

# Technical Data Sheet

Euro Classic Primer 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. This primer can also be tinted using Transtar's exclusive "Star Shade" system for a better match.

## 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: 4:1  
As a Primer 4 Part Primer (7241, 7244, 7261, 7264, 7271, 7274)  
Surfacer 1 part Activator (7254, 7257)

By Volume 4:1:1  
As a Primer 4 Part Primer (7241, 7244, 7261, 7264, 7271, 7274)  
Sealer 1 part Activator (7254, 7257)  
1 part Urethane Grade Reducer (6700-F Series)

Pot Life 2 hours (@77°F (25°C) and 50% relative humidity)

\* Use reducer according to shop conditions. For tinting instructions and the use of additives, please refer to next page.

## FLASH TIMES/DRY TIMES



Flash Between Coats 5-10 minutes  
Dry to Sand 1-6 hours  
Dry to Recoat w/o Sanding 20 minutes up to 4 hours  
Force Drying 30 minutes @140°F (60°C)

## SURFACE PREPARATION



Wash surface with soap and washer. Rinse well and wipe dry with a clean cloth. Solvent clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry. See next page for sanding information.

\* 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 1.4 - 1.8 mm 1.4 - 1.8 mm  
Air Pressure 10 PSI @ aircap 30-40 PSI @ gun  
Mil Thickness: 1.5-2.5 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 production application.

# Technical Data Sheet

## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.8 mm	1.4-1.8 mm	1.0-1.2 mm	1.4-1.8 mm
Air Pressure	40-50 PSI (@gun)	30-40 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10 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:** Steel and galvanized should be sanded using an 80 grit abrasive. Aluminum should be sanded with 150-180 grit abrasive. Body filler should be sanded with 80 grit followed by 120-180 grit abrasive. Featheredge all broken film areas. Unsanded E-coat, clean the surface, apply the Euro Primer either as a non-sanding sealer with reduction or as a surfacer. As a sealer: For existing finishes, sand with 400-600 grit. If using as a non-sanding sealer, wait 20-30 minutes before topcoating.

## TINTING & ADDITIVES

**Tinting:** Can be tinted up to 10% by volume with basecoat mixing toners. Use Transtar's "Star Shade" tint system for optimal hiding capabilities. This system utilizes black, white, and gray primers. See chart below for more details.

**Additives:** Fisheye Remover (6737) - Can be used at a rate of ¼ to ½ oz per sprayable quart.  
Universal Urethane Flex Additive (9194) - Do not use.  
Kicker (6417): Do not use.

## APPLICATION & FILM BUILD

**As a primer surfacer:** Stir primer thoroughly before use. Mix 4 parts primer 7200 series with 1 part activator 7254/7257. Apply 2 - 3 medium wet coats, allowing 5 - 10 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.








**As a sealer:** Stir primer thoroughly before use. Mix 4 parts primer with 1 part activator 7254/7257 with 1 part Urethane Grade Reducer (6700 or 6700-F Series). Flash 20-30 minutes and no longer than 4-6 hours before topcoating.

**Film Build:** 1.5-2.5 mils per coat (dry film thickness)

## PRODUCT SPECIFICATIONS

Weight per gallon: 12.31	Shelf Life: 1 year
RTS Solids by Weight: 4:1 - 62%   4:1:½ - 58%   4:1:1 - 55%	Approximate Coverage: 4:1 - 650 ft <sup>2</sup> /gal @ 1 mil 4:1:½ - 590 ft <sup>2</sup> /gal @ 1 mil   4:1:1 - 541 ft <sup>2</sup> /gal @ 1 mil
Color: White (7261/7264), Gray (7241/7244), Black (7271/7274), Activator (7254/7257)	Size: Gallon (7241/7261/7271), Quart (7244/7254/7264/7274), ½ pint (7257)

## STAR SHADE MIX RATIOS

SS1	SS2	SS3	SS4	SS5	SS6	SS7
						
7261/7264 as packaged	2 parts 7261 1 part 7241	1 part 7261 2 parts 7241	7241/7244 as packaged	2 parts 7241 1 part 7271	1 part 7241 2 parts 7271	7271/7274 as packaged

### Recommendations:

- 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.
  - On featheredge areas, to prevent lifting of basecoats you can also seal with a coat of 7300 Series Euro Classic DTM Primer mixed 4:1:1.
- Visit [www.tat-co.com](http://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).

# Technical Data Sheet

## REGULATORY

Category: Primer/Primer Sealer*	7241/7244	7261/7264	7271/7274	7254/7257
VOC Actual	4.0#/gal (479 g/l)	3.97#/gal (476 g/l)	3.92#/gal (469 g/l)	5.88#/gal (705 g/l)
VOC Regulatory	4.0#/gal (479 g/l)	3.97#/gal (476 g/l)	3.92#/gal (469 g/l)	5.88#/gal (705 g/l)
Weight % of Volatiles	32.46	32.27	32.51	76.32
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	0	0	0	0
Volume % of Exempt Compounds	0	0	0	0
Density of Material #/gal	12.31	12.31	12.05	7.71
VOC Actual RTS (4:1)	4.37#/gal (524 g/l)	4.36#/gal (522 g/l)	4.31#/gal (516 g/l)	
VOC Regulatory (4:1)	4.37#/gal (524 g/l)	4.36#/gal (522 g/l)	4.31#/gal (516 g/l)	
VOC Actual RTS (4:1:1) 6700-F Series Reducer	3.65#/gal (437 g/l)	3.63#/gal (435 g/l)	3.59#/gal (430 g/l)	
VOC Regulatory (4:1:1) 6700-F Series Reducer	4.37#/gal (524 g/l)	4.36#/gal (522 g/l)	4.13#/gal (516 g/l)	

\*The use of 6700 Series Reducer with mixing this as a primer sealer (4:1:1) puts it over the limit for use in the US. If reducing to use as a primer sealer, 6700-F series reducers must be used to be compliant.