

Technical Data Sheet

2K Acrylic Urethane Primer is a premium lead/chromate free, two component acrylic urethane primer-surfacer for basecoat/clearcoat refinishing. Acrylic Urethane Primer provides excellent fill and build characteristics, and sands easily wet or dry without clogging. 6921 provides an excellent base for your top coat, thus offering excellent topcoat holdout, gloss and D.O.I. Acrylic Urethane Primer can be directly top coated with alkyd enamels, acrylic enamels, urethane enamel basecoat/clearcoat systems and lacquers.

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 (6921)
1 part Activator (6934/6937)
1 part Urethane Grade Reducer (6700 or 6700-F Series)

Pot Life 1-2 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 10-15 minutes
Dry to Sand 1.5-2.5 hours
Max Recoat Time 20 minutes to 2 hours
Force Drying 30 minutes @140°F (60°C), after air drying for 20-30 minutes.

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 HVLP/LVLP Gravity Feed
Fluid Tip 1.6 - 1.8 mm 1.6 - 2.0 mm
Air Pressure 10 PSI @ aircap 25-35 PSI @ gun
Mil Thickness: 1.5 - 2.0 mils per coat (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	1.6-2.0 mm	1.6-2.0 mm	1.0-1.2 mm	1.6-1.8 mm
Air Pressure	35-45 PSI (@gun)	25-35 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10-14 PSI	N/A

Always refer to gun manufacturer's recommendation for proper set up and spray pressure.

SURFACE PREPARATION

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.

TINTING & ADDITIVES

Tinting: Not recommended.

Additives: Fisheye Remover (6737) - Can be used at a rate of ¼ to ½ oz per sprayable quart.

Universal Urethane Flex Additive (9194) - May be used, for use as a specialty coating for elastomeric substrates, refer to 9194 TDS for mixing recommendations.

Kicker (6417): Can be used at a rate of ½ oz per sprayable quart. Accelerated products should never be used direct-to-metal.

APPLICATION & FILM BUILD

Primer: 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). For best results, do not exceed 6 mils dry film thickness total.

PRODUCT SPECIFICATIONS

Weight per gallon: 12.5	Shelf Life: 1 year
RTS Solids by Weight: 64%	Approximate Coverage: 525 ft ² /gal @ 1 mil.
Color: Light Gray	Size: Primer - Gallon (6921) Activator - Quart (6934), ½ Pint (6937)

REGULATORY

Category: Primer	6921	6934/6937	RTU VOC Actual (4:1:1) (6700 Series)	4.76#/gal (571 g/l)
VOC Actual	3.98#/gal (477 g/l)	5.24#/gal (628 g/l)	RTU VOC Regulatory (4:1:1) (6700 Series)	4.76#/gal (571 g/l)
VOC Regulatory	3.98#/gal (477 g/l)	5.24#/gal (628 g/l)	RTU VOC Actual (4:1:1) (6700-F Series)	3.53#/gal (422 g/l)
Weight % of Volatiles	31.07	68.75	RTU VOC Regulatory (4:1:1) (6700-F Series)	4.23#/gal (507 g/l)
Weight % of Water	0	0		
Weight % of Exempt Compounds	0	0		
Volume % of Exempt Compounds	0	0		
Density of Material #/gal	12.8	7.63		

Recommendations:

- 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.

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