

# Technical Data Sheet

Kwik Fill Polyester Primer Surfacer is a catalyzed primer surfacer that offers excellent fill and build capabilities. It can provide one-coat coverage for many applications. Its fast drying and easy sanding features make it the ideal primer for every day use. Kwik Fill's chemical cross-link cure provides excellent sealing and holdout properties when used over body filler repair areas. It has excellent adhesion to a wide range of substrates including metal, galvanized metal, fiberglass, SMC, aluminum, body fillers and polyester glazing putties, and over properly prepared old finishes.

## SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Bare Steel	✓	Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching	✓
Bare Galvanized	✓	Raw Plastic - Flexible (ABD, PPO) +		Primer - 1K	✓
Bare Aluminum	✓	Raw Plastic - Soft (PUR) +		Primer - 2K	✓
OEM E-Coat**	✓	Plastic Part - Primed ++	✓	OEM Finish & Old Paint Work - Reversible	
Fiberglass/SMC Unbroken Gel Coat	✓	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible	✓

\*\* Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter may be required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

## MIXING



By Weight: Add liquid hardener at a rate of 2% by weight  
 Pot Life 45-55 minutes (@70°F (21°C) and 50% relative humidity)

\* Use reducer according to shop conditions. Using urethane grade reducer will increase VOC's. For tinting instructions and the use of additives, please refer to next page.

## FLASH TIMES/DRY TIMES



Flash Between Coats 10-15 minutes  
 Dust Free 30 minutes  
 Dry to Sand 55-65 minutes  
 Force Drying Purge 10 minutes, bake 30 minutes @140°F (60°C)  
 IRT Purge 5 minutes, bake 24-36" for 15 minutes

## SURFACE PREPARATION



Wash all surfaces thoroughly with soap and water. Rinse well and dry with a clean cloth. Clean the area with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry with a clean cloth. Sand as directed on next page.

\* For more information on surface prep and application refer to next page.

## SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.6 - 1.8 mm	1.4 - 1.8 mm
Air Pressure	9.6 PSI @ aircap	40 - 50 PSI @ gun
Mil Thickness:	2.0-3.0 mils per coat (dry film thickness)	

## LIMITATIONS & PRECAUTIONS

- 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.
- See next page for more detailed product application.

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## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.8 mm	1.4-1.8 mm	1.0-1.2 mm	1.6-1.8 mm
Air Pressure	40-50 PSI (@gun)	40-50 PSI (@ gun)	40-50 PSI (@ gun)	9.6 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10-14 PSI	N/A

*Always refer to gun manufacturer's recommendation for proper set up and spray pressure.*

## SURFACE PREPARATION

**Cleaning:** Clean surfaces using standard refinish techniques to avoid contamination. Wash surfaces thoroughly with soap and water. Rinse well and wipe dry with a clean cloth. Solvent clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry with clean cloth.

**Sanding:** Untreated & Galvanized Steel & Bare Aluminum: Sand surface using 180 – 220 grit sandpaper and reclean surface.  
 Body Fillers & Putty: Rough sand filler with 80 grit sandpaper, follow with 180 – 220 grit sandpaper, featheredge with 320 grit paper and blow off with air gun.  
 Plastics (Rigid & Semi-Rigid only): Sand with 180 grit sandpaper and reclean.  
 Prepainted Surfaces: Sand and featheredge using 80 - 220 and finish with 320 on an orbital sander. Reclean surface.

## TINTING & ADDITIVES

**Tinting:** Not recommended.  
**Additives:** Fisheye Remover (6737) - Do not use.  
 Universal Urethane Flex Additive (9194) - Do not use.  
 Kicker (6417): Do not use.

## APPLICATION & FILM BUILD

**Mixing:** Shake and stir contents of can thoroughly before mixing. Add Liquid Hardener at the rate of 2% by weight. (Example: To one quart of primer, add 0.75 oz. of hardener.) Mix primer and hardener thoroughly before adding to gun cup. NOTE: If necessary, this product may be reduced 5 – 10% with acetone to improve pot life, flow-out and dry to sand time.

**Application:** Apply 1 –3 medium wet coats holding gun 8 – 10 inches from surface. Allow primer to flash for 10 – 15 minutes between coats. Do not apply heavy wet-on-wet coats. Avoid dry spray, which must be removed before application of topcoat.

**Film Build:** 2.0 - 2.5 mils per coat (dry film thickness)

## PRODUCT SPECIFICATIONS

Weight per gallon: 11.4	Shelf Life: 1 year
RTS Solids by Weight: 76.8%	Approximate Coverage: 800 ft <sup>2</sup> /gal @ 1 mil
Color: Light Gray	Size: Gallon

## REGULATORY

Category: Primer			
VOC Actual	2.42#/gal (290 g/l)	Weight % of Exempt Compounds	12.85
VOC Regulatory	3.12#/gal (375 g/l)	Volume % of Exempt Compounds	22.2
Weight % of Volatiles	34.1	Density of Material #/gal	11.4
Weight % of Water	0		

**Recommendations:**

- Primer must be shaken for a minimum of 10 minutes.
- Important: When any Transtar product is applied over or under another manufacturer's material/coating, check the all of the appropriate manufacturers' label instructions and Tech Data Sheets. Refer to each manufacturer's recommendations. Test on a small area to assure compatibility.
- Do not allow material to remain in cup longer than 50 minutes. Wash equipment with acetone, lacquer thinner or an appropriate spray gun cleaner.
- Keep lid closed when not in use. Do not return unused mixed material to can.
- Observe flash times to provide good cure times, reduce shrinkage and avoid solvent entrapment.

Visit [www.tat-co.com](http://www.tat-co.com) to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

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