



Universal Primer

6001, 6004, 6005, 6021, 6024

Universal Primer is a fast drying, easy sanding primer surfacer, which has excellent adhesion and filling properties. It sands to a fine featheredge while providing excellent color hold out.



Mix Ratio

1:1½ - 2 – 1 part primer to 1½ - 2 parts acetone (Do not use wash thinner.)
Pot life: 4 hours (@70°F (21°C) and 50% R.H.). Unlimited in a sealed cup.



Suitable Substrates

- Primer - self etching
- Plastic part - primed
- OEM finish & old paint work - non-reversible
- 1K Primer
- Raw plastic - rigid (SMC, BMC)
- 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: Solvent wash entire surface with a wax and grease remover, such as SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry. Sand all painted areas, feather edging broken spots. Bare steel and aluminum should be treated with epoxy or self etch primer. If large areas of zinc coated steel are involved, use a self etch primer such as Transtar's Self Etch Primer 6111/6114.

Sanding: Sand with 400 grit sandpaper until a smooth primer surface is obtained.

Application: Reduce 1½ - 2 parts with acetone. DO NOT USE WASH THINNER AS THIS MAY CAUSE RESIN "KICK OUT". Apply 2 or more medium wet coats allowing 10 – 15 minutes between coats for flash off. Do not apply heavy wet coats. Allow 30 minutes drying time before sanding. Sand with 400 grit sandpaper until a smooth primer surface is obtained. Universal Primer must be sanded before topcoating. Follow manufacturer's topcoat instructions. If topcoating with an enamel, recoat entire surface with a non-sanding sealer to provide uniform holdout between primed and unprimed areas.

Film build: 1.0 - 1.5 mils per coat (dry film thickness)

Tinting & Additives

TintingNot recommended.

Kicker (6417)Do not use.

Fisheye Remover (6737) ..Do not use.

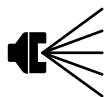
Flex Additive (9194)May be used, for use as a specialty coating for elastomeric substrates, refer to TDS for mixing recommendations.

**Flash Times/Dry Times**

Flash between coats..... 10-15 min
 Dry to sand..... 30 min
 Dry to recoat w/o sand... Must sand/seal
 Force drying..... 20 min @ 140°F (60°C)

**Gun Set-up**

| | |
|---------------------------------|--------------------------------|
| Siphon feed..... 1.4 - 1.6 mm | Gravity feed..... 1.2 - 1.6 mm |
| Pressure feed..... 1.0 - 1.2 mm | HVLP/LVLP..... 1.2 - 1.6 mm |

**Air Pressure**

| | |
|--|---------------------------------------|
| Siphon feed (@ gun)..... 40 - 55 psi | Gravity feed (@ gun)..... 40 - 45 psi |
| Pressure feed (@ gun)..... 40 - 50 psi | HVLP/LVLP (@ aircap)..... 10 psi |

Fluid Pressure

Pressure feed..... 10 - 14 psi

**Product Specifications**

| | |
|---|-----------------------------------|
| Color (6001/6004/6005)..... Gray | Size (6001/6021)..... Gallon |
| (6021/6024)..... Black | (6004/6024)..... Quart |
| Approx. coverage (gray)..... 388 ft ² /gal @ 1 mil | (6005)..... 5 gallon |
| (black)..... 358 ft ² /gal @ 1 mil | Weight per gallon..... 9.01 #/gal |
| Shelf life..... 3 years | RTS solids by weight..... 18% |

Regulatory**6001/6004/6005**

| | |
|---|-------------------------------------|
| Category..... Primer | Wt % of volatiles..... 57.51 |
| VOC actual..... 3.30#/gal (395 g/l) | Wt % of water..... 0.1 |
| VOC regulatory..... 4.61#/gal (553 g/l) | Wt % of exempt compound..... 20.84 |
| Density..... 9.01 #/gal | Vol % of exempt compound..... 28.41 |

6021/6024

| | |
|---|-------------------------------------|
| Category..... Primer | Wt % of volatiles..... 61.09 |
| VOC actual..... 3.26#/gal (391 g/l) | Wt % of water..... 0 |
| VOC regulatory..... 4.71#/gal (565 g/l) | Wt % of exempt compound..... 23.40 |
| Density..... 8.67 #/gal | Vol % of exempt compound..... 30.68 |

**Limitations & Precautions**

- Primer must be shaken for a minimum of 10 minutes.
- If priming over large areas of zinc coated steel, use a self etch primer such as Transtar's Self Etch Primer 6111/6114.
- Universal Primer must be sanded prior to topcoating. If topcoating with an enamel, recoat entire surface with a non-sanding sealer to provide uniform holdout between primed and unprimed areas.
- 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.
