



STANDARD OPERATING PROCEDURE

**Corrosion Protection of Bare Metal Using Self Etching Primer  
for Steel, Aluminum & Galvanized Metal**

|          |    | Aerosol Self Etch Primer<br>#6183, #6193  | Self Etch Primer & Spray Gun<br># 6184, #6111  |
|----------|----|---|--|
| Inspect  | 1  | Inspect repair area for defects. Assure area is properly repaired & prepped. Return to body dept if necessary.  |  |
| Clean    | 2  | Clean repair area with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.  |  |
|          | 3  | Clean with waterborne degreaser, Aqua SCAT 2 #1394.   |  |
| Sand     | 4  | Sand bare metal with palm sander. On steel-galvanized, sand with 80 grit and finish with 180 grit. On aluminum, sand with 150-180 grit. On previously painted surface, sand with 180-220 grit and feather edge.   |  |
| Clean    | 5  | Blow off vehicle. Wipe repair area with Aqua SCAT 2 #1394.  |  |
| Mix      | 6  | Shake aerosol can for 1-2 minutes.  | Agitate primer can thoroughly before use. For #6184, 1K, single-component primer, no activator is required. For #6111, 2K (two-component) mix with 6121-F activator according to TDS and stir thoroughly. Adjust gun pressure and spray pattern per manufacturer recommendation. |
|          | 7  | Immediately after cleaning, tack off panel. Apply Self Etching primer, #6183/6193 - 2-3 even medium wet coats to achieve hiding. Overlap spray pattern by 50% for an even coat. Allow 3-5 minute flash time between coats.                                    | Immediately after cleaning, tack off panel. Apply Self Etching primer. For #6184, apply 2-3 light coats and allow 5 minute flash time between coats. For #6111, apply 2-3 medium coats and allow 10-15 minute flash time between coats.  |
|          |    | Important: Minimize the time that bare metal panel is exposed to air as surface corrosion (flash rust) may result.  |  |
| Clean-up | 8  | To prevent clogging when finished spraying, invert can and spray until valve is free of material.   | 8 Clean gun as specified by manufacturer.  |
|          | 9  | If recoated within 24 hours, additional sanding of self etch primer is not required. After 24 hours, lightly dry sand / scuff with 400 grit or finer paper, then recoat with self etch primer (step 7).   |  |
| Topcoat  | 10 | Allow self etch to dry for 60 minutes before priming or topcoating. Tack off, and then apply primer surfacer, sealer or basecoat to panel/part. Refer to SOP 051 for Prep & sanding metal substrates; SOP 111 for Steel Finishing; or SOP 509 for topcoating. |  |
|          |    |   | Important: After applying self etch or other primer, do not leave vehicle/panel with only primer for an extended period or outside exposed to sunlight without other coating – as primer contains no UV protection   |

Note: Always wear gloves and appropriate personal protection equipment.

**SUGGESTED MATERIALS FOR JOB**

- Soap & water • Lint-free Towels • Sandpaper
- Solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321 • Transtar Waterborne Degreaser, #1394 • Tack rags
- Self Etching: 1K - #6183, 6193, 6184; 2K - #6111 & activator 6121-F
- Transtar Primer Surfacer / Sealer • Transtar Topcoat

\* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.