



## 2K Acrylic Urethane Prime

### 6561, 6564

**2K Acrylic Urethane Primer is a premium lead/chrome free two component acrylic urethane primer surfacer. It provides exceptional fill and build and provides a base which yields excellent top coat hold out, gloss and D.O.I. 2K Acrylic Urethane 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

As a primer 4:1 - 4 parts primer to 1 part activator

As a sealer 4:1:1/2 - 2 - 4 parts primer to 1 part activator to 1/2 up to 2 parts 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
- Plastic part - primed
- OEM E-Coat
- OEM finish & old paint work - reversible and non-reversible
- Body filler

*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 steel, aluminum and galvanized metal:* Must be primed with Self Etch Primer 6111/6114 or Epoxy Primer 6100 Series.

*OEM and refinish paints and lacquers:* Must be cured and sanded. Refinish lacquers require entire panel repair.

*Body filler, fiberglass, SMC:* Must be sanded.

*As a sealer:* Sanded and degreased existing finish and primers.

**Application:** *Primer:* Stir 2K Acrylic Urethane Primer thoroughly before use. Mix 4 parts primer to 1 part activator. Apply 2 -3 medium wet coats, allowing 10 - 15 minutes flash time between coats.

*Non-Sanding Sealer:* Mix 4 parts primer to 1 part activator to 1/2 part reducer or up to 2 parts zero VOC reducer. Apply 1 medium wet coat. Flash for 20 minutes before topcoating. If applying 2 coats of 6561, flash for 30 minutes before topcoating. Denib with 600 wet or dry. After two hours, it will be necessary to sand the sealer with 500-600 grit sandpaper to ensure good basecoat adhesion.

Film build: 2.0 - 2.5 mils per coat (dry film thickness). For best results, do not exceed 6 mils dry film thickness total.

### Tinting & Additives

Tinting ..... Not recommended.  
 Kicker (6417) ..... Can be used at a rate of 1/2 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, refer to TDS for mixing recommendations.



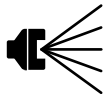
### Flash Times/Dry Times

As a primer  
 Flash between coats ..... 10-15 min  
 Dry to sand ..... 1-3 hrs  
 Force drying ..... 30 min @ 140°F (60°C)  
 As a sealer  
 To recoat ..... 20 min  
 Denib ..... 20-30 min  
 Dry to recoat w/o sand ... 2 hrs  
 Force drying ..... 30 min @ 140°F (60°C)



### Gun Set-up

Siphon feed ..... 1.6 - 2.0 mm	Gravity feed ..... 1.6 - 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) ..... 35 - 45 psi
Pressure feed (@ gun) ..... 40 - 50 psi	HVLP/LVLP (@ aircap) ..... 10 psi

### Fluid Pressure

Pressure feed ..... 8 - 10 psi



### Product Specifications

Color (6561/6564) ..... Light gray	Size (6561) ..... Gallon
(6584/6587) ..... Activator	(6564/6584) ..... Quart
RTS solids by weight (primer) .58%	(6587) ..... 1/2 pint
(sealer) ..55%	Weight per gallon ..... 12.17 #/gal
Approx. coverage (primer) ..717 ft <sup>2</sup> /gal @ 1 mil	Shelf life ..... 3 years
(sealer) ...665 ft <sup>2</sup> /gal @ 1 mil	

### Regulatory

#### 6561, 6564

Category ..... Primer	Wt % of volatiles ..... 35.34
VOC actual ..... 1.39#/gal (167 g/l)	Wt % of water ..... 0
VOC regulatory ..... 2.25#/gal (268 g/l)	Wt % of exempt compound ..... 23.92
Density ..... 12.17 #/gal	Vol % of exempt compound ..... 37.79
Regulatory ready to use	
4:1 ..... 2.07#/gal (248 g/l)	
4:1:1/2 w/6700 series ..... 2.88#/gal (345 g/l)	
4:1:1 w/6700-F series ..... 2.07#/gal (248 g/l)	

**6584, 6587**

Category .....	Primer	Wt % of volatiles .....	70.72
VOC actual .....	0.34#/gal (41 g/l)	Wt % of water .....	0
VOC regulatory .....	0.94#/gal (113 g/l)	Wt % of exempt compound .....	67.47
Density .....	10.52 #/gal	Vol % of exempt compound .....	63.73

**Limitations & Precautions**

- Primer must be shaken for a minimum of 10 minutes.
- Observe flash times to provide good cure times to reduce shrinkage.
- 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.

**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.