



# Kwik Seal 2K Urethane Sealer

## 6221, 6224, 6231, 6234, 6241,

Kwik Seal 2K Urethane Sealer has been specifically formulated as a premium quality sealer to be used over a variety of substrates. It is one of the most innovative products on the market today! Utilizing Transtar's "Star Shade" system, these colors can be intermixed at established ratios to create a wide variety of color offerings for optimum basecoat coverage.



### Mix Ratio

4:1:1 - 4 parts sealer to 1 part activator to 1 part 6700 or 6700-F reducer

4:1:2 - 1 part primer to 1 part activator to 2 parts acetone Pot life: 2.5 hrs (@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. Check local regulatory requirements for reducer selection.



### Suitable Substrates

- Primer - self-etching
- Body filler
- Plastic part - primed
- OEM finish & old paint work - non-reversible
- 1K primer
- Fiberglass/SMC gel coat
- OEM finish & old paint work - reversible
- 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 clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry with clean cloth.

**Sanding:** Steel\*: Degreased and sanded with 80 - 120 grit dry. Aluminum\*: Degreased and sanded with 180 - 200 grit dry. Existing Finishes: Degreased and sanded with 320 - 400 grit dry. Fiberglass & Gelcoat: Degreased and sanded with 220 - 320 grit dry. If the Gelcoat is broken use a polyester primer like Transtar's Kwik Fill 6451-G. All Transtar Primers: Degreased and sanded with 320 - 400 dry, 500 - 600 grit wet. OEM E-coats: Degreased and sanded with 320 - 400 grit dry.

\*Kwik Seal will provide adequate adhesion to steel and aluminum. For areas larger than 1' x 1', Kwik Seal should be applied over Self Etching Primer 6111/6114 or Epoxy Primer 6100 Series.

**Application:** Mix 4 parts Sealer 6200 Series with 1 part activator 6254/6257 and 1 part of Urethane Grade Reducer 6700 or 6700-F Series suitable for shop conditions. Mix and strain before using.

**Wet-on-wet application:** Apply one full even wet coat to achieve 1.0 mils. Sealer should be topcoated within three hours to avoid adhesion problems. After three hours, scuff sand the sealer with a gray scuff pad or sand with 400-600 grit wet or dry, before applying sealer or basecoat color.

**As a barrier coat:** Kwik Seal can be used as a barrier coat to seal over troublesome substrates (ie old finishes). The barrier coat helps prevent lifting of existing finish by the basecoat upon base coat application. Apply 2-3 medium coats, allowing each coat to flash 5-10 minutes before applying the next coat. Allow to dry thoroughly and scuff or sand before applying topcoat.

*Note: For best results in temperatures above 85°F (29°C) or in high air flow spray booths, a narrow spray gun pattern will help prevent dry spray. Clean spray gun immediately after use.*

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

**Critical recoat time:** Sealer should be topcoated within 3 hours to avoid adhesion problems. After 3 hours, scuff sand the sealer with gray scuff pad or sand (wet or dry) with 400-600 grit before applying more sealer or basecoat color. Topcoating without sufficient dry times may result in die-back. Denib with 1200-1500 wet, using a coarser grit could gouge the sealer.

**Tinting & Additives**

Tinting*	Can be tinted up to 10% by volume with basecoat mixing toners. Or, use Transtar’s “Star Shade” tint system for optimal hiding capabilities. This system utilizes white, black and gray sealers.
Kicker (6417)	Do not use.
Fisheye Remover* (6737)	Can be used at a rate of ¼ to ½ oz per sprayable quart.
Flex Additive (9194)	May be used. Refer to TDS for mixing information.

*\*Will increase VOC, verify compliance to local regulations.*



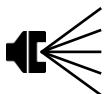
**Flash Times/Dry Times**

- Flash between coats .....5-10 min
- Dry to topcoat ..... 20 min
- Dry to tape.....30-45 min
- Dry to sand.....60-90 min
- Dry to recoat w/o sand..... 20 min up to 1 hr



**Gun Set-up**

- |                                 |                                 |
|---------------------------------|---------------------------------|
| Siphon feed .....1.4 - 1.6 mm   | Gravity feed ..... 1.4 - 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) .....psi         |

**Fluid Pressure**

- Pressure feed ..... 10 - 14 psi



**Product Specifications**

**Color:**

6221/6224 White  
 6231/6234 Gray  
 6241/6244 Black  
 6254/6257 Activator

RTS Solids by Weight: 37.3%

Approximate Coverage: 473 ft<sup>2</sup>/gal @ 1 mil

**Size:**

6221/6231/6241 Gallon  
 6224/6234/6244/6254 Quart  
 6257 ½ Pint

Weight per gallon: 8 – 9 #/gal

Shelf Life: 3 years

<b>Category: Primer Sealer</b>	<b>6254</b>	<b>6221</b>	<b>6231</b>	<b>6241</b>
VOC Actual	5.20 #/gal (623 g/l)	2.65 #/gal (318 g/l)	2.21 #/gal (265 g/l)	2.28 #/gal (273 g/l)
VOC Regulatory	5.20 #/gal (623 g/l)	3.37 #/gal (404 g/l)	3.11 #/gal (373 g/l)	3.15 #/gal (377 g/l)
Weight % of Volatiles	61.12	34.44	40.11	41.21
Weight % of Water	0.00	0.00	0.00	0.00
Weight % of Exempt Compounds	0.00	11.94	19.30	19.16
Volume % of Exempt Compounds	0.00	21.31	28.84	27.69
Density of Material #/gal	8.51	11.78	10.63	10.34
		<b>with 6254</b>	<b>with 6254</b>	<b>with 6254</b>
No reduction	Ready to Use (less water, less exempt compounds)	3.85 #/gal (461 g/l)	3.65 #/gal (437 g/l)	3.67 #/gal (440 g/l)
No reduction + additives	Ready to Use (less water, less exempt compounds)	3.86 #/gal (463 g/l)	3.67 #/gal (446 g/l)	3.68 #/gal (441 g/l)
Reduced (4:1:1)	Ready to Use (less water, less exempt compounds)	4.59 #/gal (550 g/l)	4.43 #/gal (531 g/l)	4.45 #/gal (533 g/l)
4:1:1 Reduced + additives	Ready to Use (less water, less exempt compounds)	4.63 #/gal (555 g/l)	4.47 #/gal (536 g/l)	4.49 #/gal (538 g/l)
Reduced w/Acetone (4:1:2)	Ready to Use (less water, less exempt compounds)	3.73 #/gal (447 g/l)	3.67 #/gal (440 g/l)	3.68 #/gal (441 g/l)
Reduced w/Acetone + additives	Ready to Use (less water, less exempt compounds)	3.80 #/gal (455 g/l)	3.73 #/gal (447 g/l)	3.76 #/gal (451 g/l)

**Star Shade Mix Ratios**

<b>SS1</b>	<b>SS2</b>	<b>SS3</b>	<b>SS4</b>	<b>SS5</b>	<b>SS6</b>	<b>SS7</b>
						
6221/6224 as packaged	2 parts 6221 1 part 6231	1 part 6221 2 parts 6231	6231/6234 as packaged	2 parts 6231 1 part 6241	1 part 6231 2 parts 6241	6241/6244 as packaged



### Limitations & Precautions

- Sealer must be shaken for a minimum of 10 minutes.
- Topcoating without sufficient dry times may result in die-back.
- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://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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### 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.

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