

PRODUCT HIGHLIGHTS

6921, 6934, 6937 2K Acrylic Urethane Primer

DESCRIPTION:

2K Acrylic Urethane Primer (Gray) is a premium lead/chromate free, two component acrylic urethane primer-surfacer for basecoat/clearcoat refinishing. Acrylic Urethane Primer provides excellent fill and build characteristics, and sands easily wet or dry without clogging. 6921 provides an excellent base for your top coat, thus offering excellent topcoat holdout, gloss and D.O.I. Acrylic Urethane Primer can be directly top coated with alkyd enamels, acrylic enamels, urethane enamel basecoat/clearcoat systems and lacquers.

PRODUCTS:

6921 2K Acrylic Urethane Primer, Gallon (3.78 L), 2/case
6934 2K Acrylic Urethane Activator, Quart (0.946 L), 4/case
6937 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 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.



MIX RATIO:

4 parts primer to 1 part activator to 1 part reducer
Pot Life: 1 - 2 hours @ 70° (21°C)



REDUCER:

6700 Series Urethane Grade Reducer or 6700-F Series Zero VOC Urethane Grade Reducer that is suitable for shop conditions.



HVLP/LVLP:

1.6 - 1.8 mm
1 - 3 medium wet coats



10 - 15 minute flash
1.5 - 2.0 mils per coat (dry film thickness)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

77°F (25°C), 50% Humidity 1.5 - 2.5 hours

Cooler temperatures will extend dry times

Force Dry: 30 minutes @ 140°F (60°C) after air drying for 20 - 30 minutes



SANDING:

DA (Dry): #220, finish #320 Hand (Wet): #400, finish #500 - 600

Final wet sand with 600 grit if primer is not sealed before topcoating.

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

6921, 6934, 6937 2K Acrylic Urethane Primer

SUITABLE SUBSTRATES:

Treated Steel, OEM Enamels, Body Filler, Refinish Preparation, Galvanized Steel, Etching Primers Refinish Lacquers, OEM Lacquers, Treated Aluminum, Fiberglass/SMC



SURFACE PREPARATION:

Before sanding: Wash surfaces thoroughly with soap and water. Rinse well and wipe dry with a clean cloth. Solvent clean if necessary with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry with a clean cloth. If necessary, sand repair with 80 grit, followed by 180 grit to feather edge all broken film areas. To remove sanding residue, clean with SCAT and wipe dry with a clean cloth. Note: Treat bare metal with appropriate metal conditioner or Transtar's Self Etching Primers.

APPLICATION & MIXING:

Stir 2K Acrylic Primer thoroughly before activating (preferably by mechanical agitation). Mix 4 parts primer #6921 to 1 part activator #6934/6937 to one part reducer (depending on shop temperature) by volume. Apply 1 - 3 medium wet coats allowing 10-15 minutes flash between coats (1.5 - 2.0 mils per coat). Can be force dried for 30 minutes @ 140°F (60°C) after air drying for 20 - 30 minutes.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.6 - 2.0 mm	35 - 45 PSI (at gun)	n/a
Gravity Feed	1.6 - 2.0 mm	25 - 35 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:	Gray
% SOLIDS:	64%
WEIGHT PER GALLON:	12.5#/gallon
SHELF LIFE:	One year (unopened)
MIX RATIO*:	4:1:1
REDUCER:	6700 Series Urethane Grade Reducer or 6700-F Series Zero VOC Urethane Grade Reducer suitable for shop conditions.
POT LIFE:	1 - 2 hours @ 70°F (21°C) and 50% Relative Humidity
FILM BUILD:	1 - 3 mils per coat
FORCE DRYING:	30 min @ 140°F (60°C)

See website (www.tat-co.com) for this document in other languages.

Vea el Web site (www.tat-co.com) para este documento en español.

Voir le site Web (www.tat-co.com) pour ce document en français.

6921, 6934, 6937

2K Acrylic Urethane Primer

REGULATORY:

Category: Primer 6921	Individual Component	4:1:1 (w/6700 Reducers)	4:1:1 (w/ Zero VOC Reducer)
VOC Actual	4.2#/gal (505 g/l)	4.9#/gal (591 g/l)	4.4#/gal (530 g/l)
VOC Regulatory	4.2#/gal (505 g/l)	4.9#/gal (591 g/l)	4.4#/gal (530 g/l)
Weight % of Volatiles	33.67		
Weight % of Water	0		
Weight % of Exempt Compounds	0		
Volume % of Exempt Compounds	0		
Density of Material	12.52		

Category: Primer 6934 & 6937	Individual Component
VOC Actual	5.24#/gal (628 g/l)
VOC Regulatory	5.24#/gal (628 g/l)
Weight % of Volatiles	68.75
Weight % of Water	0
Weight % of Exempt Compounds	0
Volume % of Exempt Compounds	0
Density of Material	7.63

TECHNICAL TIPS:

CLEANING:

Clean all equipment immediately with lacquer thinner.

PERFORMANCE ADDITIVES

6417 Kicker – 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 – Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.

9194 Universal Urethane Flex Additive – May be used, for use as a specialty coating for elastomeric substrates, refer to TDS for mixing recommendations.

NOTES:

- Excessive application will extend dry times. Maximum recommended dry film is 6 mils.
- If Primer is allowed to dry overnight, scuff sand before recoating.
- Primer should not be mixed with other primer surfacers. Keep container closed when not in use. Do not transfer contents to other containers for storage.
- When using over lacquer, always complete the entire panel. Spot repairs may lift around the repair.

ADVANTAGES:

- Unique formula offers superior adhesion and excellent hold-out.
- No sealing required.
- Quick drying times.

COMPETITION:

DuPont 1141S/1147S
Sherwin Williams P50
Matrix 2KPB

Glasurit 285-51
Spies Hecker 5310
Nason 421-20

PPG K36/K38
Evercoat 2234
Omni MP182

RM Diamont DP20
Marhyde 5553
Rubberseal RS782