

STANDARD OPERATING PROCEDURE

Primer - Substrate Suitability

Transtar Primer / Sealer for Use Direct on Substrate ^a

Transtar undercoats shown in this table may be applied direct to specified substrate - when cleaned & properly prepared.

Transtar Undercoat	Substrate											
	Bare Steel ^b	Bare Galvanized	Bare Aluminum	Bare Plastic - Type A ^c	Bare Fiberglass, SMC, Unbroken Gel Coat	Body Filler ^d	OEM E-coat ^e	Self Etching Primers	1K Primers	2K Primers	OEM Finish / Old Paint ^f	
											Non-Reversible	Reversible
1074/84/94, Adhesion Primer				✓								
1161, Black OEM Flex Primer				✓								
1221, Hydroflex® Super Hi-Build Water Primer				✓								
1231, Hydroflex® Waterborne Primer				✓								
4600 series, 2 in 1 Primer	✓	✓	✓	✓			✓	✓	✓	✓	✓	
4951-01, True Finish 2K Urethane Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
6001, Universal Primer							✓	✓	✓	✓	✓	
6051, Super Sand							✓	✓	✓	✓	✓	
6071, Fast Prime						✓	✓	✓	✓	✓	✓	
6081, 1K Speed Sealer							✓	✓	✓	✓	✓	
6091, 1K Low VOC Speed Sealer							✓	✓	✓	✓	✓	
6100 series, 2K Epoxy Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
6111, 2K Self Etching Primer	✓	✓	✓			✓	✓	✓		✓	✓	
6183/84/94, 1K Self Etching Primer	✓	✓	✓				✓	✓		✓	✓	
6200 series, Kwik Seal 2K						✓	✓	✓	✓	✓	✓	✓
6401, 2K EZ Sand Primer					✓	✓	✓	✓	✓	✓	✓	
6441, 2K Kwik Prime	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
6541-G, Kwik Fill Polyester Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
6561, 2K Low VOC Acrylic Urethane Primer					✓	✓	✓	✓	✓	✓	✓	
6921, 2K High Performance Acrylic Primer					✓	✓	✓	✓	✓	✓	✓	
7200 series, Euro Classic Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
7300 series, Euro Classic DTM Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
9471, Signature Speed Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
9500 series, Signature Low VOC Sealer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓
32-0051, DTM Waterborne Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓
OR2001, Select Luxury DTM Primer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	
OR2101, Select Luxury Sealer	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓

^a Refer to Transtar Technical Data Sheets (TDS) for product application & other details.

^b On bare steel, always apply metal treatment for corrosion protection. See SOP 111.

^c For Type A & other plastics, see SOP 022 for complete list of Transtar primers, suitable plastic resin & required preparation.

^d Body filler must be fully cured & sanded prior to application of primer.

^e For pre-primed substrates, test with acetone or paint thinner. If coating fails, strip panel to bare substrate. See SOP 111/251.

^f Reversible finishes dissolve with solvent or heat; Non-reversible finishes do not dissolve.

For improved adhesion on substrates, apply Adhesion Promoter #1031 or #1021. See SOP 022.