

PRODUCT HIGHLIGHTS

9471, 9474, 9484, 9487 Speed Primer

DESCRIPTION:

Signature Series Speed Primer is a premium, 2K urethane primer surfacer that covers in as little as two coats and air dries in 30 minutes under ideal conditions! This easy-to-sand primer surfacer can be applied directly to metal, provides excellent gloss holdout and is highly resistant to film shrinkage. Save 30-40% on your entire labor process time when used in conjunction with Transtar's No Mix[®] Low VOC Basecoat and Signature Series Speed Clearcoat.

PRODUCTS:

- 9471 Speed Primer, Gallon (3.78 L), 2/case
- 9474 Speed Primer, Quart (0.946 L), 6/case
- 9484 Speed Primer Activator, Quart (0.946 L), 6/case
- 9487 Speed Primer Activator, 1/2 Pint (236 ml), 12/case



SURFACE PREP:

Depending on surface, see surface preparation for sanding recommendations.
Clean with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225).



MIX RATIO:

4:1 - 4 parts primer to 1 part activator
Pot Life: 2 - 3 hours @ 70°F (21°C) and 50% R.H.



REDUCER:

Optional: Up to 10% Zero VOC Urethane Grade Reducer (TDS601) or Urethane Grade Reducer (TDS600).
Note: Using regular Urethane Grade Reducer (TDS600) will increase VOCs.



HVLP/LVLP:

1.4 - 1.8 mm



2 - 3 medium wet coats

5 - 10 minute flash

1.8 - 2.5 mils per coat (dry film thickness, based on spray equipment and technique)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

>60°F (15°C)	60-70°F (15-21°C)	70-80 °F (21-26°C)	80-100°F (26-38°C)	140°F (60°C) (force dry)
60 minutes	45 minutes	30 minutes	25 minutes	15 minutes



SANDING:

DA (Dry): #220, finish #320-400

Hand (Wet): #400, finish #500-600

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See next page for more detailed product application. See website for this document in other languages.
Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

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SUITABLE SUBSTRATES:

Steel: Primer will provide adequate adhesion and corrosion protection when applied directly to bare steel. However, for larger areas we recommend priming with Transtar Self Etch Primer (TDS209), Epoxy Primer (TDS208) or Hydrobase® DTM Primer (TDS228).

Aluminum and Galvanized Metals: Must be primed with Transtar Self Etch Primer (TDS209), Epoxy Primer (TDS208) or Hydrobase DTM Primer (TDS228).

OEM and Refinish Paints: Must be cured and sanded. Refinish lacquers require entire panel repair. Not recommended for spot repairs over lacquers as lifting may occur.

Body Filler, Fiberglass, SMC: Must be sanded with 150 – 240 grit.

SURFACE PREPARATION:

Wash all surfaces thoroughly with soap and water. Rinse well and dry with a clean cloth. Clean area with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225) and wipe dry with a clean cloth. Sand repair area with 80 grit followed by 180 grit. (Sand existing finishes with 180). Featheredge all broken film areas. Wipe all sanded areas with SCAT and wipe dry with a clean cloth before applying primer.

APPLICATION & MIXING:

Stir primer thoroughly before use. Mix 4 parts primer #9471 with 1 part activator #9484. Apply 2 - 3 medium wet coats, allowing 5 - 10 minutes flash time between coats, using the gun settings listed below. Film build is approximately 1.8 - 2.5 mils per coat (dry film thickness). Note: For best results, do not exceed 6 mils dry film thickness total. In temperatures below 68°F (20°C), allow a 10 - 15 minute flash time between coats to ensure proper cure.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE
Siphon HVLP	1.4 - 1.8 mm	10 PSI (at gun)
Gravity HVLP	1.4 - 1.8 mm	10 PSI (at gun)
Conventional	1.4 - 1.8 mm	35 - 50 PSI (at gun)
LVLP	1.4 - 1.8 mm	9.6 PSI max. (at aircap)

TECHNICAL DATA:

APPEARANCE:	Gray
% SOLIDS:	59.54% by weight
SHELF LIFE:	One year (unopened)
MIX RATIO:	4:1
REDUCER:	Optional. Up to 10%
POT LIFE:	2 - 3 hours @ 70°F (21°C) and 50% Relative Humidity
FILM BUILD:	1.8 - 2.5 mils per coat
FORCE DRYING:	15 min @ 140°F (60°C)
COVERAGE @ 1 mil:	566ft ² /gal

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REGULATORY:

Category: Primer 9471 & 9474	Individual Component	Ready to Use
VOC Actual	0.6#/gal (74 g/l)	0.6#/gal (74 g/l)
VOC Regulatory	1.3#/gal (152 g/l)	1.3#/gal (153 g/l)
Weight % of Volatiles	40.57	
Weight % of Water	0	
Weight % of Exempt Compounds	35.20	
Volume % of Exempt Compounds	51.69	
Density of Material	11.41	

Category: Primer 9484 & 9487	Individual Component
VOC Actual	0.56#/gal (67 g/l)
VOC Regulatory	1.29#/gal (155 g/l)
Weight % of Volatiles	65.26
Weight % of Water	0
Weight % of Exempt Compounds	59.61
Volume % of Exempt Compounds	57.01
Density of Material	9.84

TECHNICAL TIPS:

TOPCOATING:

Follow topcoat manufacturer's instructions for proper topcoat procedures. Sealing is not required.

PERFORMANCE ADDITIVES

6417 Kicker (TDS700) – Do not use.

6737 Fisheye Remover (TDS703) – Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.

9194 Universal Urethane Flex Additive (TDS711) – Do not use.

ADVANTAGES:

- Air dries in 30 minutes
- Highly flexible - compatible with metal and plastic
- Exceptional gloss holdout
- Highly resistant to film shrinkage
- High solids for a superior build
- Easy-to-sand
- Low VOC formula is compliant across North America

COMPETITION:

SW P30, Speed P30 Spectra Prime®