



OEM Flex Primer 1161

OEM Flex Primer is a specialty coating designed for priming flexible automotive parts. It is fast-drying, offers excellent adhesion, superior fill and build, and sands easily. Because of its unique formula, it has good low temperature crack resistance.



Mix Ratio

Ready to use, thinning is not necessary.
Pot life: unlimited in a sealer container.



Suitable Substrates

- Raw plastic - rigid (SMC, BMC)
- Plastic part - primed
- Fiberglass/SMC gel coat
- Raw plastic - flex (ABD, PPO)
- Raw plastic - soft (PUR)

Note: Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

Note: Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.



Surface Prep & Application

Cleaning: Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

Sanding: Sand with 320-500 grit wet or dry.

Application: Mask and sand as necessary. Ready to use gallons need no thinning. Apply 2-3 medium wet coats and allow a 5-10 minute flash time between coats, and 20 - 30 minutes before sanding. Film Build: 2.5 mils total film build.

Tinting & Additives

TintingNot recommended.

Kicker (6737)Do not use.

Fisheye Remover (6737) ..Do not use.

Flex Additive (9194)Do not use.



Flash Times/Dry Times

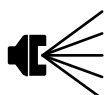
Flash time5 - 10 min between coats

To sand20 - 30 min

**Gun Set-up**

Siphon feed 1.5 - 1.6 mm
 Pressure feed 1.4 - 1.5 mm

Gravity feed 1.4 - 1.6 mm
 HVLP/LVLP 1.4 - 1.6 mm

**Air Pressure**

Siphon feed 40 - 55 psi
 Pressure feed 40 - 50 psi

Gravity feed (@ regulator) 40 - 50 psi
 HVLP/LVLP (@ aircap) 10 psi

Fluid Pressure

Pressure feed 10 - 14 psi

**Product Specifications**

Color.....	Black	Size	Gallon
Shelf life.....	3 years	RTS solids by weight.....	24%
Approx. coverage.....	206 ft ² /gal @ 0.5 mil	Weight per gallon.....	8.07 #/gal

Regulatory

Category.....	Specialty coating	Wt % of volatiles.....	75.86
VOC actual.....	4.71#/gal (564 g/l)	Wt % of water	0
VOC regulatory.....	6.00#/gal (719 g/l)	Wt % of exempt compound	17.47
Density.....	8.07 #/gal	Vol % of exempt compound	21.5

**Limitations & Precautions**

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.