



## Speed Prime

### 32-0181

**Speed Prime is a 2K urethane primer surfacer that has excellent fill and build properties 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.**



#### Mix Ratio

4:1:1 - 4 parts primer to 1 part activator to 1 part reducer\*

Pot life: 45-60 min (@77°F (25°C) and 50% R.H.)

*\* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.*



#### Suitable Substrates

- Bare steel
- Primer - self-etching
- Fiberglass/SMC gel coat
- Raw plastic - rigid (SMC, BMC)
- Bare galvanized
- 1K primer
- Body filler
- OEM finish & old paint work - non-reversible
- Bare aluminum
- 2K primer
- OEM E-Coat

*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 surfaces using standard refinish techniques to avoid contamination. Wash surfaces thoroughly with soap and water. Rinse well and wipe dry with a clean cloth. Solvent clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry with clean cloth.

**Sanding:** *Steel and aluminum:* Sand with 150 - 240 grit paper. Primer will provide adequate adhesion and corrosion protection when applied directly to bare metal. However, for improved adhesion to difficult substrates and for lifetime warranty, we recommend priming with Transtar Self Etch Primer 6111/6114.

*OEM and Refinish Paints:* Must be cured and sanded with 150 - 240 grit.

*Refinish lacquers require entire panel repair.* Not recommended for spot repairs over lacquers as lifting may occur.

*Body Filler, Fiberglass, SMC:* Must be sanded with 150 - 240 grit.

**Application:** Stir primer thoroughly before use. Mix 4 parts primer to 1 part activator to 1 part Urethane Grade Reducer (6700-F or 6700 Series). Apply 2 - 3 medium wet coats, allowing 5 - 10 minutes flash time between coats, using the gun settings listed below. Film build is approximately 1.5 - 2.0 mils per coat (dry film thickness). In temperatures below 68°F (20°C), allow a 10 - 15 minute flash time between coats to ensure proper cure.

Film build: 1.5-2.0 mils per coat (dry film thickness). Do not exceed 6 mils dry film thickness total.

### Tinting & Additives

Tinting ..... Not recommended.  
 Kicker (6417) ..... Do not use.  
 Fisheye Remover (6737) .. Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.  
 Flex Additive (9194) ..... Do not ue.



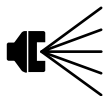
### Flash Times/Dry Times

Flash between coats..... 5-10 min  
 Dry to sand..... 30-60 min  
 Force drying..... 15 min @ 140°F (60°C)



### Gun Set-up

Siphon feed..... 1.4 - 1.8 mm	Gravity feed..... 1.4 - 1.8 mm
Pressure feed ..... 1.0 - 1.2 mm	HVLP/LVLP ..... 1.4 - 1.8 mm



### Air Pressure

Siphon feed (@ gun) ..... 40 - 50 psi	Gravity feed (@ gun) ..... 30 - 40 psi
Pressure feed (@ gun)..... 40 - 50 psi	HVLP/LVLP (@ aircap)..... 10 psi

### Fluid Pressure

Pressure feed ..... 10 psi



### Product Specifications

Color (32-0181)..... Gray	Size (32-0181)..... Gallon
(40-0194)..... Activator	(40-0194)..... Quart
RTS solids by weight..... 52%	Weight per gallon..... 12.21 #/gal
Approx. coverage..... 683 ft²/gal @ 1 mil	Shelf life..... 3 years

### Regulatory

#### 32-0181

Category..... Primer	Wt % of volatiles..... 35.17
VOC actual..... 0.70#/gal (84 g/l)	Wt % of water ..... 0
VOC regulatory..... 1.35#/gal (162 g/l)	Wt % of exempt compound ..... 29.40
Density..... 12.2 #/gal	Vol % of exempt compound ..... 47.81

Regulatory ready to use

4:1 w/6700 series..... 3.07#/gal (368 g/l)

4:1 w/6700-F series ..... 1.29#/gal (154 g/l)

#### 40-0194

Category..... Primer	Wt % of volatiles..... 70.72
VOC actual..... 0.34#/gal (41 g/l)	Wt % of water ..... 0
VOC regulatory..... 0.94#/gal (113 g/l)	Wt % of exempt compound ..... 67.47
Density..... 10.52 #/gal	Vol % of exempt compound ..... 63.73



### Limitations & Precautions

- For best results, spray immediately after mixing.
- Primer should not be mixed with other primer surfacers. Keep container closed when not in use. Do not transfer contents to other containers for storage.
- Follow topcoat manufacturer's instructions for proper topcoat procedures. Sealing is not required.
- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://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.

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### 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.

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