



2K Acrylic Urethane Prime 6561, 6564

2K Acrylic Urethane Primer is a premium lead/chrome free two component acrylic urethane primer surfacer. It provides exceptional fill and build and provides a base which yields excellent top coat hold out, gloss and D.O.I. 2K Acrylic Urethane Primer sands easily wet or dry and can be directly topcoated with alkyd enamels, acrylic enamels, lacquers, acrylic urethane enamels and basecoat/clearcoat systems.



Mix Ratio

As a primer 4:1 - 4 parts primer to 1 part activator

As a sealer 4:1:1/2 - 2 - 4 parts primer to 1 part activator to 1/2 up to 2 parts reducer*

Pot life: 2-3 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

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

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: *Bare steel, aluminum and galvanized metal:* Must be primed with Self Etch Primer 6111/6114 or Epoxy Primer 6100 Series.

OEM and refinish paints and lacquers: Must be cured and sanded. Refinish lacquers require entire panel repair.

Body filler, fiberglass, SMC: Must be sanded.

As a sealer: Sanded and degreased existing finish and primers.

Application: *Primer:* Stir 2K Acrylic Urethane Primer thoroughly before use. Mix 4 parts primer to 1 part activator. Apply 2 -3 medium wet coats, allowing 10 - 15 minutes flash time between coats.

Non-Sanding Sealer: Mix 4 parts primer to 1 part activator to 1/2 part reducer or up to 2 parts zero VOC reducer. Apply 1 medium wet coat. Flash for 20 minutes before topcoating. If applying 2 coats of 6561, flash for 30 minutes before topcoating. Denib with 600 wet or dry. After two hours, it will be necessary to sand the sealer with 500-600 grit sandpaper to ensure good basecoat adhesion.

Film build: 1.5-2.0 mils per coat (dry film thickness). Do not exceed 6 mils dry film thickness total.

Tinting & Additives

TintingNot recommended.
 Kicker (6417)Can be used at a rate of 1/2 oz per sprayable quart.
 Accelerated products should never be used direct-to-metal.
 Fisheye Remover (6737) ..Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.
 Flex Additive (9194)May be used, refer to TDS for mixing recommendations.



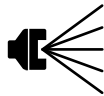
Flash Times/Dry Times

As a primer
 Flash between coats..... 10-15 min
 Dry to sand..... 1-3 hrs
 Force drying 30 min @ 140°F (60°C)
 As a sealer
 To recoat 20 min
 Denib 20-30 min
 Dry to recoat w/o sand... 2 hrs
 Force drying 30 min @ 140°F (60°C)



Gun Set-up

Siphon feed.....	1.6 - 2.0 mm	Gravity feed.....	1.6 - 1.8 mm
Pressure feed	1.0 - 1.2 mm	HVLP/LVLP	1.6 - 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 (6561/6564).....	Light gray	Size (6561).....	Gallon
(6584/6587).....	Activator	(6564/6584).....	Quart
RTS solids by weight (primer) .	58%	(6587).....	1/2 pint
(sealer) ..	55%	Weight per gallon.....	12.17 #/gal
Approx. coverage (primer) ..	717 ft ² /gal @ 1 mil	Shelf life	3 years
(sealer) ...	665 ft ² /gal @ 1 mil		

Regulatory

6561, 6564

Category	Primer	Wt % of volatiles.....	35.34
VOC actual	1.39#/gal (167 g/l)	Wt % of water	0
VOC regulatory	2.25#/gal (268 g/l)	Wt % of exempt compound	23.92
Density.....	12.17 #/gal	Vol % of exempt compound	37.79
Regulatory ready to use			
4:1	2.07#/gal (248 g/l)		
4:1:1/2 w/6700 series	2.88#/gal (345 g/l)		
4:1:1 w/6700-F series	2.07#/gal (248 g/l)		

6584, 6587

Category	Primer	Wt % of volatiles.....	70.72
VOC actual	0.34#/gal (41 g/l)	Wt % of water	0
VOC regulatory	0.94#/gal (113 g/l)	Wt % of exempt compound	67.47
Density	10.52 #/gal	Vol % of exempt compound	63.73



Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- Observe flash times to provide good cure times to reduce shrinkage.
- Best adhesion results are achieved if topcoated within 8 hours, best holdout is achieved if primer is allowed to cure overnight.
- When using over lacquer, always complete the entire panel. Spot repairs may lift around the repair.
- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (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.

LIMITED WARRANTY

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