

Technical Data Sheet

Signature Series Speed Primer is a premium, 2K urethane primer surfacer that has excellent fill and build properties 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.

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: 4:1:1
4 Part Primer (9471, 9474)
1 part Activator (9484, 9487)
1 part Reducer (6700 or 6700-F Series)

Pot Life 2-3 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 30-60 minutes
Force Drying 15 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.

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	1.4-1.8 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, aluminum and galvanized metals: Sand with 150 - 240 grit paper. Primer will provide adequate adhesion and corrosion protection when applied directly to bare metal. However, for improved adhesion to difficult substrates and for lifetime warranty, we recommend priming with Transtar Self Etch Primer 6111/6114. **OEM and Refinish Paints:** Must be cured and sanded with 150 - 240 grit. 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.

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) - Do not use.
 Kicker (6417): Do not use.

APPLICATION & FILM BUILD

Stir primer thoroughly before use. Mix 4 parts primer to 1 part activator to 1 part Urethane Grade Reducer (6700-F or 6700 Series). Apply 2 - 3 medium wet coats, allowing 5 - 10 minutes flash time between coats, using the gun settings listed below. Film build is approximately 1.5 - 2.0 mils per coat (dry film thickness). In temperatures below 68°F (20°C), allow a 10 - 15 minute flash time between coats to ensure proper cure.
Film Build: 1.5-2.0 mils per coat (dry film thickness). Do not exceed 6 mils dry film thickness total.

PRODUCT SPECIFICATIONS

Color: Gray (9471/9474), Activator (9484/9487)	Size: Gallon (9471), Quart (9474/9484), ½ pint (9487)
Shelf Life: 1 year	Weight per gallon: 12.21
RTS Solids by Weight: 65%	Approximate Coverage: 682 ft ² /gal @ 1 mil

REGULATORY

Category: Primer	9471/9474	9484/9487	RTU VOC Actual (6700 Series)	1.80#/gal (216 g/l)
VOC Actual	0.70#/gal (84 g/l)	0.56#/gal (67 g/l)	RTU VOC Regulatory (6700 Series)	3.07#/gal (368 g/l)
VOC Regulatory	1.35#/gal (162 g/l)	1.29#/gal (155 g/l)	RTU VOC Actual (6700-F Series)	0.56#/gal (67 g/l)
Weight % of Volatiles	35.17	65.26	RTU VOC Regulatory (6700-F Series)	1.34#/gal (160 g/l)
Weight % of Water	0	0		
Weight % of Exempt Compounds	29.40	59.61		
Volume % of Exempt Compounds	47.86	57.01		
Density of Material #/gal	12.21	9.84		

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

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