



## 2K Kwik Prime

### 6441, 6444

**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. It 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. Can be tinted using basecoat mixing toners.**



#### Mix Ratio

4:1:1 - 4 parts primer to 1 part activator to 1 part reducer\*

High build 4:1 - 4 parts primer to 1 part activator

Pot life: 3 hrs (@70°F (21°C) and 50% R.H.)

\* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.



#### Suitable Substrates

- Bare steel
- Primer - self-etching
- Fiberglass/SMC gel coat
- Plastic part - primed
- Bare galvanized
- 1K primer
- Body filler
- OEM finish & old paint work - non-reversible
- Bare aluminum
- 2K primer
- OEM E-Coat

*Note: Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.*

*Note: Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.*



#### Surface Prep & Application

**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.

**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.

**Application:** 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 (dry film thickness). Do not exceed 6 mils dry film thickness total.

**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.

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

Fisheye Remover (6737) .. Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.

Flex Additive (9194) ..... Do not use.



**Flash Times/Dry Times**

Flash between coats.....2-5 min

Dry to sand.....1-2 hrs

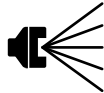
Dry to recoat w/o sand...30 min

Force drying.....30 min @ 140°F (60°C)



**Gun Set-up**

Siphon feed.....	1.4 - 1.8 mm	Gravity feed.....	1.4 - 1.8 mm
Pressure feed .....	1.0 - 1.2 mm	HVLP/LVLP .....	1.4 - 1.8 mm



**Air Pressure**

Siphon feed (@ gun) .....	40 - 50 psi	Gravity feed (@ gun) .....	35 - 45 psi
Pressure feed (@ gun).....	40 - 50 psi	HVLP/LVLP (@ aircap).....	10 psi

**Fluid Pressure**

Pressure feed .....8 - 10 psi



**Product Specifications**

Color (6441/6444).....	Light gray	Size (6441).....	Gallon
(6454/6457).....	Activator	(6444/6454).....	Quart
RTS solids by weight (4:1:1) ..	52%	(6457).....	1/2 pint
(4:1).....	59%	Weight per gallon.....	11.72 #/gal
Approx. coverage (4:1:1) .....	503 ft <sup>2</sup> /gal @ 1 mil	Shelf life.....	3 years
(4:1).....	604 ft <sup>2</sup> /gal @ 1 mil		

**Regulatory**

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Category.....	Primer	Wt % of volatiles.....	35.74
VOC actual.....	2.84#/gal (341 g/l)	Wt % of water .....	0
VOC regulatory.....	3.57#/gal (428 g/l)	Wt % of exempt compound .....	11.48
Density.....	11.72 #/gal	Vol % of exempt compound .....	20.35
Regulatory ready to use			
4:1 .....	4.12#/gal (494 g/l)		
4:1:1 w/6700 series.....	4.77#/gal (571 g/l)		
4:1:1 w/6700-F series.....	4.12#/gal (494 g/l)		

6454, 6457

Category .....	Primer	Wt % of volatiles.....	76.32
VOC actual .....	5.9#/gal (705 g/l)	Wt % of water .....	0
VOC regulatory .....	5.9#/gal (705 g/l)	Wt % of exempt compound .....	0
Density .....	7.71 #/gal	Vol % of exempt compound .....	0



**Limitations & Precautions**

- Primer must be shaken for a minimum of 10 minutes.
- 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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- See website ([www.tat-co.com](http://www.tat-co.com)) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

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