



Kwik Fill Polyester Primer Surfer 6451-G

Kwik Fill Polyester Primer Surfer is a catalyzed primer surfer that offers excellent fill and build capabilities. It can provide one-coat coverage for many applications. It has excellent adhesion to a wide range of substrates including metal, galvanized metal, fiberglass, SMC, aluminum, body fillers and polyester glazing putties, and over properly prepared old finishes.



Mix Ratio

2% by weight with included liquid hardener
Pot life: 45-55 min (@70°F (21°C) and 50% R.H.)



Suitable Substrates

- Bare steel
- Primer - self-etching
- Fiberglass/SMC gel coat
- Plastic part - primed
- OEM finish & old paint work - non-reversible
- Bare galvanized
- 1K primer
- Body filler
- Raw plastic - rigid (SMC, BMC)
- Bare aluminum
- 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: 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: *Untreated & Galvanized Steel & Bare Aluminum:* Sand surface using 180 – 220 grit sandpaper and reclean surface.

Body Fillers & Putty: Rough sand filler with 80 grit sandpaper, follow with 180 – 220 grit sandpaper, featheredge with 320 grit paper and blow off with air gun.

Plastics (Rigid & Semi-Rigid only): Sand with 180 grit sandpaper and reclean.

Prepainted Surfaces: Sand and featheredge using 80 - 220 and finish with 320 on an orbital sander. Reclean surface.

Application: Shake and stir contents of can thoroughly before mixing. Add Liquid Hardener at the rate of 2% by weight. (Example: To one quart of primer, add 0.75 oz. of hardener.) Mix primer and hardener thoroughly before adding to gun cup. NOTE: If necessary, this product may be reduced 5 – 10% with acetone to improve pot life, flow-out and dry to sand time. Apply 1 –3 medium wet coats holding gun 8 – 10 inches from surface. Allow primer to flash for 10 – 15 minutes between coats. Do not apply heavy wet-on-wet coats. Avoid dry spray, which must be removed before application of topcoat.

Film build: 2.0 - 2.5 mils per coat (dry film thickness)

Tinting & Additives

Tinting Not recommended.
 Kicker (6417) Do not use.
 Fisheye Remover (6737) .. Do not use.
 Flex Additive (9194) Do not use.



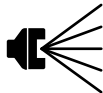
Flash Times/Dry Times

Flash between coats 10-15 min
 Dust free 30 min
 Dry to sand 55-65 min
 Force drying Purge 10 min, bake 30 min @ 140°F (60°C)
 IRT Purge 5 min, bake 24-36" for 15 min



Gun Set-up

Siphon feed 1.4 - 1.8 mm	Gravity feed 1.4 - 1.8 mm
Pressure feed 1.0 - 1.2 mm	HVLP/LVLP 1.6 - 1.8 mm



Air Pressure

Siphon feed (@ gun) 40 - 50 psi	Gravity feed (@ gun) 40 - 50 psi
Pressure feed (@ gun) 40 - 50 psi	HVLP/LVLP (@ aircap) 9.6 psi

Fluid Pressure

Pressure feed 10 - 14 psi



Product Specifications

Color Light gray	Size Gallon
Weight per gallon 11.4 #/gal	RTS solids by weight (4:1:1) 76.8%
Approx. coverage 800 ft ² /gal @ 1 mil	Shelf life 1 year

Regulatory

6451-G

Category Primer	Wt % of volatiles 34.1
VOC actual 2.42#/gal (290 g/l)	Wt % of water 0
VOC regulatory 3.12#/gal (375 g/l)	Wt % of exempt compound 12.85
Density 11.4 #/gal	Vol % of exempt compound 22.2



Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- Important: When any Transtar product is applied over or under another manufacturer's material/coating, check the all of the appropriate manufacturers' label instructions and Tech Data Sheets. Refer to each manufacturer's recommendations. Test on a small area to assure compatibility.
- Do not allow material to remain in cup longer than 50 minutes. Wash equipment with acetone, lacquer thinner or an appropriate spray gun cleaner.
- Keep lid closed when not in use. Do not return unused mixed material to can.
- Observe flash times to provide good cure times, reduce shrinkage and avoid solvent entrapment.
- 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.
