



# Luxury Sealer

## OR2101

**Transtar Select Luxury Sealer is a high quality sealer. It has excellent leveling and gloss hold out and is compatible with water and solvent basecoat/clearcoat and single stage systems.**



### Mix Ratio

4:1:1 - 4 parts sealer to 1 part activator to 1 part reducer

Pot life: 2.5 hrs (@70°F (21°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
- Body filler
- OEM finish & old paint work - reversible & non-reversible
- Bare galvanized
- 1K primer
- Fiberglass/SMC gel coat
- 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:** Bare Metal, Steel, Aluminum, Galvanized Metals: 320-400 grit dry.

OEM & Refinish Paints: 320-400 grit dry.

Body Filler, Fiberglass, SMC: 320-400 dry grit.

Finish sand all areas to be sealed with 400-600 grit or finer sandpaper. For improved adhesion on difficult substrates and for lifetime warranty, it is recommended priming with Transtar Self Etch Primer 6111/6114. 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.

**Application:** 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.

**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) ..... May be used refer to TDS for mixing instructions.



**Flash Times/Dry Times**

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

Dry to touch ..... 10 min

Dust free..... 10-15 min

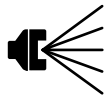
Dry to recoat w/o sand... 1 hr

Force drying..... 5 min @ 140°F (60°C)



**Gun Set-up**

Siphon feed.....	1.4 - 1.6 mm	Gravity feed.....	1.2 - 1.6 mm
HVLP/LVLP .....	1.2 - 1.6 mm		



**Air Pressure**

Siphon feed (@ gun) .....	40 - 50 psi	Gravity feed (@ gun) .....	30 - 40 psi
HVLP/LVLP (@ aircap).....	10 psi		

**Fluid Pressure**

Pressure feed ..... 10 psi



**Product Specifications**

Color (OR2101) .....	Gray	Size (OR2101).....	Gallon
(OR1024/1034/1044)...	Gray	(OR1024/1034/1044).....	Quart
Weight per gallon.....	10.4 #/gal	RTS solids by weight.....	47%
Approx. coverage.....	533 ft <sup>2</sup> /gal @ 1 mil	Shelf life.....	3 years

**Regulatory**

**OR1024**

Category .....	Primer Sealer	Wt % of volatiles.....	45.31
VOC actual .....	1.86#/gal (223 g/l)	Wt % of water .....	0
VOC regulatory .....	2.36#/gal (282 g/l)	Wt % of exempt compound .....	25.30
Density.....	9.29 #/gal	Vol % of exempt compound .....	21.10

**OR1034**

Category .....	Primer Sealer	Wt % of volatiles.....	45.31
VOC actual .....	1.84#/gal (221 g/l)	Wt % of water .....	0
VOC regulatory .....	2.36#/gal (282 g/l)	Wt % of exempt compound .....	25.82
Density.....	9.44 #/gal	Vol % of exempt compound .....	21.90

**OR1044**

Category .....	Primer Sealer	Wt % of volatiles.....	45.31
VOC actual .....	1.86#/gal (222 g/l)	Wt % of water .....	0
VOC regulatory .....	2.37#/gal (284 g/l)	Wt % of exempt compound .....	25.62
Density .....	9.42 #/gal	Vol % of exempt compound .....	21.68

**OR2101**

Category .....	Primer Sealer	Wt % of volatiles.....	43.33
VOC actual .....	0.85#/gal (102 g/l)	Wt % of water .....	0
VOC regulatory .....	1.75#/gal (210 g/l)	Wt % of exempt compound .....	35.17
Density .....	10.39 #/gal	Vol % of exempt compound .....	51.58

Regulatory ready to use

w/6700 series.....3.42#/gal (409 g/l)

w/6700-F series.....1.93#/gal (231 g/l)



**Limitations & Precautions**

- Sealer must be shaken for a minimum of 10 minutes.
- This product provides adhesion and corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded and applied.
- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://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**

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.