



1K Low VOC Speed Sealer

6091, 6094, 6091-B, 6091-W

1K Low VOC 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. 1K Low VOC Speed Sealer can be applied over sanded factory primers on replacement parts and panels. This product is tintable 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 two medium 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.

Recoatability/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.

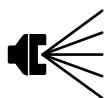
**Flash Times/Dry Times**

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 (6091/6094)..... Gray
 (6091-B)..... Black
 (6091-W)..... White

Shelf life..... 3 years

Approx. coverage..... 218 ft²/gal @ 1 mil

Size (6091/6091-B/6091-W) Gallon
 (6094)..... Quart

Weight per gallon..... 9.35 #/gal

RTS solids by weight..... 22%

Regulatory**6091, 6094**

Category.....	Primer/Primer Sealer	Wt % of volatiles.....	77.87
VOC actual.....	0.4#/gal (48 g/l)	Wt % of water.....	0
VOC regulatory.....	2.07#/gal (248 g/l)	Wt % of exempt compound.....	73.58
Density.....	9.35 #/gal	Vol % of exempt compound.....	80.77

6091-B

Category.....	Primer/Primer Sealer	Wt % of volatiles.....	79.54
VOC actual.....	0.4#/gal (49 g/l)	Wt % of water.....	0
VOC regulatory.....	2.07#/gal (248 g/l)	Wt % of exempt compound.....	75.05
Density.....	9.10 #/gal	Vol % of exempt compound.....	80.40

6091-W

Category.....	Primer/Primer Sealer	Wt % of volatiles.....	77.45
VOC actual.....	0.11#/gal (13 g/l)	Wt % of water.....	0
VOC regulatory.....	0.74#/gal (88 g/l)	Wt % of exempt compound.....	76.23
Density.....	9.46 #/gal	Vol % of exempt compound.....	84.81

**Limitations & Precautions**

- Sealer must be shaken for a minimum of 10 minutes.
- 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.
