

Technical Data Sheet

Transtar's Polyurethane Topcoat (Anti-Sag) is a unique high performance topcoat with superior chemical resistance and outstanding durability. Formulated with a specially modified polymer and Anti-Sag Technology, this product allows for fast, easy 1-coat application eliminating runs and sags. This is an exceptional product for fleet refinishing, OEM manufacturing, general aviation, pleasure marine and for other performance demanding markets such as industrial, general metal and specialty industrial maintenance applications. This highly productive, easy to apply coating meets the demanding requirements of today's market. 8600 Series is available in both 3.5 and 2.8 VOC for air quality regulatory compliance.

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 ✓
Sanded OEM E-Coat**	Plastic Part - Primed ++	OEM Finish & Old Paint Work - Reversible
Fiberglass/SMC 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 maybe 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: 3:1 (3 quarts paint to 1 quart of activator)

Pot Life 2 hours (@68°F (20°C) and 50% relative humidity)

FLASH TIMES/DRY TIMES



@70°F (21°C) and 50% RH With 8704 Urethane Accelerator

Dust Free 20 minutes 20 minutes

Tack Free 3 hours 1.5 hours

Tape Time 12 hours 3 hours

Dry Time 12 hours 8 hours

Force Dry May be force dried for 20 minutes @ 140°F (60°C). Allow a 10 minute cool down before handling and a 1 hour cool time before sanding and polishing.

SURFACE PREPARATION



Clean substrate with Aqua SCAT 2 1391/1394 then sand. See surface preparation for exact sanding recommendations.

* 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 - 1.7 1.4 - 1.7

Air Pressure 10 PSI @ aircap 40 - 65 PSI

Mil Thickness: 1.5 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.
- 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	HVLP/LVLP
Fluid Tip	1.4 - 1.7 mm	1.4 - 1.7 mm	1.4 - 1.7 mm
Air Pressure	40 - 65 PSI	40 - 65 PSI	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	N/A

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

SURFACE PREPARATION

Cleaning: Clean substrate with Aqua SCAT 2 1391/1394

Sanding: Dry sand (DA) using 320-500 grit paper; if wet sanding, use 500-800 grit paper. The existing finish must be tightly adhered to the substrate. Best results are achieved when topcoat is sprayed over properly applied two component primer, such as Transtar's Kwik Prime 6441/6444, EZ Sand Primer 6401/6404 or any of Transtar's Star Shade Sealer Systems.

ADDITIVES

Additives: Fisheye Remover (6737) - Use 1 oz per ready to spray gallon of topcoat.
 Universal Urethane Flex Additive (9194) - Do not use.
 Kicker (6417) - Do not use.
 Topcoat Accelerator (8704) - Use 8 oz per ready to spray gallon of topcoat.

APPLICATION & FILM BUILD

Mixing: Stir thoroughly to ensure uniform mixture. Mix 3 parts Polyurethane Topcoat with 1 part Polyurethane Topcoat Activator 8604, (3 quarts topcoat to 1 quart activator). Reduction is not necessary. However, paint may be reduced up to 10% by volume using Transtar's Urethane Grade Reducer that is appropriate for the shop temperature.

Application - "Solid Colors": Apply using 40-55 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max (at aircap) for HVLP spray guns. Apply a light tack coat and 2-3 medium wet coats until desired coverage and flow is reached. Allow a 5-10 minute flash time between coats.

Application - "Metallic/Iridescent Colors": Apply using 55-65 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max (at aircap) for HVLP spray guns. Apply a light tack coat and 2-3 medium wet coats until desired coverage and flow is reached. Allow a 5-10 minute flash time between coats.

Application - "Clearcoat" (Optional Step): Acrylic Polyurethane Topcoat can be clearcoated with any of Transtar's 2K Acrylic Urethane Clearcoats. Allow color to flash 15 minutes. Mix clear as per label instructions. Follow clearcoat label and datasheet instructions for proper flash times and other application information.

PRESSURE POT APPLICATION: Set fluid delivery at 18-22 ounces per minute. Follow atomizing air and application instructions.

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

Critical Recoat Time: Polyurethane Topcoat may be recoated with itself at any stage of drying. Sanding will become necessary after 24 hours.

PRODUCT SPECIFICATIONS

Weight per gallon: 8.25 #/gal	Shelf Life: 1 year
RTS Solids by Weight: 37%	Approximate Coverage: 603 ft ² /gal @ 1 mil
Color: Various colors available, contact TM for more details	Size: 3/4 Gallon (8600 Series), Quart - Activator (8604)

REGULATORY

Category: Single Stage Coating	8600 Series	8604	RTU VOC Actual	2.72#/gal (326 g/l)
VOC Actual	3.63#/gal (435 g/l)	0.00#/gal (0g/l)	RTU VOC Regulatory	3.46#/gal (414 g/l)
VOC Regulatory	4.11#/gal (493 g/l)	0.00#/gal (0g/l)		
Weight % of Volatiles	60.00	53.27		
Weight % of Water	0	0		
Weight % of Exempt Compounds	16.00	53.27		
Volume % of Exempt Compounds	12.00	49.37		
Density of Material #/gal	8.25	10.32		

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