



True Finish Acrylic Urethane Primer

4951-01

Acrylic Urethane Primer is an acrylic urethane primer surfacer. It sands easily wet or dry and can be directly topcoated with alkyd enamels, acrylic enamels, lacquers, acrylic urethane enamels and base coat/clear coat systems.



Mix Ratio

4:1:1 – 4 parts 4951-01 primer to 1 part 5911-04 activators to 1 part 6700 or 6700-F Series Urethane Grade Reducer*.

Pot life: 2-3 hours (@70°F (21°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

- Primer - self etching
- Plastic part - primed
- Fiberglass/SMC/Unbroken gel coat
- OEM finish & old paint work - reversible & non-reversible
- 1K Primer
- OEM E-Coat
- 2K Primer
- Body filler

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:

Aluminum and galvanized metal: Must be pretreated with an etching or epoxy primer.

OEM and Refinish Paints: Must be cured and sanded. Sand with 180 grit.

OEM and Refinish Lacquers: Must be sanded. Not recommended for spot repairs over lacquers, as lifting may occur.

Body Filler: Must be sanded. Sand with 180 grit.

Fiberglass and SMC: Must be sanded. Sand with 180 grit.

Application: Apply 2-3 medium wet coats, allowing 5 minute flash between coats.

Film build: 1.5 - 2.5 mils per coat (dry film thickness).

Tinting & Additives

Tinting	Can be tinted up to 10% with basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels.
Kicker (6417)	Can be used at a rate of 1/2 oz per sprayable quart. Accelerated products should never be used direct-to-metal.
Fisheye Remover (6737) ..	Can be used at a rate of 1/4 or 1/2 oz per sprayable quart.
Flex Additive (9194)	May be used, for use as a specialty coating for elastomeric substrates, refer to TDS for mixing recommendations.



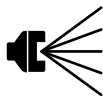
Flash Times/Dry Times

Flash between coats.....	5 min
Dry to sand.....	1-3 hrs
Dry to recoat	45 min
Force drying.....	30 min @ 140°F (60°C)



Gun Set-up

Siphon feed	1.6 - 1.8 mm	Gravity feed	1.6 - 1.8 mm
Pressure feed	1.6 - 1.8 mm	HVLP/LVLP	1.6 - 1.8 mm



Air Pressure

Siphon feed (@ gun)	40 - 50 psi	Gravity feed (@ gun)	35 - 45 psi
Pressure feed (@ gun).....	40 - 50 psi	HVLP/LVLP (@ aircap).....	10 psi

Fluid Pressure

Pressure feed	8 - 10 psi
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Product Specifications

Color.....	Gray	Size (4951-01)	Gallon
Shelf life.....	3 years	(5911-04)	Quart
RTS solids by weight.....	51%	Weight per gallon.....	11.53 #/gal
Approx. coverage.....	511 ft ² /gal @ 1 mil		

Regulatory

4951-01

Category	Primer	Wt % of volatiles.....	36.57
VOC actual	3.36#/gal (403 g/l)	Wt % of water	0
VOC regulatory	3.86#/gal (463 g/l)	Wt % of exempt compound	7.38
Density	11.53 #/gal	Vol % of exempt compound	12.87
Ready to use			
RTU actual with 6700	4.36#/gal (523 g/l)		
RTU regulatory with 6700 ..	4.77#/gal (572 g/l)		
RTU actual with 6700-F	3.12#/gal (374 g/l)		
RTU regulatory with 6700-F ..	4.17#/gal (500 g/l)		

5911-04

Category	Primer	Wt % of volatiles.....	68.75
VOC actual	5.24#/gal (628 g/l)	Wt % of water	0
VOC regulatory	5.24#/gal (628 g/l)	Wt % of exempt compound	0
Density	7.63 #/gal	Vol % of exempt compound	0

**Limitations & Precautions**

- Primer must be shaken for a minimum of 10 minutes.
- This product provides adhesion and corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded and applied.
- When priming over lacquer, it is recommended to coat the complete panel.
- 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.

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