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# PRODUCT DATA

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## 6464, 6477 Roll-It Primer

### DESCRIPTION:

Transtar 6464 Roll-It Primer is a two-component primer designed for application by an ultra-fine polyurethane foam roller. This product can be applied direct-to-metal, and eliminates the need for a self-etch primer. It allows for non-spray application of the primer, which eliminates paint overspray issues on jobs that are done outside the booth. Roll-It Primer is fast drying, and has good flow out properties. It is tintable tint paste or basecoat.

### TECHNICAL DATA:

APPEARANCE:	Light Gray
MIX RATIO:	4:1 with Roll-It Activator 6477 (4 parts primer to 1 part activator) by volume
% SOLIDS (WEIGHT):	57%
REDUCTION:	Not required. If conditions dictate (ex. high temperatures), reduce up to 10% using Transtar Urethane Grade Reducer. (Note: adding reducers will increase V.O.C.)
V.O.C. CONTENT:	4.6#/gallon (552 g/l) Ready To Roll
POT LIFE:	3 hours @ 70° F (21° C) and 50% Relative Humidity
FILM BUILD:	0.8 - 1.2 mils per coat
COVERAGE:	575 sq. ft. (@ 1 mil DFT)

### SALES POINTS:

- Eliminates paint booth bottlenecks.
- Less material waste. Primer goes on the vehicle, not into the air.
- No more paint over spray!
- Unnecessary to mask the entire car or surrounding cars, just spot mask the area of the repair.
- Saves money on tape and masking paper.
- 1 step, direct to metal.
- No spray gun clean up!
- Ideal for spot and panel refinishing.
- Easy to sand, wet or dry.
- Fast drying.
- May be tinted using tint paste or basecoat
- Excellent fill and leveling properties.
- Improves efficiency and reduces cycle time.
- Isocyanate-free
- Can be sprayed if desired.

### SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS

*(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin).*

### PACKAGE SIZE:

- #6464 Roll-It Primer, Quart, 6/case
- #6477 Roll-It Activator, ½ Pint, 12/case
- #6590 Extra Fine Foam Roller (10 pack), 4", 10/case
- #6591 Extra Fine Foam Roller (10 pack), 2", 10/case
- #6592 Roller Handle, 10/case
- #6593 Paint Roller Tray, 6" x 11", 10/case



# 6464, 6477 Roll-It Primer

## **SUITABLE SUBSTRATES:**

Steel & aluminum      Body Fillers      Galvanized steel      SMC  
Fiberglass              Degreased & sanded existing finishes      1K and 2K Transtar Primers

## **SURFACE PREPARATION:**

1. Before sanding, wash all surfaces with soap and water. Rinse well and dry with a clean cloth. Solvent clean the area using SCAT #6311 or Speedi SCAT #6321/6323, and wipe dry with a clean cloth.
2. Sand bare metal with 80 grit sandpaper. Sand repair area with 120-180 grit, followed by 220-320 grit. Feather-edge all broken film areas. Solvent clean the area using SCAT #6311 or Speedi SCAT #6321/6323, and wipe dry with a clean cloth before applying Roll-It Primer.

## **APPLICATION:**

Activate Roll-It Primer at a ratio of 4:1 (by volume; four parts primer #6464 to one part activator #6477). Mix thoroughly before using.

Pour mixed material into roller tray. Dip roller into primer and roll over ridges in paint tray to work primer into the applicator and to remove any excess material. Apply an even coat of primer using roller to smooth out the application. Apply the first coat all the way out to the clearcoat featheredge. Feather-out the edges of this first coat by re-rolling to the edge without applying additional primer.

Flash for 5 - 10 minutes. Apply the second coat to within 1 inch of the outside edge of the first coat. If a third coat is desired, flash 5 - 10 minutes and roll to within 1 inch of the second coat edge. For best results, do not apply more than three even coats. Film build should be approximately 3 - 5 mils DFT. Avoid over application of primer.

*Tinting:* Roll-It Primer can be tinted up to 5% by volume using tint paste, or up to 10% by volume using basecoat mixing toners for optimal hiding capabilities. For best results, activate primer before tinting.

## **CLEAN UP:**

Wash the foam roller immediately after use with a solvent/gun thinner.

Note: The foam roller will expand from the absorption of solvents during cleaning, but will return to its original size and shape when dry.

## **DRY TIMES:**

<u>Temperature</u>	<u>Dry Time To Sand</u>
70°F	1.5 - 2 hours
85° - 90°F	1 hour
140°F (bake)	30 minutes

## **SANDING:**

Dry: Pre-sand with 220 grit, finish with 320 - 400 grit  
Wet: Pre-sand with 400 grit, finish with 500 - 600 grit.

## **COMPETITION:**

We are not aware of another product like this primer in the professional refinish market!

*DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Transtar Autobody Technologies experience and research and is believed to be reliable. As Transtar has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.*