



Signature Series Low VOC Sealer

9521, 9524, 9531, 9534, 9541, 9544

Signature Series Low VOC Sealer has been specifically formulated as a premium quality sealer to be used over a variety of substrates. This sealer offers excellent adhesion to bare metal, aluminum, SMC, fiberglass, old paint finishes and all Transtar primers. It is compatible with most basecoat/clearcoat and single stage systems. It is available in 3 colors to suit all your color match needs.



Mix Ratio

4:1:1 - 4 parts sealer to 1 part activator to 1 part reducer

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.*



Suitable Substrates

- Bare steel
- Primer - self-etching
- Body filler
- OEM finish & old paint work - reversible & non-reversible
- Bare galvanized
- 1K primer
- Fiberglass/SMC gel coat
- 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: Finish sand all areas to be sealed with 400-600 grit or finer sandpaper. For OEM E-coat panels, no sanding is necessary, follow cleaning steps above prior to application. Refinish lacquers require entire panel repair. Not recommended for spot repairs over lacquer as lifting may occur. If gelcoat is broken, a polyester primer, such as Kwik Fill 6541-G, should be used.

Application: Apply 1 full wet coat. If desired, additional coats may be used to achieve coverage. Allow 5-10 minute flash.

Film build: 1.0 - 1.5 mils

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 600-800 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% with basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels. For Star Shade ratios, refer to the chart on the next page.

Kicker (6417) Do not use.

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 instructions.

**Flash Times/Dry Times**

Flash between coats 5-10 min

Dry to touch 10 min

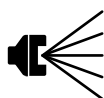
Dust free 10-15 min

Dry to recoat w/o sand ... 3 hrs

Force drying 5 min @ 140°F (60°C)

**Gun Set-up**

Siphon feed 1.4 - 1.6 mm	Gravity feed 1.2 - 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) 10 psi

Fluid Pressure

Pressure feed 10 - 14 psi

**Product Specifications**

Color (9521/9524) White	Size (9521/9531/9541) Gallon
(9531/9534) Gray	(9524/9534/9544) Quart
(9541/9544) Black	(9404/9414/9424) Quart
(9400 series) Activator	(9417/9427) 1/2 pint
Weight per gallon 10.4 #/gal	RTS solids by weight 47%
Approx. coverage 533 ft²/gal @ 1 mil	Shelf life 3 years

9404

Category Primer Sealer	Wt % of volatiles 45.31
VOC actual 1.86#/gal (223 g/l)	Wt % of water 0
VOC regulatory 2.36#/gal (282 g/l)	Wt % of exempt compound 25.30
Density 9.29 #/gal	Vol % of exempt compound 21.10

9414, 9417

Category Primer Sealer	Wt % of volatiles 45.31
VOC actual 1.84#/gal (221 g/l)	Wt % of water 0
VOC regulatory 2.36#/gal (282 g/l)	Wt % of exempt compound 25.82
Density 9.44 #/gal	Vol % of exempt compound 21.90

9424, 9427

Category	Primer Sealer	Wt % of volatiles.....	45.31
VOC actual	1.86#/gal (222 g/l)	Wt % of water	0
VOC regulatory	2.37#/gal (284 g/l)	Wt % of exempt compound	25.62
Density	9.42 #/gal	Vol % of exempt compound	21.68

9521, 9524

Category	Primer Sealer	Wt % of volatiles.....	33.82
VOC actual	0.96#/gal (115 g/l)	Wt % of water	0
VOC regulatory	1.65#/gal (198 g/l)	Wt % of exempt compound	25.73
Density	11.86 #/gal	Vol % of exempt compound	41.83

Regulatory ready to use

w/6700 series.....3.19#/gal (383 g/l)

w/6700-F series.....1.83#/gal (219 g/l)

9531, 9534

Category	Primer Sealer	Wt % of volatiles.....	43.33
VOC actual	0.85#/gal (102 g/l)	Wt % of water	0
VOC regulatory	1.75#/gal (210 g/l)	Wt % of exempt compound	35.12
Density	10.39 #/gal	Vol % of exempt compound	51.58

Regulatory ready to use

w/6700 series.....3.41#/gal (408 g/l)

w/6700-F series.....1.93#/gal (231 g/l)

9541, 9544

Category	Primer Sealer	Wt % of volatiles.....	43.59
VOC actual	0.83#/gal (100 g/l)	Wt % of water	0
VOC regulatory	1.69#/gal (203 g/l)	Wt % of exempt compound	35.38
Density	10.16 #/gal	Vol % of exempt compound	50.70

Regulatory ready to use

w/6700 series.....3.36#/gal (403 g/l)

w/6700-F series.....1.88#/gal (225 g/l)

Star Shade Mix Ratios

SS1	SS2	SS3	SS4	SS5	SS6	SS7
						
9521/9524 as packaged	2 parts 9521 1 part 9531	1 part 9521 2 parts 9531	9531/9534 as packaged	2 parts 9531 1 part 9541	1 part 9531 2 parts 9541	9541/9544 as packaged

**Limitations & Precautions**

- Sealer must be shaken for a minimum of 10 minutes.
- This product provides adhesion and corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded and applied.
- 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

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