

Signature SERIES

Speed Primer & Clearcoat



The Speed Process

TRANSTAR[®]

AUTOBODY TECHNOLOGIES, INC.

2040 Heiserman Drive
Brighton, MI 48114
ph (800) 824-2843
fax (800) 477-7923
www.tat-co.com

Signature Series Speed Repair Process

1. Clean panel with soap and water followed by SCAT or Aqua SCAT 2.
2. Assess damage.
3. Perform necessary repairs.
4. Finish sand repair area with 180 -240 grit.
5. Clean with SCAT or Aqua SCAT 2.
6. Mask accordingly.
7. Mix Signature Series Speed Primer @ 4:1:1 ratio.
8. Apply two to three coats allowing a 5-10 minute flash between coats.
9. Allow primer to dry 30 minutes.
10. Sand with 320 – 400 grit finish sand with 500-600 grit
11. Prepare remainder of panel as necessary to complete repair.
12. Clean with SCAT or Aqua SCAT 2.
13. Mask accordingly.
14. Tack panel.
15. Apply a sealer, if necessary.
16. Tack panel.
17. If necessary apply one medium coat of LV-500 to blend area. Allow 15-20 minute flash.
18. Reduce No Mix® Low VOC Basecoat @ 1:1 ½ using the speed of reducer best suited for the shop conditions and repair size.
19. Apply 2-3 coats of color to the repair area allowing a 10-15 min flash between coats. Progressively step each coat past the previous and tack between coats.
20. If performing a blend mix 2 part LV-500 to one part ready to spray color. Apply over the repair area and taper beyond the last coat of color applied.
21. Allow 15-20 minute flash.
22. Mix Signature Series Speed Clearcoat @4:1 with Signature Series slow activator.
23. Tack panel and apply one medium wet coat followed immediately by one full wet coat (no flash between coats).

The Products...

Speed Primer

Signature Series Speed Primer is a premium, 2K urethane primer surfacer that covers in as little as two coats and air dries in 30 minutes under ideal conditions! This easy-to-sand primer surfacer can be applied directly to metal, provides excellent gloss holdout and is highly resistant to film shrinkage. Save 30-40% on your entire labor process time when used in conjunction with Transtar's No Mix® Low VOC Basecoat and Signature Series Speed Clearcoat.

APPEARANCE:	Gray
% SOLIDS:	65% by weight
SHELF LIFE:	One year (unopened)
MIX RATIO:	4:1:1
REDUCERS:	A zero V.O.C. Reducer (6700-F Series) or Urethane Grade Reducer #6700 Series depending upon shop temperature.
POT LIFE:	2 - 3 hours @ 70°F (21°C) & 50% Relative Humidity
FILM BUILD:	1.5 - 2.0 mils per coat
FORCE DRYING:	15 min @ 140°F (60°C)
COVERAGE @ 1 mil:	682ft ² /gal

Availability:

- 9471 Signature Series Speed Primer - Gallon, 2/case
- 9474 Signature Series Speed Primer - Quart, 6/case
- 9484 Signature Series Speed Primer Activator, Quart, 4/case
- 9487 Signature Series Speed Primer Activator, 1/2 Pint, 12/case

Speed Clearcoat

Signature Series Speed Clearcoat is a medium solids, ultra fast cure clearcoat for spot and panel topcoating. Productivity is increased with 10 minute dust, 20 minute touch and 30 minute polish times.

APPEARANCE:	Clear Liquid
% SOLIDS (RTU):	Weight: 36% Volume: 35%
SHELF LIFE:	One Year (unopened)
ACTIVATORS:	9424/9427 Signature Series Activator Slow
REDUCERS:	A zero V.O.C. Reducer (6700-F Series) or Urethane Grade Reducer #6700 Series depending upon shop temperature.
MIX RATIO:	4:1 (If desired, add up to 1/2 part Transtar Reducer)
POT LIFE:	1.5 - 2 hours @ 68°F - 75°F (20° - 24°C)
COVERAGE:	556 ft ² /gal @ 1 mil.

Availability:

- 9451 Signature Series Speed Clearcoat, Gallon, 2/case
- 9454 Signature Series Speed Clearcoat, Quart, 6/case
- 9424 Signature Series Activator - Slow, Quart, 4/case
- 9427 Signature Series Activator - Slow, 1/2 Pint, 12/case