



# Self Etching 1K Primer

## 6183, 6184, 6193

**Self Etching 1K Primer is a ready to use one component metal etching primer. It provides excellent adhesion and protection against corrosion to bare metal, thereby eliminating the need for metal conditioning. It is recommended for use to treat bare metal or for application under primer surfacers.**



### Mix Ratio

Ready to use.

Pot Life: Up to 5 days @ 70°F(21°C) and 50% R.H.



### Suitable Substrates

- Steel
- Galvanized steel
- Aluminum

### Surface Prep & Application

First, degrease all surfaces with Transtar's SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

**Steel & Galvanized:** Sand with 80-120 grit sandpaper. Degrease with Aqua SCAT 2 again before priming.

**Aluminum and Fiberglass:** Sand with 150-180 grit sandpaper. Degrease with Aqua SCAT 2 again before priming.

**Previously Painted Surfaces:** Sand and featheredge any surface repairs using 180 - 220 grit sandpaper.



**Aerosol:** Shake can vigorously for 1 minute to ensure color uniformity and to prevent clogging. Clean/degrease surfaces thoroughly using Transtar SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Apply 2 - 3 medium wet coats allowing a 3 - 5 minute flash time between coats. Spray with steady even strokes. Primer is dry to touch in 15 minutes. Allow one hour dry time before sanding, priming or topcoating. Sanding is not necessary if recoated within 24 hours.



**Quart:** Stir primer thoroughly before use. For best results, apply 2 - 3 light coats. Allow to flash 5 minutes between coats. Dried film thickness is approximately 0.3 mils per coat. Recommended spraying viscosity is 14 - 17 seconds using a Zahn #2 cup. Reduction is not necessary. Primer is dry to touch in 15 minutes. Allow one hour dry time before sanding, priming or topcoating. Sanding is not necessary if recoated within 24 hours. Note: 1K Self Etching Primer can be force dried at 140°F (60°C) for up to 30 minutes after air drying 5 minutes.

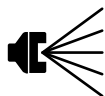
Recommended Mil Thickness: 0.3 mils per coat (dry film thickness)

Note: Do not store material in a metal gun. Clean equipment immediately.



### Gun Set-up

HVLP/LVLP ..... 1.4 - 1.6 mm      Gravity feed ..... 1.2 - 1.6 mm



### Air Pressure

HVLP/LVLP ..... 10 PSI @ aircap      Gravity feed ..... 30 - 40 PSI  
@ gun

### Additives

Do not use Fisheye Remover (6737), Universal Urethane Flex Additive (9194) and Kicker (6417).



### Product Specifications

Color (6183/6184)..... Olive green	Size (6184)..... Quart
(6193)..... Gray	(6183/6193)..... 20 oz aero
Shelf life..... 3 years	% Solids:..... 18% RTU

### Regulatory

#### 6184

Category..... Pre-treatment wash primer	
VOC actual..... 5.51#/gal (661 g/l)	Wt % of volatiles..... 81.39
VOC regulatory..... 6.42#/gal (769 g/l)	Wt % of water ..... 0.1
Density..... 7.93 #/gal	Wt % of exempt compound ..... 11.68
	Vol % of exempt compound ..... 14

#### 6183/6193

Category..... ABP
MIR..... <0.95

### Limitations & Precautions



- This product provides adhesion & corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded & applied.
- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://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.
- Before use, read and follow all TDS, label and SDS precautions.
- If mixed with other components, mixture may be hazards of all combined components.
- All Standard Operating Procedures (SOP) can be found on the Transtar website at [www.tat-co.com](http://www.tat-co.com).

### 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.