

# Technical Data Sheet

No Mix Low VOC Sealer offers excellent adhesion to bare metal, aluminum, SMC, fiberglass, old paint finishes and all Transtar primers. It has excellent leveling and gloss hold out properties and is compatible with most solvent and water basecoat/clearcoat and single stage systems. Can be used without sanding on OEM E-coat panels.

## 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 No Mix Low VOC Sealer (LV-631)  
1 part No Mix Activators (LV-604/LV-614/LV-624)  
1 part No Mix Reducer\* (LV-541/LV-551/LV-571/LV-581)

Pot Life 2.5 hours (@70°F 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 5-10 minutes  
Dry to Touch 10 minutes  
Dust Free 10-15 minutes  
Max recoat w/o sanding 3 hours  
Force Drying 5 minutes @ 140°F (60°C)

## SURFACE PREPARATION



Bare Metal, Steel, Aluminum, Galvanized Metals: 80-220 grit dry  
OEM & Refinish Paints: 320-400 grit dry  
Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry  
\* For more information on surface prep and application refer to next page.

Body Filler, Fiberglass, SMC: 220-320 dry grit

## SPRAY GUN SET-UP/APPLICATION



Gun Type HVLP/LVLP Gravity Feed  
Fluid Tip 1.2 - 1.6 1.2 - 1.6  
Air Pressure 10 PSI @ aircap 30 - 40 PSI @ gun inlet  
Mil Thickness: 1.0 - 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.
- If mixed with other components, mixture may be hazardous of all combined components.
- See next page for more detailed production application.

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).

TRANSTAR AUTOBODY TECHNOLOGIES • 2040 HEISERMAN DRIVE, BRIGHTON, MI 48114 • (800) 824-2843

FAX (800) 477-7923 • EMAIL: [info@tat-co.com](mailto:info@tat-co.com)

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## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.6 mm	1.2-1.6 mm	1.0-1.2 mm	1.2-1.6 mm
Air Pressure	40-50 PSI (@gun)	30-40 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10-14 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:** Finish sand all areas to be sealed with 400-600 grit or finer sandpaper. For OEM E-coat panels, no sanding is necessary, follow cleaning steps above prior to application. Refinish lacquers require entire panel repair. Not recommended for spot repairs over lacquer as lifting may occur. If gelcoat is broken, a polyester primer, such as Kwik Fill 6541-G, should be used.

## TINTING & ADDITIVES

**Tinting:** Can be tinted up to 10% with No Mix basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels.

**Additives:** Fisheye Remover (6737) - Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.  
Universal Urethane Flex Additive (9194) - May be used, refer to TDS for mixing instructions.  
DO NOT USE: Kicker (6417).

## APPLICATION & FILM BUILD

**Coats:** Apply 1 full wet coat. If desired, additional coats may be used to achieve coverage. Allow 5-10 minute flash.

**Film Build:** 1.0 - 1.5 mils

**Critical Recoat Time:** Sealer should be topcoated within 3 hours to avoid adhesion problems. After 3 hours, scuff sand the sealer with gray scuff pad or sand (wet or dry) with 600-800 grit before applying more sealer or basecoat color. Topcoating without sufficient dry times may result in die-back. Denib with 1200-1500 wet, using a coarser grit could gouge the sealer.

## PRODUCT SPECIFICATIONS

Color: Gray	Size: Gallon
Shelf Life: 1 year	RTS Solids by Weight: 48%
Weight per gallon: 10.48	Approximate Coverage: 568 ft <sup>2</sup> /gal @ 1 mil

## REGULATORY

Category: Primer Sealer	LV-604	LV-614	LV-624	LV-631
VOC Actual	1.86#/gal (223 g/l)	1.84#/gal (221 g/l)	1.86#/gal (222 g/l)	0.85#/gal (102 g/l)
VOC Regulatory	2.36#/gal (282 g/l)	2.36 #/gal (282 g/l)	2.37#/gal (284 g/l)	1.75#/gal (210 g/l)
Weight % of Volatiles	45.34	45.28	45.34	43.35
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	25.30	25.82	25.62	35.12
Volume % of Exempt Compounds	21.10	21.90	21.68	51.58
Density of Material #/gal	9.26	9.41	9.39	10.48