

Technical Data Sheet

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.

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 Select Luxury DTM Primer (OR2001)
As a Primer 1 part Select Luxury DTM Activator (OR2014)
By Volume: 4 parts Select Luxury DTM Primer (OR2001)
As a Sealer 1 part Select Luxury DTM Activator (OR2014)
1 part 6700 or 6700-F Series Transtar Urethane Grade Reducer*

Pot Life 3 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



As a Primer: Flash Between Coats 5-10 minutes
Dry to Sand 1.5-2 hours
Dry to Recoat 20-30 minutes
Force Drying 30 minutes @140°F (60°C)
As a Sealer: Max recoat w/o sanding 4-6 hours

SURFACE PREPARATION



Bare Metal, Steel, Galvanized Metals: 80 grit Aluminum: 150 grit
OEM & Refinish Paints: 180-220 grit Body Filler, Fiberglass, SMC: 80 grit, followed by 120-180 grit
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.

SPRAY GUN SET-UP/APPLICATION



Gun Type HVLV/LVLP Gravity Feed
Fluid Tip 1.4 - 1.8 mm 1.4 - 1.8 mm
Air Pressure 10 PSI @ aircap 35-45 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	HVLP/LVLP
Fluid Tip	1.4-1.8 mm	1.4-1.8 mm	1.4-1.8 mm
Air Pressure	35-50 PSI (@gun)	35-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	N/A
<i>Always refer to gun manufacturer's recommendation for proper set up and spray pressure.</i>			

SURFACE PREPARATION

Sanding: As a Primer: Sand all areas to be primed with 180-220 grit sandpaper. Featheredge all broken film areas.

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

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.

TINTING & ADDITIVES

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) - DO NOT USE.
 Kicker (6417): DO NOT USE.

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.

APPLICATION & FILM BUILD

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.

Film Build (Primer): 1.5 - 2.5 mils percoat. Do not exceed 10 mils dry film thickness.

As a Sealer: Allow 20-30 minutes and no longer than 4-6 hours before topcoating.

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.

PRODUCT SPECIFICATIONS

Weight per gallon: 12.49	Shelf Life: 3 years
RTS Solids by Weight: 4:1 - 66% 4:1:1 - 57%	Color: Gray
Approximate Coverage: (4:1) 708 ft ² /gal @ 1 mil	Approximate Coverage (4:1:1) 590 ft ² /gal @ 1 mil

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.
- On featheredge areas, to prevent lifting of basecoats you can also seal with a coat of OR2001 Luxury DTM Primer mixed 4:1:1.

REGULATORY

Category: Primer	OR2001	OR2014	RTU VOC Actual (4:1)	1.29#/gal (154 g/l)
VOC Actual	1.00#/gal (120 g/l)	2.44#/gal (293 g/l)	RTU VOC Regulatory (4:1)	2.00#/gal (239 g/l)
VOC Regulatory	1.62#/gal (194 g/l)	3.25#/gal (389 g/l)	RTU VOC Actual (6700-F Series Reducers) (4:1:1)	1.07#/gal (129 g/l)
Weight % of Volatiles	31.56	60.41	RTU VOC Regulatory (6700-F Series Reducers) (4:1:1)	2.00 #/gal (239 g/l)
Weight % of Water	0	0		
Weight % of Exempt Compounds	23.79	32.03		
Volume % of Exempt Compounds	38.21	24.76		
Density of Material #/gal	12.87	8.61		