



## EZ Sand Primer

### 6401, 6404

**EZ Sand Primer is a premium lead/chrome free two component acrylic urethane primer surfacer. It provides exceptional fill and build, yet provides a base which yields excellent top coat hold out, gloss and D.O.I. EZ Sand Primer sands easily wet or dry and can be directly topcoated with alkyd enamels, acrylic enamels, lacquers, acrylic urethane enamels and basecoat clearcoat systems.**



#### Mix Ratio

4:1:1 - 4 parts primer to 1 part activator to 1 part reducer\*

Pot life: 2-3 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.



#### Suitable Substrates

- Primer - self-etching
- 1K primer
- 2K primer
- Fiberglass/SMC gel coat
- Body filler
- OEM E-Coat
- OEM finish & old paint work - reversible and 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:** Steel: Pretreat with Transtar Self Etch Primer 6111/6114, Epoxy Primer 6100 Series.

*Aluminum and galvanized metal:* Must be pretreated with an etching or epoxy primer.

*OEM and Refinish Paints:* Must be cured and sanded. Sand with 180 grit.

*OEM and Refinish Lacquers:* Must be sanded. Not recommended for spot repairs over lacquers, as lifting may occur.

*Body Filler, Fiberglass, SMC:* Must be sanded. Sand with 180 grit.

**Application:** Apply 2-3 medium wet coats, allowing 10-15 minute flash between coats. Film build: 2.0 - 2.5 mils per coat (dry film thickness) For best results, do not exceed 6.0 mils dry film thickness total.

### Tinting & Additives

Tinting .....	Can be tinted up to 10% with basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels.
Kicker (6417) .....	Can be used at a rate of 1/2 - 1 oz per sprayable quart. Accelerated products should never be used direct-to-metal.
Fisheye Remover (6737) ..	Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.
Flex Additive (9194) .....	May be used, for use as a specialty coating for elastomeric substrates, refer to TDS for mixing recommendations.



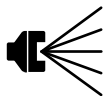
### Flash Times/Dry Times

Flash between coats.....	10-15 min
Dry to sand.....	1-3 hrs
Dry to recoat .....	45 min
Force drying.....	30 min @ 140°F (60°C)



### Gun Set-up

Siphon feed .....	1.6 - 1.8 mm	Gravity feed .....	1.6 - 1.8 mm
Pressure feed .....	1.6 - 1.8 mm	HVLP/LVLP .....	1.6 - 1.8 mm



### Air Pressure

Siphon feed (@ gun) .....	40 - 50 psi	Gravity feed (@ gun) .....	35 - 45 psi
Pressure feed (@ gun).....	40 - 50 psi	HVLP/LVLP (@ aircap).....	10 psi

### Fluid Pressure

Pressure feed .....	8 - 10 psi
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### Product Specifications

Color .....	Light gray	Size (6401) .....	Gallon
Weight per gallon.....	11.53 #/gal	(6404) .....	Quart
RTS solids by weight.....	50%	Shelf life.....	3 years
Approx. coverage.....	511 ft <sup>2</sup> /gal @ 1 mil		

### Regulatory

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Category .....	Primer	Wt % of volatiles.....	36.57
VOC actual .....	3.36#/gal (403 g/l)	Wt % of water .....	0
VOC regulatory .....	3.86#/gal (463 g/l)	Wt % of exempt compound .....	7.38
Density .....	11.53 #/gal	Vol % of exempt compound .....	12.87
Regulatory ready to use			
4:1:1 w/6700 series.....	4.78#/gal (573 g/l)		
4:1:1 w/6700-F series .....	4.17#/gal (500 g/l)		

**6934, 6937**

Category .....	Primer	Wt % of volatiles .....	68.75
VOC actual .....	5.24#/gal (628 g/l)	Wt % of water .....	0
VOC regulatory .....	5.24#/gal (628 g/l)	Wt % of exempt compound .....	0
Density .....	7.63 #/gal	Vol % of exempt compound .....	0

**Limitations & Precautions**

- Primer must be shaken for a minimum of 10 minutes.
- Observe flash times to provide good cure times, reduce shrinkage and avoid solvent entrapment.
- Best adhesion results are achieved if topcoated within 8 hours, best holdout is achieved if primer is allowed to cure overnight.
- When using over lacquer, always complete the entire panel. Spot repairs may lift around the repair.
- 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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