

Technical Data Sheet

2K Epoxy Primer Sealer/Groundcoat is an exceptional lead and chromate free corrosion-resistant coating with excellent adhesion on a variety of properly prepared surfaces. 2K Epoxy Primer Sealer/Groundcoat improves adhesion of body fillers and resists moisture damage caused by water permeation. If further reduced, this product may be used as a precoat or sealer/groundcoat prior to topcoating.

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: 1:1
As a Primer 1 Part Primer (6101, 6104, 6131, 6134, 6161, 6164)
1 part Activator (6141, 6144)

By Volume 1:1:10%
As a Sealer/ 1 part primer(6101, 6104, 6131, 6134, 6161, 6164)
Groundcoat 1 part Activator (6141, 6144)
10% Urethane Grade Reducer (6700-F Series)

Pot Life 72 hours (@77°F (25°C) and 50% relative humidity)

* Use reducer according to shop conditions. For tinting instructions and the use of additives, please refer to next page.

FLASH TIMES/DRY TIMES



Flash Between Coats 10-15 minutes
Dry to Sand 60 minutes
Dry to Recoat w/o Sanding 30 minutes up to 72 hours
Force Drying 30 minutes @140°F (60°C)

SURFACE PREPARATION



Wash surface with soap and washer. Rinse well and wipe dry with a clean cloth. Solvent clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry. Sand bare metal with 80-150 grit. Sand existing finishes with 220 grit.

* For more information on surface prep and application refer to next page.

SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.2 - 1.6 mm	1.2 - 1.6 mm
Air Pressure	10 PSI @ aircap	30-40 PSI @ gun
Mil Thickness: 0.3-0.6 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	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.6 mm	1.2-1.6 mm	1.0-1.2 mm	1.2-1.6 mm
Air Pressure	40-50 PSI (@gun)	30-40 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10 PSI	N/A

Always refer to gun manufacturer's recommendation for proper set up and spray pressure.

SURFACE PREPARATION

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 should be sanded using an 80 - 150 grit abrasive. Sand and featheredge any surface repairs using 180 - 220 grit abrasive to ensure adhesion. Existing finishes should be sanded using a 220 grit abrasive.

TINTING & ADDITIVES

Tinting: Only use unreduced basecoats or basecoat toners when tinting. DO NOT tint with single stage urethanes or acrylic enamels. First, mix the Epoxy Primer Sealer with the Activator, then tint up to 10% by volume using basecoat or basecoat toner. Reduce if desired, up to 10%.

Additives: Fisheye Remover (6737) - Can be used at a rate of ¼ to ½ oz per sprayable quart.
Universal Urethane Flex Additive (9194) - Do not use.
Kicker (6417): Do not use.

APPLICATION & FILM BUILD

As a Primer (Direct to bare metal): Stir 2K Epoxy Primer Sealer thoroughly before using. Mix primer and activator components using a 1:1 ratio. NO INDUCTION TIME IS NECESSARY. Apply 1 - 2 medium wet coats. Allow 10 - 15 minutes flash time between coats. Allow to air dry 30 minutes at normal temperatures (70 - 85°F, 21 - 30°C) or force dry for 15 minutes at 140°F, (60°C) before applying additional topcoats.

As a Sealer/Groundcoat/Precoat: Thoroughly clean and prepare substrate. Mix 1:1:10% by volume. Apply 1 full wet coat. (If desired, a second coat may be applied after 10 - 15 minutes.) Allow to air dry 30 minutes at normal temperatures 70 - 85°F (21 - 30°C) or force dry for 15 minutes at 140°F, (60°C) before applying additional topcoats.

Recoatability:	50°F (10°C)	70°F (20°C)	100°F (38°C)	140°F (60°C)
Recoatable Wet-On-Wet	45 minutes	30 minutes	20 minutes	15 minutes
Recoatable w/ Body Filler	2 hours	1 hour	45 minutes	30 minutes

- After the drying time listed in the table above for Wet-On-Wet, 2K Epoxy Primer Sealer can be topcoated as a Wet-On-Wet system with 2K Primer Surfacer.
- Recoat Body Filler after the stated dry times using 2K Primer Surfacer
- When recoating with Polyester Primer 6541-G allow 2K Epoxy Primer/Sealer 6100 Series to cure for 24 hours before the application of Polyester Primer.

Film Build: 0.3-0.6 mils percoat (dry film thickness)

PRODUCT SPECIFICATIONS

Color: White (6101/6104), Gray (6131/6134), Black (6161/6164), Activator (6141/6144)	Size: Gallon (6101/6131/6141/6161), Quart (6104/6134/6144/6164)
Shelf Life: 1 year	Weight per gallon: 11.53
RTS Solids by Weight: 47.73%	Approximate Coverage: 520 ft ² /gal @ 1 mil

Technical Data Sheet

REGULATORY

Category: Primer Sealer/Primer	6101/6104	6131/6134	6161/6164	6141/6144
VOC Actual	2.53#/gal (303 g/l)	2.5#/gal (299 g/l)	2.68#/gal (321 g/l)	5.54#/gal (664 g/l)
VOC Regulatory	3.24#/gal (388 g/l)	3.16#/gal (379 g/l)	3.35#/gal (401 g/l)	5.54#/gal (664 g/l)
Weight % of Volatiles	33.07	32.64	35.13	77.49
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	12.04	11.69	11.62	0
Volume % of Exempt Compounds	21.89	21.07	20.04	0
Density of Material #/gal	12.02	11.92	11.4	7.15
VOC Actual RTS (1:1)	4.02#/gal (482 g/l)	4.01#/gal (480 g/l)	4.11#/gal (492 g/l)	
VOC Regulatory (1:1)	4.51#/gal (541 g/l)	4.48#/gal (536 g/l)	4.57#/gal (547 g/l)	
RTU VOC Actual (6700-F Series Reducers) 1:1:10%	3.66#/gal (438 g/l)	3.64#/gal (437 g/l)	3.74#/gal (448 g/l)	
RTU VOC Regulatory (6700-F Series Reducers) 1:1:10%	4.51#/gal (541 g/l)	4.5#/gal (538 g/l)	4.57#/gal (547 g/l)	
RTU VOC Actual (6700 Series Reducers) 1:1:10%	4.33#/gal (519 g/l)	4.33#/gal (519 g/l)	4.41#/gal (529 g/l)	
RTU VOC Regulatory (6700 Series Reducers) 1:1:10%	4.81#/gal (576 g/l)	4.79#/gal (573 g/l)	4.86#/gal (582 g/l)	

Recommendations:

- Not for sale in low VOC markets (CA, MD, UT, Canada).