



1K Speed Sealer

6081, 6084

1K Acrylic Speed Sealer is a ready-to-spray acrylic sealer with good holdout properties and excellent adhesion. This non-sanding sealer is ideal for spot and panel refinishing and is designed to provide excellent DOI under a wide range of topcoats. May be tinted with solvent basecoat toners.



Mix Ratio

Ready to use. Reduction is not necessary.
Pot life: Unlimited in a sealed cup.



Suitable Substrates

- Primer - self etching
- Plastic part - primed
- OEM finish & old paint work - non-reversible
- Fiberglass/SMC gel coat
- Raw plastic - rigid (SMC, BMC)
- 1K Primer
- 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.

Sanding: Finish sand all areas to be sealed with 400 - 600 grit or finer sandpaper.

Application: The product is supplied ready-to-spray. Reduction is not required. Stir or agitate thoroughly and filter before using.

Wet-on-wet: Apply one to two full wet coats to achieve hiding (.75 to 1.0 mil film build). Avoid heavy applications. Allow sealer to flash for 10-15 minutes (@75° F (24°C)) prior to top coating.

Recoatibility/Repair: If sealer is not top coated within 8 hours, clean, scuff (with 600 grit or finer sandpaper) before topcoating.

Note: If sanding is required to remove any imperfections, wet or dry sand using 600 - 1000 grit sandpaper. Use light pressure to avoid cutting through sealer.

Film build: 0.75-1.0 mils per coat (dry film thickness)

Tinting & Additives

Tinting May be tinted up to 10% by volume using solvent based basecoat mixing toners.

Kicker (6417) Do not use.

Fisheye Remover (6737) .. Do not use.

Flex Additive (9194) Do not use.

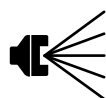
**Flash Times/Dry Times**

Flash between coats..... 10-15 min
 Flash before topcoat..... 10-20 min
 Dry to sand..... 10-20 min
 Dry to recoat w/o sand... 8 hrs
 Force drying..... N/A

**Gun Set-up**

Siphon feed..... 1.4 - 1.6 mm
 Pressure feed 1.0 - 1.2 mm

Gravity feed 1.2 - 1.6 mm
 HVLP/LVLP 1.2 - 1.4 mm

**Air Pressure**

Siphon feed (@ gun) 40 - 50 psi
 Pressure feed (@ gun)..... 40 - 50 psi

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

Fluid Pressure

Pressure feed 10 - 14 psi

**Product Specifications**

Color..... Light gray
 Weight per gallon..... 8.76 #/gal
 Shelf life..... 3 years
 Approx. coverage..... 225 ft²/gal @ 1 mil

Size (6081)..... Gallon
 (6084)..... Quart
 RTS solids by weight..... 22%

Regulatory**6081, 6084**

Category..... Primer/Primer Sealer	Wt % of volatiles..... 77.76
VOC actual..... 1.57#/gal (188 g/l)	Wt % of water 0
VOC regulatory..... 4.58#/gal (549 g/l)	Wt % of exempt compound 59.79
Density..... 8.76 #/gal	Vol % of exempt compound 65.67

**Limitations & Precautions**

- Sealer must be shaken for a minimum of 10 minutes.
- Provides good adhesion and corrosion protection when applied directly to bare metal. For areas larger than 1' X 1', apply one of Transtar's direct to metal primers (Self-Etch 6111/6114, Epoxy Primer 6100 Series or Kwik Prime 6441/6444) per instructions indicated on product data sheet.
- 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

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