



2K Epoxy Primer

6101, 6104, 6131, 6134, 6161, 6164

2K Epoxy Primer Sealer/Groundcoat is an exceptional lead and chromate free corrosion-resistant coating with excellent adhesion on a variety of properly prepared surfaces. 2K Epoxy Primer Sealer/Groundcoat improves adhesion of body fillers and resists moisture damage caused by water permeation. If further reduced, this product may be used as a precoat or sealer/groundcoat prior to topcoating.



Mix Ratio

1:1 - As a primer - 1 part primer to 1 part activator

1:1:10% - As a sealer/groundcoat - 1 part primer to 1 part activator to 10% reducer*

Pot life: 72 hrs (@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

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

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: Bare metal should be sanded using an 80 - 150 grit abrasive. Sand and featheredge any surface repairs using 180 - 220 grit abrasive to ensure adhesion. Existing finishes should be sanded using a 220 grit abrasive.

Application: As a Primer (Direct to bare metal): Stir 2K Epoxy Primer Sealer thoroughly before using. Mix primer and activator components using a 1:1 ratio. NO INDUCTION TIME IS NECESSARY. Apply 1 - 2 medium wet coats. Allow 10 - 15 minutes flash time between coats. Allow to air dry 30 minutes at normal temperatures (70 - 85°F, 21 - 30°C) or force dry for 15 minutes at 140°F, (60°C) before applying additional topcoats. As a Sealer/Groundcoat/Precoat: Thoroughly clean and prepare substrate. Mix 1:1:10% by volume. Apply 1 full wet coat. (If desired, a second coat may be applied after 10 - 15 minutes.) Allow to air dry 30 minutes at normal temperatures 70 - 85°F (21 - 30°C) or force dry for 15 minutes at 140°F, (60°C) before applying additional topcoats.

Recoatability:

	50°F (10°C)	70°F (20°C)	100°F (38°C)	140°F (60°C)
Recoatible Wet-On-Wet	45 min	30 min	20 min	15 min
Recoatible w/Body Filler	2 hrs	1 hr	45 min	30 min

- After the drying time listed in the table above for Wet-On-Wet, 2K Epoxy Primer Sealer can be topcoated as a Wet-On-Wet system with 2K Primer Surfacer.
 - Recoat Body Filler after the stated dry times using 2K Primer Surfacer
 - When recoating with Polyester Primer 6541-G allow 2K Epoxy Primer/Sealer 6100 Series to cure for 24 hours before the application of Polyester Primer.
- Film build: 0.3-0.6 mils percoat (dry film thickness)

Tinting & Additives

Tinting Only use unreduced basecoats or basecoat toners when tinting. DO NOT tint with single stage urethanes or acrylic enamels. First, mix the Epoxy Primer Sealer with the Activator, then tint up to 10% by volume using basecoat or basecoat toner. Reduce if desired, up to 10%.

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 use.



Flash Times/Dry Times

Flash between coats..... 10-15 min

Dry to sand..... 60 min

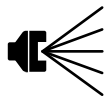
Dry to recoat w/o sand... 30 min up to 72 hrs

Force drying..... 30 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 - 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 (6101/6104)..... White	Size (6101/6131/6141/6161) Gallon
(6131/6134)..... Gray	(6104/6134/6144/6164) Quart
(6141/6144)..... Activator	Weight per gallon..... 11.53 #/gal
(6161/6164)..... Black	RTS solids by weight..... 47.7%
Approx. coverage..... 520 ft ² /gal @ 1 mil	Shelf life..... 3 years

Regulatory**6101, 6104**

Category	Primer/Primer Sealer	Wt % of volatiles	33.07
VOC actual	2.53#/gal (303 g/l)	Wt % of water	0
VOC regulatory	3.24#/gal (388 g/l)	Wt % of exempt compound	12.04
Density	12.02 #/gal	Vol % of exempt compound	21.89
Regulatory ready to use			
1:1	4.51#/gal (541 g/l)		
1:1:10% w/6700 series	4.51#/gal (541 g/l)		
1:1:10% w/6700-F series	4.81#/gal (576 g/l)		

6131, 6134

Category	Primer/Primer Sealer	Wt % of volatiles	32.64
VOC actual	2.5#/gal (299 g/l)	Wt % of water	0
VOC regulatory	3.16#/gal (379 g/l)	Wt % of exempt compound	11.69
Density	11.92 #/gal	Vol % of exempt compound	21.07
Regulatory ready to use			
1:1	4.48#/gal (536 g/l)		
1:1:10% w/6700 series	4.5#/gal (538 g/l)		
1:1:10% w/6700-F series	4.79#/gal (4.86 g/l)		

6141, 6144

Category	Primer/Primer Sealer	Wt % of volatiles	77.49
VOC actual	5.54#/gal (664 g/l)	Wt % of water	0
VOC regulatory	5.54#/gal (664 g/l)	Wt % of exempt compound	0
Density	7.15 #/gal	Vol % of exempt compound	0

6161, 6164

Category	Primer/Primer Sealer	Wt % of volatiles	35.13
VOC actual	2.68#/gal (321 g/l)	Wt % of water	0
VOC regulatory	3.35#/gal (401 g/l)	Wt % of exempt compound	11.62
Density	11.4 #/gal	Vol % of exempt compound	20.04
Regulatory ready to use			
1:1	4.57#/gal (547 g/l)		
1:1:10% w/6700 series	4.57#/gal (547 g/l)		
1:1:10% w/6700-F series	4.86#/gal (582 g/l)		

**Limitations & Precautions**

- Primer must be shaken for a minimum of 10 minutes.
- Not for sale in low VOC markets (CA, MD, UT, Canada).
- 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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