



Luxury DTM Primer

OR2001

Transtar Select Luxury DTM Primer is a direct-to-metal 2K primer surfacer. It provides excellent corrosion protection. Help reduce cycle times and improve productivity with this luxury primer. It can be tinted with basecoat.



Mix Ratio

As a primer surfacer 4:1 - 4 parts primer to 1 part activator

As a primer sealer 4:1:1 - 4 parts primer to 1 part activator to 1 part reducer*

Pot life: 3 hrs (@77°F (25°C) and 50% R.H.)

* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.



Suitable Substrates

- Bare steel
- Primer - self-etching
- Fiberglass/SMC gel coat
- Raw plastic - rigid (SMC, BMC)
- Bare galvanized
- 1K primer
- Body filler
- OEM finish & old paint work - non-reversible
- Bare aluminum
- 2K primer
- OEM E-Coat

Note: Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

Note: Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.



Surface Prep & Application

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: As a primer, sand all areas to be primed with 180-220 grit sandpaper. Featheredge all broken film areas.

As a sealer, Finish sand all areas to be sealed with 400-600 grit or finer sandpaper. Featheredge all broken film areas.

Application: As a primer: Apply 2-3 medium wet coats, allowing 5-10 minute flash between coats. In temperatures below 68°F allow 10-15 minutes between coats to insure proper cure.

As a sealer: Allow 20-30 minutes and no longer than 4-6 hours before topcoating. Film build: 1.5 - 2.5 mils percoat. Do not exceed 10 mils dry film thickness. Do not exceed 6 mils dry film thickness total.

Critical Recoat Time: Sealer should be topcoated within 4-6 hours to avoid adhesion problems. After 4-6 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.

Tinting & Additives

Tinting Can be tinted up to 10% with basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels.

Kicker (6417) Do not use.

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

Flex Additive (9194) Do not use.



Flash Times/Dry Times

As a primer

Flash between coats..... 5-10 min

Dry to sand..... 1.5-2 hrs

Dry to recoat 20-30 min

Force drying..... 30 min @ 140°F (60°C)

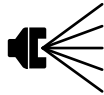
As a sealer

Max recoat w/o sand..... 4-6 hrs



Gun Set-up

Siphon feed.....	1.4 - 1.8 mm	Gravity feed.....	1.4 - 1.8 mm
HVLP/LVLP	1.4 - 1.8 mm		



Air Pressure

Siphon feed (@ gun)	35 - 50 psi	Gravity feed (@ gun)	35 - 50 psi
HVLP/LVLP (@ aircap).....	10 psi		

Fluid Pressure

Pressure feed 10 psi



Product Specifications

Color (OR2001)	Gray	Size (OR2001).....	Gallon
(OR2014)	Activator	(OR2014).....	Quart
Weight per gallon.....	12.49 #/gal	Shelf life	3 years
Approx. coverage (4:1).....	708 ft ² /gal @ 1 mil	RTS solids by weight (4:1).....	66%
(4:1:1)	590 ft ² /gal @ 1 mil	(4:1:1)	57%

Regulatory

OR2001

Category	Primer/Primer Sealer	Wt % of volatiles.....	31.56
VOC actual	1.0#/gal (120 g/l)	Wt % of water	0
VOC regulatory	1.62#/gal (194 g/l)	Wt % of exempt compound	23.79
Density.....	12.87 #/gal	Vol % of exempt compound	38.21
Regulatory ready to use			
4:1	2.0#/gal (239 g/l)		
4:1:1 w/6700-F series	2.0#/gal (239 g/l)		

Regulatory

OR2014

Category	Primer/Primer Sealer	Wt % of volatiles.....	60.41
VOC actual	2.44#/gal (293 g/l)	Wt % of water	0
VOC regulatory	3.25#/gal (389 g/l)	Wt % of exempt compound	32.03
Density	8.61 #/gal	Vol % of exempt compound	24.76



Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- 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 to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

LIMITED WARRANTY

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