

PRODUCT HIGHLIGHTS

6071 1K Fast Prime

DESCRIPTION:

Transtar's 1K Fast Prime is a low VOC, excellent quality one-component primer surfacer with good filling and sanding characteristics. This product dries quickly and provides good topcoat holdout. It may be used under acrylic enamels, acrylic lacquers, alkyd enamels, urethane enamels, and basecoat/clearcoat systems. 1K Fast Prime provides excellent adhesion and good featheredging properties.

PRODUCTS:

6071 1K Fast Prime, Gallon (3.78 L), 2/case



SURFACE PREP:

Depending on surface, see surface preparation for sanding recommendations
Clean with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225).



MIX RATIO:

1 Part 6071 : ½ to 1 part acetone



REDUCER:

Reduce with acetone 50% - 100%



HVLP/LVLP:

1.0 - 1.2 mm
2 - 3 medium wet coats



5 - 10 minute flash
2.0 mil film build



Please refer to gun manufacturer for proper spray pressure recommendations



DRY TO SAND TIMES:

65°-75°F (19° - 24°C)
45- 60 min.

75°-85°F (24° - 29°C)
30 min.

Over 85°F (+ 29°C)
20 min.



SANDING:

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See next page for more detailed product application. See website for this document in other languages.
Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

6071 1K Fast Prime



SUITABLE SUBSTRATES:

Degreased and sanded existing finishes; properly prepared steel, aluminum and galvanized steel; fiberglass; body filler; and over Transtar's Self-Etch Primer (TDS205), Hydrobase (TDS 218) and Epoxy Primer(TDS218).

SURFACE PREPARATION:

Prior to application, the surface must be dry, clean and free of all wax, grease, dust, rust, dirt and other surface contaminants. *For existing finishes, aluminum, fiberglass and body filler:* Degrease the surface with a quality cleaner, sand with 180-200 grit sandpaper, and degrease again. *For steel and galvanized steel:* Degrease the surface with a quality cleaner, sand with 80-180 grit sandpaper, and degrease again.

APPLICATION & MIXING:

Mix contents thoroughly before each use. Reduce with acetone 50 - 100% (1 part primer : ½ to 1 part acetone). This product is formulated for reduction with acetone to meet 2.1 VOC requirements.

This product is formulated at a V.O.C. level of 2.1 #/gal (250 g/l). 1K Fast Prime meets SCAQMD Rule 1151 requirements of 2.1 V.O.C. when reduced 1:1 with acetone. If higher V.O.C. levels are permissible, this product may be thinned 1:½ with lacquer thinner and the V.O.C. will be 4.7#/gal (564g/l).

Apply 2-3 medium wet coats (approximately 2 mils) to the prepared substrate. Flash 5-10 minutes between coats (@ 70°F (21°C)). Allow 30 - 40 minutes dry time before sanding and topcoating.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.4 - 1.6 mm	40 - 50 PSI (at gun)	n/a
Gravity Feed	1.2 - 1.6 mm	30 - 40 PSI (at gun)	n/a
Pressure Feed	1.0 - 1.2 mm	40 - 50 PSI (at gun)	10 - 14 PSI
HVLP/LVLP	1.0 - 1.2 mm	10 PSI max. (at aircap)	n/a

DRY TIMES:

Temperature	Sand Time
65°-75°F (19° - 24°C)	45-60 minutes
75°-85°F (24° - 29°C)	30 minutes
Over 85°F (+ 29°C)	20 minutes

CLEANING:

Equipment should be cleaned immediately after use with a compliant solvent using an enclosed system.

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1K Fast Prime

TECHNICAL DATA:

COLOR:	Light Gray
SOLIDS (BY WEIGHT):	52%
SPRAYABLE VISCOSITY:	16 - 18 seconds (Zahn #2)
FILM BUILD:	1 - 1.25 mil/coat
REDUCTION RATIO:	Reduce with acetone 50% - 100%. (1 Part 6071 : ½ to 1 part acetone)
COVERAGE:	309 sq. ft. per gallon (@1 mil DFT)

REGULATORY:

Category: Primer	Individual Component
VOC Actual	0.78#/gal (94g/l)
VOC Regulatory	2.09#/gal (250g/l)
Weight % of Volatiles	52.93
Weight % of Water	0.1
Weight % of Exempt Compounds	45.34
Volume % of Exempt Compounds	62.79
Density of Material	10.2

ADVANTAGES:

- Easy to mix and apply
- VOC compliant for use in SCAQMD Rule 1151 markets
- Easy to sand and excellent leveling
- Provides good filling capabilities
- Excellent adhesion
- Sandable -wet or dry

COMPETITION:

CAR/Bernardo Ecenarro URKI-FILLER

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