

Technical Data Sheet

2K Kwik Prime is a two component primer surfacer that can be applied direct to metal surfaces. It is quick drying and easy to sand wet or dry. Kwik Prime provides corrosion protection along with excellent fill and build properties. This unique primer provides improvements in productivity and reduces cycle times while providing significant labor and material savings. Kwik Prime may be tinted using basecoat mixing toners.

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 (6441/6444)
1 part Activator (6454/6457)
1 part Urethane Grade Reducer (6700 or 6700-F Series)

High Build: 4 parts Primer (6441/6444)
1 part Activator (6454/6457)

Pot Life 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 2-5 minutes
Dry to Sand 1-2 hours
Dry to Recoat w/o Sanding 30 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 80-180 grit.

* For more information on surface prep and application refer to next page.

SPRAY GUN SET-UP/APPLICATION



Gun Type HVLV/LVLP Gravity Feed
Fluid Tip 1.4 - 1.8 mm 1.4 - 1.8 mm
Air Pressure 10 PSI @ aircap 35-45 PSI @ gun
Mil Thickness: 1.5 - 2.0 mils per coat @ 4:1:1 and 2.0 - 2.5 mils per coat @ 4:1 (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	1.4-1.8 mm	1.4-1.8 mm	1.0-1.2 mm	1.4-1.8 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 refinishing 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: Sand repair area with 80 grit followed by 120-180 grit. (Sand existing finishes with 180 grit). Featheredge all broken film areas. Wipe all sanded areas with SCAT and wipe dry with a clean cloth before applying Kwik Prime.

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) - Do not use.
Kicker (6417): Do not use.

APPLICATION & FILM BUILD

Activate primer according to mix ratios on page 1 dependant on your use (4:1 or 4:1:1). Keep activator tightly closed when not in use to avoid moisture contamination. Stir Kwik Prime thoroughly before use. Apply 2 - 3 medium wet coats, allowing 2 - 5 minutes flash time between coats, using the gun settings listed below. In temperatures below 68°F (20°C), allow a 10 - 15 minute flash time between coats to insure proper cure.

Film Build: 1.5 - 2.0 mils per coat @ 4:1:1 and 2.0 - 2.5 mils per coat @ 4:1 (dry film thickness)

PRODUCT SPECIFICATIONS

Weight per gallon: 11.72	Shelf Life: 1 year
RTS Solids by Weight: 4:1:1 - 52% 4:1 - 59%	Approximate Coverage: 4:1:1 - 503 ft ² /gal @ 1 mil 4:1 - 604 ft ² /gal @ 1 mil
Color: Light Gray	Size: Primer - Gallon (6441), Quart (6444) Activator - Quart (6454), ½ Pint (6457)

REGULATORY

Category: Primer	6441/6444	6454/6457	RTU VOC Actual (4:1)	3.5#/gal (413 g/l)
VOC Actual	2.84#/gal (341 g/l)	5.9#/gal (705 g/l)	RTU VOC Regulatory (4:1)	4.1#/gal (494 g/l)
VOC Regulatory	3.57#/gal (428 g/l)	5.9#/gal (705 g/l)	RTU VOC Actual (4:1:1) (6700 Series)	4.12#/gal (494 g/l)
Weight % of Volatiles	35.74	76.32	RTU VOC Regulatory (4:1:1) (6700 Series)	4.77#/gal (571 g/l)
Weight % of Water	0	0	RTU VOC Actual (4:1:1) (6700-F Series)	3.88#/gal (345 g/l)
Weight % of Exempt Compounds	11.48	0	RTU VOC Regulatory (4:1:1) (6700-F Series)	4.12#/gal (494 g/l)
Volume % of Exempt Compounds	20.35	0		
Density of Material #/gal	11.72	7.71		

Recommendations:

- Kwik Prime will provide excellent adhesion and protection if applied direct to bare steel.
- Observe flash times to provide good cure times, reduce shrinkage and avoid solvent pop.
- On featheredge areas, it is best to use a sealer to prevent lifting by basecoats.

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