



Self Etching Primer

6111, 6114

Self-Etch Primer is a two part, self-etching and passivating primer. This system provides excellent protection against corrosion to bare metal, thereby eliminating the need for metal conditioning. It features an easy mix ratio and requires no induction time prior to using. Mixing 6111/6121-F/Acetone @ 1:1:2 complies with Rule 1151 for Group 1 & II vehicles for use as a pre-treatment/wash primer.



Mix Ratio

1:1 - 1 part primer to 1 part activator
 1:1:2 - 1 part primer to 1 part activator to 2 parts acetone
 Pot life: Up to 5 days (@70°F (21°C) and 50% R.H.)



Suitable Substrates

- Bare aluminum
- Bare galvanized
- Bare steel
- Body filler
- Primer - self-etching
- OEM E-Coat
- Fiberglass/SMC gel 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: Wash surfaces thoroughly with soap and water. Rinse well and wipe dry with clean cloth. Solvent wash entire surface with a wax and grease remover, such as SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry.

Sanding: Finish sand all areas to be sealed with 400-600 grit wet or dry. For galvanized steel panels, sand with 80-120 grit. For aluminum and fiberglass, sand with 150-180 grit.

Application: Mix 1:1 or 1:1:2 per info above. For best results apply 2-3 medium wet coats. Can also be recoated with topcoats (basecoat/clearcoat or single stage) after 45 minute flash time without sanding.

Priming and Painting of OEM E-Coated Panels: Transtar's Self Etch Primer performs as an excellent tie coat for any top coat system when applied over unsanded E-Coat panels. Clean E-Coated part with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Prime with a minimum of two coats of Self Etch Primer 6111/6114. Flash for 30 minutes and apply topcoat wet-on-wet. Optional: Parts can be scuffed with a scuff pad prior to priming for improved adhesion.

Film build: 1.5-2.0 mils per coat (dry film thickness). Do not exceed 6 mils dry film thickness total.

Tinting & Additives

TintingNot recommended.
 Kicker (6417)Do not use.
 Fisheye Remover (6737) ..Do not use.
 Flex Additive (9194)Do not use.



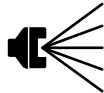
Flash Times/Dry Times

Flash between coats..... 10-15 min
 Dry to touch 15 min
 Dry to sand.....60 min
 Dry to recoat w/o sand...45 min
 Force drying30 min @ 140°F (60°C) after air drying 15 min.



Gun Set-up

Siphon feed.....1.4 - 1.6 mm	Gravity feed..... 1.2 - 1.6 mm
Pressure feed1.0 - 1.2 mm	HVLP/LVLP 1.2 - 1.4 mm



Air Pressure

Siphon feed (@ gun)35 - 45 psi	Gravity feed (@ gun) 25 - 35 psi
Pressure feed (@ gun).....40 - 50 psi	HVLP/LVLP (@ aircap)..... 10 psi

Fluid Pressure

Pressure feed10 - 14 psi



Product Specifications

Color (6111/6114).....Olive green	Size (6111/6121-F)..... Gallon
(6121-F/6124-F).....Activator	(6114/6124-F)..... Quart
Weight per gallon.....9.40 #/gal	RTS solids by weight (1:1)..... 24.51%
Approx. coverage.....213 ft ² /gal @ 1 mil	Shelf life 3 years

Regulatory

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Category.....Pretreatment Coating	Wt % of volatiles..... 56.52
VOC actual5.31#/gal (636 g/l)	Wt % of water 0
VOC regulatory.....5.31#/gal (636 g/l)	Wt % of exempt compound 0
Density.....9.40 #/gal	Vol % of exempt compound 0
Regulatory ready to use	
1:15.50#/gal (659 g/l)	
1:1:2.....5.50#/gal (659 g/l)	

6121-F, 6124-F

Category.....Pretreatment Coating	Wt % of volatiles..... 97.93
VOC actual1.09#/gal (131 g/l)	Wt % of water 0.4
VOC regulatory.....6.64#/gal (796 g/l)	Wt % of exempt compound 83.82
Density.....7.97 #/gal	Vol % of exempt compound 83.7



Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- Not for sale in low VOC markets (CA, MD, UT, Canada).
- 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

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.
