



2K Acrylic Urethane Primer 6921

2K Acrylic Urethane Primer is a premium lead/chromate free, two component acrylic urethane primer-surfacer for basecoat/clearcoat refinishing. It provides excellent fill and build characteristics, and sands easily wet or dry without clogging. It provides an excellent base for your top coat, thus offering excellent topcoat holdout, gloss and D.O.I.



Mix Ratio

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

Pot life: 1-2 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
- Raw plastic - rigid (SMC, BMC)
- Body filler
- OEM finish & old paint work - reversible and non-reversible

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: If necessary, sand repair with 80 grit, followed by 180 grit to feather edge all broken film areas.

Note: Treat bare metal with appropriate metal conditioner or Transtar's Self Etching Primer 6111/6114.

Application: Stir 2K Acrylic Primer thoroughly before activating (preferably by mechanical agitation). Mix 4 parts primer 6921 to 1 part activator 6934/6937 to 1 part reducer 6700 or 6700-F Series (depending on shop temperature) by volume. Apply 1 - 3 medium wet coats allowing 10-15 minutes flash between coats (1.5 - 2.0 mils per coat).

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, for use as a specialty coating for elastomeric substrates, refer to 9194 TDS for mixing recommendations.



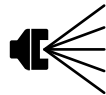
Flash Times/Dry Times

Flash between coats..... 10-15 min
 Dry to sand..... 1.5-2.5 hrs
 Max recoat time..... 20 min to 2 hrs
 Force drying..... 30 min @ 140°F (60°C) after air drying for 20-30 min



Gun Set-up

Siphon feed.....	1.6 - 2.0 mm	Gravity feed.....	1.6 - 2.0 mm
Pressure feed	1.0 - 1.2 mm	HVLP/LVLP	1.6 - 1.8 mm



Air Pressure

Siphon feed (@ gun)	35 - 45 psi	Gravity feed (@ gun)	25 - 35 psi
Pressure feed (@ gun).....	40 - 50 psi	HVLP/LVLP (@ aircap).....	10 psi

Fluid Pressure

Pressure feed



Product Specifications

Color (6921).....	Light gray	Size (6921).....	Gallon
(6934/6937).....	Activator	(6934).....	Quart
RTS solids by weight.....	64%	(6937).....	1/2 pint
Approx. coverage (primer) ..	525 ft ² /gal @ 1 mil	Weight per gallon.....	12.5 #/gal
Shelf life.....	3 years		

Regulatory

6921

Category.....	Primer	Wt % of volatiles.....	31.07
VOC actual.....	3.98#/gal (477 g/l)	Wt % of water	0
VOC regulatory.....	3.98#/gal (477 g/l)	Wt % of exempt compound	0
Density.....	12.8 #/gal	Vol % of exempt compound	0
Regulatory ready to use			
4:1:1 w/6700 series.....	4.76#/gal (571 g/l)		
4:1:1 w/6700-F series.....	4.23#/gal (507 g/l)		

6934, 6937

Category	Primer	Wt % of volatiles.....	68.75
VOC actual	5.24#/gal (628 g/l)	Wt % of water	0
VOC regulatory	5.24#/gal (628 g/l)	Wt % of exempt compound	0
Density	7.63 #/gal	Vol % of exempt compound	0



Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- Excessive application will extend dry times.
- If Primer is allowed to dry overnight, scuff sand before recoating.
- Primer should not be mixed with other primer surfacers. Keep container closed when not in use. Do not transfer contents to other containers for storage.
- 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.

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