

PRODUCT HIGHLIGHTS

6401, 6404

EZ Sand 2K Acrylic Urethane Primer

DESCRIPTION:

EZ Sand Acrylic Urethane Primer is a premium lead/chrome free two component acrylic urethane primer surfacer. EZ Sand provides exceptional fill and build, yet provides a base which yields excellent top coat hold out, gloss and D.O.I. (Distinctness of Image). EZ Sand Primer sands easily wet or dry and can be directly topcoated with alkyd enamels, acrylic enamels, lacquers, acrylic urethane enamels and basecoat clearcoat systems.

PRODUCTS:

- 6401 EZ Sand 2K Acrylic Urethane Primer Gray, Gallon (3.78 L), 2/case
- 6404 EZ Sand 2K Acrylic Urethane Primer Gray, Quart (0.946 L), 6/case
- 6934 Acrylic Urethane Primer Activator, Quart (0.946 L), 4/case
- 6937 Acrylic Urethane Primer Activator, ½ Pint (236 ml), 12/case



SURFACE PREP:

Depending on surface, see surface preparation for sanding recommendations
Clean with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225).



MIX RATIO:

4:1:1 (Four parts primer to one part activator to one part reducer)
Pot Life: 2 - 3 hours at 70°F (21° C), 50% R.H.



REDUCER:

Transtar Urethane Grade Reducer (TDS600 & TDS601) Series appropriate for shop temperature.



HVLP/LVLP:

1.6 - 1.8 mm
2 - 3 medium wet coats



10 - 15 minute flash
2.0 - 2.5 mils per coat (dry film thickness)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

60° - 70°F (15° - 21°C)	70° - 80°F (21° - 26°C)	80° - 100°F (26° - 38°C)	120°F (49°C) forced
2 - 3 hours	1.5 - 2.5 hours	1 - 2 hours	40 minutes
140°F (60°C) forced	Below 60°F (15°C)		
30 minutes	Dry times will be significantly extended		
Recoat without sanding: 45 minutes			



SANDING:

DA (Dry): #320, finish #500 - 600
Hand (Wet): #400, finish #500 - 600

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:

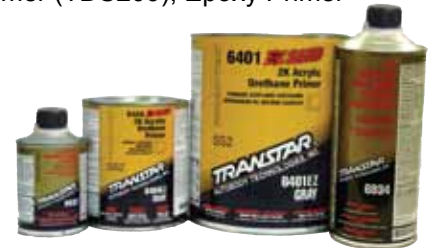
Steel: EZ Sand Primer will provide adequate adhesion and corrosion protection when applied directly to bare steel. However, for larger areas we recommend pretreatment with Transtar Self Etch Primer (TDS209), Epoxy Primer (TDS208) Series or Hydrobase® DTM Primer (TDS228).

Aluminum and Galvanized Metals: Must be pretreated with Transtar Self Etch Primer (TDS209), Epoxy Primer (TDS208) Series or Hydrobase® DTM Primer (TDS228).

OEM and Refinish Paints: Must be cured and sanded. Refinish lacquers require entire panel repair. Not

recommended for spot repairs over lacquers as lifting may occur.

Body Filler, Fiberglass, SMC: Must be sanded.



SURFACE PREPARATION:

Before sanding wash all surfaces thoroughly with soap and water. Rinse well and dry with clean cloth. Solvent clean area with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225) and wipe dry with a clean cloth. Sand repair area with 80 grit followed by 180 grit. (Sand existing finishes with 180 grit.) Featheredge all broken film areas. Wipe all sanded areas with SCAT and wipe dry with a clean cloth before applying EZ Sand Primer. Activate Primer Mix thoroughly. Keep containers tightly closed when not in use to avoid moisture contamination. Clean equipment thoroughly after each use.

APPLICATION & MIXING:

Stir EZ Sand Primer thoroughly before use. Apply 2 -3 medium wet coats, allowing 10 - 15 minutes flash time between coats, using the gun settings listed in the table below. Film build is approximately 2.0 - 2.5 mils per coat. Note: For best results, do not exceed 6 mils dry film thickness total.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.6 - 2.0 mm	40 - 50 PSI (at gun)	n/a
Gravity Feed	1.6 - 1.8 mm	35 - 45 PSI (at gun)	n/a
Pressure Feed	1.0 - 1.2 mm	40 - 50 PSI (at gun)	10 - 14 PSI
HVLP/LVLP	1.6 - 1.8 mm	10 PSI max. (at aircap)	n/a

TECHNICAL DATA:

APPEARANCE: Gray
 % SOLIDS: 66 - 70%, 50% Ready to use
 SHELF LIFE: One year (unopened)
 ACTIVATORS: #6934/6937 Acrylic Primer Activator

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EZ Sand 2K Acrylic Urethane Primer

TECHNICAL DATA CON'T:

REDUCER: Transtar Urethane Grade Reducer (TDS600 or TDS601) appropriate for shop temperature.
MIX RATIO*: Primer: 4:1:1 (Four parts primer to one part activator to one part reducer)
POT LIFE: 2 - 3 hours at 70°F (21° C), 50% rel. humidity

REGULATORY:

Category: Primer	Individual Component 6401/6404	Individual Component 6934/6937	Ready to Use
VOC Actual	3.4#/gal (403 g/l)	5.24#/gal (628 g/l)	4.4#/gal (523 g/l)
VOC Regulatory	3.9#/gal (463 g/l)	5.24#/gal (628 g/l)	4.8#/gal (572 g/l)
Weight % of Volatiles	36.57	68.75	
Weight % of Water	0	0	
Weight % of Exempt Compounds	7.38	0	
Volume % of Exempt Compounds	12.87	0	
Density of Material	11.53	7.63	

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) – Can be used at a rate of 1/2 to 1 oz per sprayable quart. Accelerated products should never be used direct-to-metal.

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, for use as a specialty coating for elastomeric substrates, refer to TDS for mixing recommendations.

NOTES:

- Observe flash times to provide good cure times, reduce shrinkage and avoid solvent pop
- Best adhesion results are achieved if topcoated within 8 hours, best holdout is achieved if primer is allowed to cure overnight.
- When using over lacquer, always complete the entire panel. Spot repairs may lift around the repair.

COMPETITION:

DuPont Chroma Systems, 1140S, 1120S

Sherwin Williams, P48

PPG Deltron/Concept, K200/K36/K38

RM Diamont, DP20/DP21

Sikkens, 2050/2051

Rubberseal, RS763

U-Tech, BMP 4.6, M997