

PRODUCT DATA

6101, 6104, 6131, 6134, 6141, 6144, 6161, 6164 2K Epoxy Primer Sealer System

DESCRIPTION:

2K Epoxy Primer Sealer/Groundcoat is an exceptional lead and chromate free corrosion-resistant coating with excellent adhesion on a variety of properly prepared surfaces. 2K Epoxy Primer Sealer/Groundcoat improves adhesion of body fillers and resists moisture damage caused by water permeation. If further reduced, this product may be used as a precoat or sealer/groundcoat prior to topcoating.

TECHNICAL DATA:

APPEARANCE:	White, Black, Gray
% SOLIDS:	47.73 by weight 32.10 by volume
V.O.C. CONTENT:	As Packaged: Coatings V.O.C.: 3.20#/gal, 385 g/l As Applied: Sealer-Groundcoat / PreCoat V.O.C.: 4.60 #/gal, 550 g/l
SHELF LIFE:	One year (unopened)
REDUCERS:	Material is ready to spray when catalyzed with Activator #6141/6144. Reduce up to 10% using the Transtar Urethane Grade Reducer suitable for shop conditions.
MIX RATIO:	SEALER-GROUNDCOAT / PRECOAT - 1:1:10% one part primer sealer to one part activator to 10% Urethane Grade Reducer.
POT LIFE:	72 hours @ 77°F
SPRAYABLE VISCOSITY:	16 - 20 seconds (#2 Zahn Cup)
FORCE DRYING:	15 minutes @ 140°F (60°C)
FILM THICKNESS:	Sealer: .3 - .6 mil
SANDING:	Not required
RECOATING:	1/2 hour (@ 70°F; 20°C) MAX recoat time without sanding: 72 hours
COVERAGE:	520 square feet / one gallon @ 1 mil dry film thickness

SALES FEATURES:

- Quick Drying
- Excellent Adhesion
- Excellent Corrosion Resistance
- Extended Pot Life - up to 72 hours
- No Induction Time
- Exceptional Top Coat Hold-out

SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS

(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin).

PACKAGE SIZES:

- #6101 2K Epoxy Primer Sealer(White), Gallon, 2/case
- #6104 2K Epoxy Primer Sealer (White), Quart, 6/case
- #6131 2K Epoxy Primer Sealer (Gray), Gallon, 2/case
- #6134 2K Epoxy Primer Sealer (Gray), Quart, 6/case
- #6141 2K Epoxy Primer Sealer Activator, Gallon, 2/case
- #6144 2K Epoxy Primer Sealer Activator, Quart, 6/case
- #6161 2K Epoxy Primer Sealer (Black), Gallon, 2/case
- #6164 2K Epoxy Primer Sealer (Black), Quart, 6/case



DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Transtar Autobody Technologies experience and research and is believed to be reliable. As Transtar has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.

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SUITABLE SUBSTRATES:

Steel OEM Finishes Galvanized Steel Cured, Sanded Body Filler
Aluminum Fiberglass/SMC Cured, Sanded Original Finishes

USE:

Use where exceptional adhesion and corrosion resistance is required over bare metal. Also improves adhesion of body plastics and resists moisture damage caused by water permeation, when plastic is put over primers.

SURFACE PREPARATION/APPLICATION (DIRECT TO BARE METAL):

Prepare surface using standard refinish techniques. To avoid contamination:

Stir 2K Epoxy Primer Sealer thoroughly before using. Mix base and activator components using a 1:1:10% ratio. **NO INDUCTION TIME IS NECESSARY.** Apply 1 - 2 medium wet coats. Allow 10 - 15 minutes flash time between coats. Allow to air dry 30 minutes at normal temperatures (70 - 85°F, 21 - 30°C) or force dry for 15 minutes at 140°F, (60°C) before applying additional topcoats.

FOR USE AS A SEALER-GROUND COAT / PRECOAT:

Thoroughly clean and prepare substrate. Mix 1:1:10% by volume. Apply 1 full wet coat. (If desired, a second coat may be applied after 10 - 15 minutes.) Allow to air dry 30 minutes at normal temperatures (70 - 85°F, 21 - 30°C) or force dry for 15 minutes at 140°F, (60°C) before applying additional topcoats.

OPTIONAL - TINTING INSTRUCTIONS:

Only use basecoats or basecoat toners when tinting. **DO NOT use single stage urethanes.** First, mix the Epoxy Primer Sealer with the Activator, then tint up to 10% by volume using basecoat or basecoat toner. Reduce if desired, up to 10%.

RECOATABILITY:

	50°F (10°C)	70°F (20°C)	100°F (38°C)	140°F (60°C)
Recoatible				
Wet-On-Wet	45 minutes	30 minutes	20 minutes	15 minutes
Recoatible w/ Body Filler	2 hours	1 hour	45 minutes	30 minutes

After the drying time listed in the table above for Wet-On-Wet, 2K Epoxy Primer Sealer can be topcoated as a Wet-On-Wet system with Transtar 2K Primer Surfacer. Recoat Body Filler after the stated dry times using Transtar 2K Primer Surfacer: EZ Sand 2K Acrylic Urethane Primer #6401 - 6414 or 2K Acrylic Urethane Primer #6921. When recoating with Polyester Primer allow 2K Epoxy Primer to cure for 24 hours before the application of Polyester Primer.

Conventional Spray Equipment:

Apply 1 - 2 medium wet coats
Allow 10 minutes flash time between coats
35 - 45 PSI (at gun)

HVLP Spray Equipment:

Apply 1 - 2 medium wet coats
Allow 10 minutes flash time between coats
10 PSI Max (at aircap)

DRY TIMES (@ 77°F AND 50% RELATIVE HUMIDITY).

Cooler temperatures and/or higher humidity will require longer times.

To Touch:	10 minutes	To Recoat (with itself):	10 minutes
To Topcoat (or prime):	30 minutes (see above table)	Max Recoat (without sanding):	72 hours

COMPETITIVE PRODUCTS:

Dupont Low V.O.C. Prime "N" Seal™ Non Sanding Primer 2710S, 2740S, 2770S, 2705S
BASF Diamont DE15, DE16
PPG DP 40-LF, DP 48-LF, DP 50-LF, DP 60-LF, DP 74-LF, DP 90-LF, DP 401-LF, DP 402-LF
Sherwin Williams E2-A976, V6-V979