1200-1500 wet, using a coarser grit could gouge the sealer.

PRODUCT SPECIFICATIONS

Weight per gallon: 6221/6224: 11.94, 6231/6234: 10.76, 6241/6244: 10.51	Shelf Life: 1 year
RTS Solids by Weight: 51%	Approximate Coverage: 560 ft ² /gal @ 1 mil
Color: White (6221/6224), Gray (6231/6234), Black (6241/6244)	Size: Gallon (6221/6231/6241), Quart (6224/6234/6244)

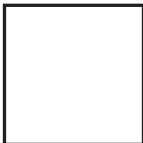
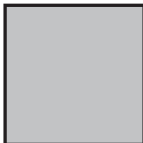





Recommendations:

- Topcoating without sufficient dry times may result in die-back.

REGULATORY

Category: Primer Sealer	6221/6224	6231/6234	6241/6244	6254/6257
VOC Actual	3.21#/gal (384 g/l)	3.16#/gal (378 g/l)	3.26#/gal (391 g/l)	5.31#/gal (637 g/l)
VOC Regulatory	3.72#/gal (445 g/l)	3.82#/gal (458 g/l)	3.89#/gal (466 g/l)	5.31#/gal (637 g/l)
Weight % of Volatiles	34.44	40.04	41.15	62.55
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	7.58	10.70	10.11	0
Volume % of Exempt Compounds	13.7	17.42	16.08	0
Density of Material #/gal	11.94	10.76	10.51	8.49
RTU Actual (6700 Series Reducers)	4.27#/gal (511 g/l)	4.23#/gal (507 g/l)	4.3#/gal (516 g/l)	
RTU Regulatory (6700 Series Reducers)	4.7#/gal (563 g/l)	4.79#/gal (574 g/l)	4.83#/gal (578 g/l)	
RTU Actual (6700-F Series Reducers)	3.02#/gal (362 g/l)	2.99#/gal (358 g/l)	3.06#/gal (367 g/l)	
RTU Regulatory (6700-F Series Reducers)	4.07#/gal (488 g/l)	4.17#/gal (500 g/l)	4.21#/gal (505 g/l)	

STAR SHADE MIX RATIOS

SS1	SS2	SS3	SS4	SS5	SS6	SS7
						
6221/6224 as packaged	2 parts 6221 1 part 6231	1 part 6221 2 parts 6231	6231/6234 as packaged	2 parts 6231 1 part 6241	1 part 6231 2 parts 6241	6241/6244 as packaged