

PRODUCT HIGHLIGHTS

6101, 6104, 6131, 6134, 6141, 6144, 6161, 6164 2K Epoxy Primer Sealer System

DESCRIPTION:

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.

PRODUCTS:

6101	2K Epoxy Primer Sealer(White), Gallon, 2/case
6104	2K Epoxy Primer Sealer (White), Quart, 6/case
6131	2K Epoxy Primer Sealer (Gray), Gallon, 2/case
6134	2K Epoxy Primer Sealer (Gray), Quart, 6/case
6141	2K Epoxy Primer Sealer Activator, Gallon, 2/case
6144	2K Epoxy Primer Sealer Activator, Quart, 6/case
6161	2K Epoxy Primer Sealer (Black), Gallon, 2/case
6164	2K Epoxy Primer Sealer (Black), Quart, 6/case



SANDING:

Bare metal - 80 to 150 grit
Existing finish - 220 to 400 grit
Clean with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225).



MIX RATIO:

1:1:10% one part primer sealer to one part activator to 10% Urethane Grade Reducer (TDS600 or TDS601)
Pot Life: 72 hours @ 77°F (25°C)



REDUCER:

Material is ready to spray when catalyzed with Activator #6141/6144. Reduce up to 10% using the Transtar Urethane Grade Reducer suitable for shop conditions.



HVLP/LVLP:

HVLP Spray Equipment:

Apply 1 - 2 medium wet coats



Allow 10 minutes flash time between coats

10 PSI Max (at aircap)



DRY TO SAND TIMES @ 77°F AND 50% RELATIVE HUMIDITY:

To Touch:	10 minutes
To Topcoat (or prime):	30 minutes
To Recoat (with itself):	10 minutes
To Apply Polyester Primer:	24 hours
Max Recoat (without sanding):	72 hours

See next page for more detailed product application. See website for this document in other languages.
Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

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SUITABLE SUBSTRATES:

Steel, OEM Finishes, Galvanized Steel, Cured, Sanded Body Filler,
Aluminum, Fiberglass/SMC, Cured, Sanded Original Finishes

SURFACE PREPARATION:

Prepare surface using standard refinish techniques.

APPLICATION & MIXING:

(Direct to bare metal) To avoid contamination: Stir 2K Epoxy Primer Sealer thoroughly before using. Mix base and activator components using a 1:1:10% 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.



FOR USE 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.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.4 - 1.6 mm	40 - 50 PSI (at gun)	n/a
Gravity Feed	1.2 - 1.6 mm	30 - 40 PSI (at gun)	n/a
Pressure Feed	1.0 - 1.2 mm	40 - 50 PSI (at gun)	10 - 14 PSI
HVLP/LVLP	1.2 - 1.6 mm	10 PSI max. (at aircap)	n/a

RECOATABILITY:

	50°F (10°C)	70°F (20°C)	100°F (38°C)	140°F (60°C)
Recoatible Wet-On-Wet	45 minutes	30 minutes	20 minutes	15 minutes
Recoatible 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 Transtar 2K Primer Surfacer. Recoat Body Filler after the stated dry times using Transtar 2K Primer Surfacer: EZ Sand 2K Acrylic Urethane Primer (TDS212) or 2K Acrylic Urethane Primer (TDS216). When recoating with Polyester Primer (TDS214) allow 2K Epoxy Primer (TDS208) to cure for 24 hours before the application of Polyester Primer.

Conventional Spray Equipment:

Apply 1 - 2 medium wet coats
Allow 10 minutes flash time between coats
35 - 45 PSI (at gun)

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HVLP Spray Equipment:

Apply 1 - 2 medium wet coats
Allow 10 minutes flash time between coats
10 PSI Max (at aircap)

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TECHNICAL DATA:

APPEARANCE:	White, Black, Gray
% SOLIDS:	47.73 by weight 32.10 by volume
SHELF LIFE:	One year (unopened)
REDUCERS:	Material is ready to spray when catalyzed with Activator #6141/6144. Reduce up to 10% using the Transtar Urethane Grade Reducer suitable for shop conditions. Note: Adding reducer will increase V.O.C.s.
MIX RATIO:	SEALER-GROUNDCOAT / PRECOAT - 1:1:10% one part primer sealer to one part activator to 10% Urethane Grade Reducer.
POT LIFE:	72 hours @ 77°F (25°C)
SPRAYABLE VISCOSITY:	16 - 20 seconds (#2 Zahn Cup)
FORCE DRYING:	15 minutes @ 140°F (60°C)
FILM THICKNESS:	Sealer: .3 - .6 mil
SANDING:	Not required
RECOATING:	1/2 hour (@ 70°F; 20°C) MAX recoat time without sanding: 72 hours
COVERAGE:	520 square feet / one gallon @ 1 mil dry film thickness

REGULATORY:

Category: Primer Sealer	Individual Component 6101 & 6104 White	Individual Component 6131 & 6134 Gray	Individual Component 6161 & 6164 Black	Individual Component 6141 & 6144 Activator
VOC Actual	2.53#/gal (303 g/l)	2.5#/gal (299 g/l)	2.7#/gal (321 g/l)	5.54#/gal (664 g/l)
VOC Regulatory	3.24#/gal (388 g/l)	3.2#/gal (379 g/l)	3.4#/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	21.06	20.02	0
Density of Material	12.02	11.91	11.39	7.15
VOC Actual Ready to Spray (1:1:10% w/6700 Series)	4.2#/gal (503 g/l)	4.2#/gal (501 g/l)	4.3#/gal (511 g/l)	
VOC Regulatory Ready to Spray (1:1:10% w/ 6700 Series)	4.7#/gal (561 g/l)	4.7#/gal (557 g/l)	4.7#/gal (565 g/l)	
VOC Actual Ready to Spray (1:1:10% w/6700-F Series)	3.8#/gal (460 g/l)	3.8#/gal (459 g/l)	3.9#/gal (469 g/l)	
VOC Regulatory Ready to Spray (1:1:10% w/ 6700-F Series)	4.5#/gal (4.5 g/l)	4.5#/gal (538 g/l)	4.6#/gal (547 g/l)	

TECHNICAL TIPS:

TINTING:

Only use unreduced basecoats or basecoat toners when tinting. **DO NOT use single stage urethanes.** 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%.

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TECHNICAL TIPS CONT.:

PERFORMANCE ADDITIVES

6417 Kicker (TDS700) – Do not use.

6737 Fisheye Remover (TDS703) – Can be used at rate of 1/4 to 1/2 oz per sprayable quart.

9194 Universal Urethane Flex Additive (TDS711) – Do not use.

ADVANTAGES:

- Exceptional edhesion & corrosion resistance over bare metal
- Improves adhesion of body filler
- Resists moisture damage caused by water permeation, when body filler is put over primers.

COMPETITION:

DuPont 2710S, 2740S, 2770S

Lesonal 072372, 072438, 072494

RM Diamont EP689, EP589, EP 7789

Marhyde 1012/1013

PPG Deltron/Concept DP48LF, DP40/DP50LF, DP90LF

DeBeer 1-75

Matrix MP450, MP400, MP 900

Martin Senour 5120, 5121

Montana PS50041A

Nason 486-19, 491-16

PPG Omni MP 170

Rubberseal RS781/788/789, RS780

U-Tech PE366, PE3601, PE3661

5 Star 5440/5442