

PRODUCT HIGHLIGHTS

6561, 6564 2K Acrylic Urethane Primer

DESCRIPTION:

2K Acrylic Urethane Primer is a premium lead/chrome free two component acrylic urethane primer surfacer. 6561/6564 provides exceptional fill and build and provides a base which yields excellent top coat hold out, gloss and D.O.I. (Distinctness of Image). 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.

PRODUCTS:

- 6561 2K Acrylic Urethane Primer, Gallon (3.78 L), 2/case
- 6564 2K Acrylic Urethane Primer, Quart (0.946 L), 6/case
- 6584 2K Acrylic Urethane Primer Activator, Quart (0.946 L), 4/case
- 6587 2K Acrylic Urethane Primer Activator, 1/2 pint (237 ml), 12/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:

Primer: 4 parts primer to 1 part activator
Sealer: 4 parts primer to 1 part activator to 1/2 part reducer (TDS600)
Sealer: 4 parts primer to 1 part activator to up 2 part zero VOC reducer (TDS601)
Pot Life: 2 - 3 hours @ 70°F (21°C) & 50% R.H.



REDUCER:

Optional as a primer. As a sealer, use Transtar Zero VOC Urethane Grade Reducer (TDS601) or Urethane Grade Reducer (TDS600) Note: Using regular Urethane Grade Reducer (TDS600) will increase VOC's.



HVLP/LVLP:

1.6 - 1.8 mm
2 - 3 medium wet coats



10 - 15 minute flash
2.0 - 2.5 mils per coat (dry film thickness)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

Primer:

>60°F (15°C)	60-70°F (15-21°C)	70-80 °F (21-26°C)	80-100°F (26-38°C)	140°F (60°C) (force dry)
3.5+ hours	2 - 3 hours	1.5 - 2.5 hours	1 - 2 hours	30 minutes

Sealer:

To recoat: 20 minutes To Denib: 20 - 30 minutes Max Recoat w/o Sanding: 2 hours



SANDING:

DA (Dry): #220, finish #320 - 400

Hand (Wet): #400, finish #500 - 600

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

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2K Acrylic Urethane Primer

SUITABLE SUBSTRATES:

(As a Primer) Steel: 2K Acrylic Urethane Primer will provide adequate adhesion and corrosion protection when applied directly to bare steel. However, for larger areas we recommend priming with Transtar Self Etch Primer (TDS209), Epoxy Primer (TDS208) or Hydrobase® DTM Primer (TDS228).

(As a Primer) Aluminum and Galvanized Metals: Must be primed with Transtar Self Etch Primer (TDS209), Epoxy Primer (TDS208) or Hydrobase® DTM Primer (TDS228).

(As a Primer) OEM and Refinish Paints: Must be cured and sanded. Refinish lacquers require entire panel repair. Not recommended for spot repairs over lacquers as lifting may occur.

(As a Primer) Body Filler, Fiberglass, SMC: Must be sanded.

As a SEALER: Sanded (320 DA, 500 block) and degreased existing finish and primers.



SURFACE PREPARATION:

Wash all surfaces thoroughly with soap and water. Rinse well and dry with a clean cloth. Clean the area with SCAT (TDS222), Speedi SCAT (TDS223) or Aqua SCAT 2 (TDS225) and wipe dry with a clean cloth. Sand repair area with 80 grit followed by 180 grit. (Sand existing finishes with 180). Featheredge all broken film areas. Wipe all sanded areas with SCAT and wipe dry with a clean cloth before applying primer.

APPLICATION & MIXING:

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, using the gun settings listed in the table below. Film build is approximately 2.0 - 2.5 mils per coat. Note: For best results, do not exceed 6 mils dry film thickness total.

FOR USE AS A NON-SANDING SEALER: Mix 4 parts primer to 1 part activator to [1 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.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.6 - 2.0 mm	40 - 50 PSI (at gun)	n/a
Gravity Feed	1.6 - 1.8 mm	35 - 45 PSI (at gun)	n/a
Pressure Feed	1.0 - 1.2 mm	40 - 50 PSI (at gun)	10 - 14 PSI
HVLP/LVLP	1.6 - 1.8 mm	10 PSI max. (at aircap)	n/a

TECHNICAL DATA:

APPEARANCE:	Light Gray
% SOLIDS (RTU):	Primer: 58% Sealer: 55%
SHELF LIFE:	Primer: One year (unopened); Activator: One year (unopened)
MIX RATIO:	4:1 For primer surfacer
	4:1:1/2 For sealer (regular reducer)
	4:1:up to 2 For sealer (zero VOC reducer)

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2K Acrylic Urethane Primer

TECHNICAL DATA CONT.:

ACTIVATOR:	2K Acrylic Urethane Activator #6584, 6587
REDUCER:	Optional as a primer. Use reducer for use as a sealer.
POT LIFE:	2 - 3 hours @ 70°F (21°C) and 50% Relative Humidity
FILM BUILD:	1.5 - 2.5 mils per coat. Do not exceed 10 mils dry film thickness
FORCE DRYING:	30 minutes @ 140°F (60°C)
COVERAGE:	Primer: 717 ft ² /gal Sealer: 665 ft ² /gal.

REGULATORY:

Category: Primer	Individual Component 6561/6564	Individual Component 6584/6587	Ready to Use 4:1	Ready to Use 4:1:1/2	Ready to Use 4:1:1 (Zero VOC Reducer)
VOC Actual	1.5#/gal (178 g/l)	0.34#/gal (41 g/l)	1.3#/gal (151 g/l)	1.8#/gal (218 g/l)	1.3#/gal (151 g/l)
VOC Regulatory	2.2#/gal (268 g/l)	0.94#/gal (113 g/l)	2.1#/gal (249 g/l)	2.8#/gal (341 g/l)	2.1#/gal (249 g/l)
Weight % of Volatiles	32.95	70.72			
Weight % of Water	0	0			
Weight % of Exempt Compounds	21.12	67.47			
Volume % of Exempt Compounds	33.43	63.7			
Density of Material	12.56	10.51			

TECHNICAL TIPS:

CLEANING:

Clean equipment immediately after use with wash solvent.

PERFORMANCE ADDITIVES

6417 Kicker (TDS700) – Can be used at a rate of 1/2 oz per sprayable quart. Accelerated products should never be used direct-to-metal.

6737 Fisheye Remover (TDS703) – Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.

9194 Universal Urethane Flex Additive (TDS711) – May be used, refer to TDS for mixing recommendations.

NOTES:

- Observe flash times to provide good cure times, reduce shrinkage and avoid solvent pop.
- 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.

ADVANTAGES:

- California Compliant (2.1 V.O.C.)
- Rollable
- Excellent fill and build properties
- Easy sanding wet or dry
- Superior hold-out

COMPETITION:

DuPont 3240S	Evercoat/Bodymagic 394,395
PPG DCP21	Matrix MPV212
Sherwin Williams NP2100	Nason 421-18
Spies Hecker 5150	Valspar 21N

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