

PRODUCT HIGHLIGHTS

6221, 6224, 6231, 6234, 6241, 6244 Kwik Seal 2K Urethane Sealer

DESCRIPTION:

Kwik Seal 2K Urethane Sealer has been specifically formulated as a premium quality sealer to be used over a variety of substrates. Kwik Seal offers excellent adhesion to bare metal, aluminum, SMC, fiberglass, old paint finishes and all Transtar primers. Kwik Seal has excellent leveling and gloss hold out properties and is compatible with most basecoat/clearcoat and single stage systems. It is one of the most innovative products on the market today! Utilizing Transtar's "Star Shade" system, these colors can be intermixed at established ratios to create a wide variety of color offerings for optimum basecoat coverage.

PRODUCTS:

- 6221 Kwik Seal 2K Urethane Sealer - White, Gallon (3.78 L), 2/case
- 6224 Kwik Seal 2K Urethane Sealer - White, Quart (0.946 L), 6/case
- 6231 Kwik Seal 2K Urethane Sealer - Gray, Gallon (3.78 L), 2/case
- 6234 Kwik Seal 2K Urethane Sealer - Gray, Quart (0.946 L), 6/case
- 6241 Kwik Seal 2K Urethane Sealer - Black, Gallon (3.78 L), 2/case
- 6244 Kwik Seal 2K Urethane Sealer - Black, Quart (0.946 L), 6/case
- 6254 Kwik Seal Activator, Quart (0.946 L), 4/case
- 6257 Kwik Seal Activator, 1/2 Pint (236 ml), 12/case



SURFACE PREP:

Finish sand all areas to be sealed with 500-600 grit or finer sandpaper.
Clean using SCAT (TDS222), Speedi SCAT (TDS223), or Aqua SCAT 2 (TDS225).



MIX RATIO:

4 parts Sealer, 1 part Activator, 1 part Reducer
Pot Life: 2.5 hours @ 70°F and 50% relative humidity



REDUCER:

Transtar Urethane Grade reducers suitable to shop conditions.



HVLP/LVLP:

1.2 - 1.6 mm
1 full wet coat



5-10 minute flash

1.0 mils per coat (dry film thickness)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

45 minutes to 1 hour



SANDING:

Sealer should be topcoated within 3 hours to avoid any adhesion problems.
After 3 hours, scuff sand with a gray scuff pad or sand (wet or dry) with 600 grit paper.

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

6221, 6224, 6231, 6234, 6241, 6244 Kwik Seal 2K Urethane Sealer

SUITABLE SUBSTRATES:

Steel*: Degreased and sanded with #80 - #120 grit dry
 Aluminum*: Degreased and sanded with #180 - #200 grit dry
 Existing Finishes: Degreased and sanded with #320 - #400 grit dry
 Fiberglass & Gelcoat: Degreased and sanded with #220 - #320 grit dry. If the Gelcoat is broken use a polyester primer like Transtar's Kwik Fill (TDS214).
 All Transtar Primers: Degreased and sanded with #320 - #400 dry, #500 - #600 grit wet
 OEM E-coats: Degreased and sanded with #320 - #400 grit dry
 *Kwik Seal will provide adequate adhesion and protection to steel and aluminum. For areas larger than 1' x 1', Kwik Seal should be applied over Self Etching Primer (TDS209) or Epoxy Primer (TDS208).



SURFACE PREPARATION:

Finish sand all areas to be sealed with 500-600 grit or finer sandpaper. Clean using SCAT (TDS222), Speedi SCAT (TDS223), or Aqua SCAT 2 (TDS225).

APPLICATION & MIXING:

Mix 4 parts Sealer with 1 part activator and 1 part of Urethane Grade Reducer (TDS600 & TDS601) Series suitable for shop conditions. Mix and strain before using.

Wet-on-wet: Apply one full even wet coat to achieve 1.0 mils. Sealer should be topcoated within three hours to avoid adhesion problems. After three hours, scuff sand the sealer with a gray scuff pad or sand (wet or dry) with 600 grit sand paper, before applying sealer or basecoat color.

As a barrier coat: Kwik Seal can be used as a barrier coat to seal over troublesome substrates (ie old finishes). The barrier coat helps prevent lifting of existing finish by the basecoat upon base coat application. Apply 2-3 medium coats, allowing each coat to flash 5-10 minutes before applying the next coat. Allow to dry thoroughly and scuff or sand before applying topcoat. **Note:** For best results in temperatures above 85°F (29°C) or in high air flow spray booths, a narrow spray gun pattern will help prevent dry spray. Clean spray gun immediately after use.

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

See website (www.tat-co.com) for this document in other languages.
 Vea el Web site (www.tat-co.com) para este documento en español.
 Voir le site Web (www.tat-co.com) pour ce document en français.

6221, 6224, 6231, 6234, 6241, 6244 Kwik Seal 2K Urethane Sealer

DRY TIME SCHEDULE:

# of Coats	Temperature	Tape/Denib Time	Min Recoat Time	Max Recoat Time
1	65-75°F (18-24°C)	30-45 Min	20 Min	5 Hrs
2	65-75°F (18-24°C)	60-90 Min	30-45 Min	6 Hrs
3	65-75°F (18-24°C)	90-120 Min	45-60 Min	7 Hrs
1	75-85°F (24-29°C)	20-30 Min	15-20 Min	4 Hrs
2	75-85°F (24-29°C)	30-60 Min	20-30 Min	5 Hrs
3	75-85°F (24-29°C)	60-90 Min	30-45 Min	6 Hrs
1	90°F+ (29°C+)	10-20 Min	10-15 Min	3 Hrs
2	90°F+ (29°C+)	15-30 Min	15-20 Min	4 Hrs
3	90°F+ (29°C+)	30-45 Min	20-30 Min	5 Hrs

NOTE: Topcoating without sufficient dry times may result in die-back.

If the max recoat time is exceeded, you must sand the sealer with either 500-600 wet or 320-400 dry. Denib with 1200-1500 wet. Going Coarser could gouge the sealer.

TECHNICAL DATA:

APPEARANCE:	White, Light Gray, Black
% SOLIDS:	51.0% Ready to Use
SHELF LIFE:	One year (unopened)
MIX RATIO:	4:1:1 (4 parts Primer, 1 part Activator, 1 part Reducer)
ACTIVATOR:	6254/6257 Kwik Seal Activator
REDUCER:	Transtar Urethane Grade reducers suitable to shop conditions.
POT LIFE:	2.5 hours @ 70°F and 50% relative humidity
COVERAGE:	560 ft ² /gallon @ 1 mil. (100% transfer efficiency)

REGULATORY:

Category: Primer Sealer 6221 & 6224	Individual Component	Ready to Use 6700 Series Reducers	Ready to Use 6700 Series Reducers
VOC Actual	3.21#/gal (384 g/l)	4.3#/gal (511 g/l)	3.6#/gal (435 g/l)
VOC Regulatory	3.72#/gal (445 g/l)	4.7#/gal (563 g/l)	4.1#/gal (488 g/l)
Weight % of Volatiles	34.44		
Weight % of Water	0		
Weight % of Exempt Compounds	7.59		
Volume % of Exempt Compounds	13.7		
Density of Material	11.94		
Category: Primer Sealer 6231 & 6234	Individual Component	Ready to Use 6700-F Series Reducers	Ready to Use 6700-F Series Reducers
VOC Actual	3.2#/gal (378 g/l)	4.2#/gal (507 g/l)	3.6#/gal (430 g/l)
VOC Regulatory	3.82#/gal (458 g/l)	4.8#/gal (574 g/l)	4.2#/gal (500 g/l)
Weight % of Volatiles	40.04		
Weight % of Water	0		
Weight % of Exempt Compounds	10.70		
Volume % of Exempt Compounds	17.42		
Density of Material	10.76		

6221, 6224, 6231, 6234, 6241, 6244 Kwik Seal 2K Urethane Sealer

REGULATORY (CONTINUED):

Category: Primer Sealer 6241 & 6244	Individual Component	Ready to Use 6700-F Series Reducers	Ready to Use 6700-F Series Reducers
VOC Actual	3.26#/gal (391 g/l)	4.3#/gal (516 g/l)	3.7#/gal (440 g/l)
VOC Regulatory	3.89#/gal (466 g/l)	4.8#/gal (578 g/l)	4.2#/gal (505 g/l)
Weight % of Volatiles	41.15		
Weight % of Water	0		
Weight % of Exempt Compounds	10.11		
Volume % of Exempt Compounds	16.08		
Density of Material	10.51		

6254 & 6257	Individual Component
VOC Actual	5.31#/gal (636 g/l)
VOC Regulatory	5.31#/gal (636 g/l)
Weight % of Volatiles	62.55
Weight % of Water	0
Weight % of Exempt Compounds	0
Volume % of Exempt Compounds	0
Density of Material	8.49

TECHNICAL TIPS:

TINTING:

(Optional) Can be tinted up to 10% by volume with basecoat mixing toners. Or, use Transtar's "Star Shade" tint system (Z659) for optimal hiding capabilities. This system utilizes white, black and gray sealers.

PERFORMANCE ADDITIVES

6417 Kicker (TDS700) – Do not use.

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

9194 Universal Urethane Flex Additive (TDS711) – May be used, refer to TDS for mixing recommendations.

COMPETITION:

Dupont Chroma Premier Sealer 42410S, 42440S, 42470S

PPG Deltron NCS 2003, 2004, 2005

PPG Global D891

Sherwin Williams Ultra Fill II S56, S57, S58

Standox 2K Non Stop

Valspar 97N

RM Diamont DP20, DP21

BASF Glasurit 285-81

Sikkens Color Build Sealer