

STANDARD OPERATING PROCEDURE

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

		Aerosol Self Etch Primer #6183, #6193	Self Etch Primer & Spray Gun # 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.

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