Euro Classic Primer

7241, 7244, 7261, 7264, 7271, 7274

Euro Classic Primer is a two component primer surfacer that can be applied direct to metal surfaces. It provides corrosion protection along with excellent fill and build properties. This unique primer provides improvements in productivity and reduces cycle times while providing significant labor and material savings. This primer can also be tinted using Transtar's exclusive "Star Shade" system for a better match.

Mix Ratio

As a primer surfacer 4:1 - 4 parts primer to 1 part activator
As a primer sealer 4:1:1 - 4 parts primer to 1 part activator to 1 part reducer*
Pot life: 2 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

- Bare steel
- Bare galvanized
- Bare aluminum
- Primer - self-etching
- 1K primer
- 2K primer
- Fiberglass/SMC gel coat
- Body filler
- OEM E-Coat
- Raw plastic - rigid (SMC, BMC)
- 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: *Steel and galvanized* should be sanded using an 80 grit abrasive. Aluminum should be sanded with 150-180 grit abrasive.
Body filler should be sanded with 80 grit followed by 120-180 grit abrasive. Featheredge all broken film areas.
Unsanded E-Coat, clean the surface, apply the Euro Primer either as a non-sanding sealer with reduction or as a surfacer.
As a sealer: For existing finishes, sand with 400-600 grit. If using as a non-sanding sealer, wait 20-30 minutes before topcoating.
Application: *As a primer surfacer*: Stir primer thoroughly before use. Mix 4 parts primer 7200 series with 1 part activator 7254/7257. Apply 2 - 3 medium wet coats, allowing 5 - 10 minutes flash time between coats, using the gun settings listed below. In temperatures below 68°F (20°C), allow a 10 - 15 minute flash time between coats to insure proper cure.

As a sealer: Stir primer thoroughly before use. Mix 4 parts primer with 1 part activator 7254/7257 with 1 part Urethane Grade Reducer (6700 or 6700-F Series). Flash 20-30 minutes and no longer than 4-6 hours before topcoating.
Film build: 1.5-2.5 mils per coat (dry film thickness)

Tinting & Additives

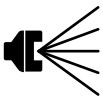
Tinting ..... Can be tinted up to 10% by volume with basecoat mixing toners. Use Transtar's "Star Shade" tint system for optimal hiding capabilities. This system utilizes black, white, and gray primers. See chart below for more details.
Kicker (6417) ..... Do not use.
Fisheye Remover (6737) .. Can be used at a rate of ¼ to ½ oz per sprayable quart.
Flex Additive (9194) ..... Do not ue.

Flash Times/Dry Times

Flash between coats ..... 5-10 min
Dry to sand ..... 1-6 hrs
Dry to recoat w/o sand ... 20 min up to 4 hrs
Force drying ..... 30 min @ 140°F (60°C)

Gun Set-up

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



Air Pressure

Siphon feed (@ gun) ..... 40 - 50 psi
Pressure feed (@ gun) ..... 40 - 50 psi
Gravity feed (@ gun) ..... 30 - 40 psi
HVLP/LVLP (@ aircap) ..... 10 psi

Fluid Pressure

Pressure feed ..... 10 psi

Product Specifications

Color (7241/7244) ..... Gray
(7261/7264) ..... White
(7271/7274) ..... Black
(7254/7257) ..... Activator
Approx. coverage (4:1) ..... 650 ft²/gal @ 1 mil
(4:1:1) ..... 541 ft²/gal @ 1 mil
Shelf life ..... 3 years
Size (7241/7261/7271) ..... Gallon
(7244/7254/7264/7274) ..... Quart
(7257) ..... ½ pint
Weight per gallon ..... 12.31 #/gal
RTS solids by weight (4:1) 62%
(4:1:1) 55%

Regulatory

7241, 7244

Category	Primer/Primer Sealer	Wt % of volatiles	32.46
VOC actual	4.0#/gal (479 g/l)	Wt % of water	0
VOC regulatory	4.0#/gal (479 g/l)	Wt % of exempt compound	0
Density	12.31 #/gal	Vol % of exempt compound	0

Regulatory ready to use

4:1	4.37#/gal (524 g/l)
4:1:1 w/6700-F series*	4.37#/gal (524 g/l)

7254, 7257

Category	Primer/Primer Sealer	Wt % of volatiles	76.32
VOC actual	5.88#/gal (705 g/l)	Wt % of water	0
VOC regulatory	5.88#/gal (705 g/l)	Wt % of exempt compound	0
Density	7.71 #/gal	Vol % of exempt compound	0

7261, 7264

Category	Primer/Primer Sealer	Wt % of volatiles	32.27
VOC actual	3.97#/gal (476 g/l)	Wt % of water	0
VOC regulatory	3.97#/gal (476 g/l)	Wt % of exempt compound	0
Density	12.31 #/gal	Vol % of exempt compound	0

Regulatory ready to use

4:1	4.36#/gal (522 g/l)
4:1:1 w/6700-F series*	4.36#/gal (522 g/l)

7271, 7274

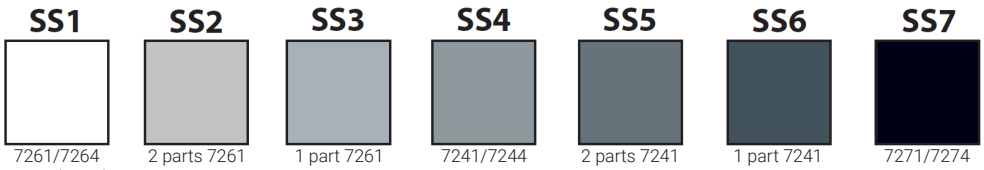
Category	Primer/Primer Sealer	Wt % of volatiles	32.51
VOC actual	3.92#/gal (469 g/l)	Wt % of water	0
VOC regulatory	3.92#/gal (469 g/l)	Wt % of exempt compound	0
Density	12.05 #/gal	Vol % of exempt compound	0

Regulatory ready to use

4:1	4.31#/gal (516 g/l)
4:1:1 w/6700-F series*	4.31#/gal (516 g/l)

*The use of 6700 Series Reducer with mixing this as a primer sealer (4:1:1) puts it over the limit for use in the US. If reducing to use as a primer sealer, 6700-F series reducers must be used to be compliant.

Star Shade Mix Ratio



Limitations & Precautions

• Primer must be shaken for a minimum of 10 minutes.
• Primer should not be mixed with other primer surfacers. Keep container closed when not in use. Do not transfer contents to other containers for storage.
• On featheredge areas, to prevent lifting of basecoats you can also seal with a coat of 7300 Series Euro Classic DTM Primer mixed 4:1:1.
• Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
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