

PRODUCT HIGHLIGHTS

2K Kwik Prime 6441, 6444

DESCRIPTION:

2K Kwik Prime is a two component primer surfacer that can be applied direct to metal surfaces. It is quick drying and easy to sand wet or dry. Kwik Prime provides corrosion protection along with excellent fill and build properties. This unique primer provides improvements in productivity and reduces cycle times while providing significant labor and material savings. May be tinted.

PRODUCTS:

- 6441 2K Kwik Prime, Gallon (3.78 L), 2/case
- 6444 2K Kwik Prime, Quart (0.946 L), 6/case
- 6454 2K Kwik Prime Activator, Quart (0.946 L), 4/case
- 6457 2K Kwik Prime Activator, ½ Pint (236 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: 4:1:1
Hi Build Primer: 4:1
Pot Life: 3 hours @ 70°F (21°C)



REDUCER:

Up to 20% by volume, if desired, using Transtar Zero VOC Urethane Grade Reducer (TDS601) or Urethane Grade Reducer (TDS600) Note: Using regular Urethane Grade reducer will increase VOCs.



HVLP/LVLP:

1.6 - 1.8 mm
2 - 3 medium wet coats



2 - 5 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:

50°F (10°C)	70°F (20°C)	90 °F (32°C)	140°F (60°C) (force dry)
4 - 6 hours	1.5 - 2 hours	1 hour	30 minutes

Recoating without sanding: 30 minutes



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

2K Kwik Prime 6441, 6444

SUITABLE SUBSTRATES:

Degreased and sanded existing finishes, steel*, aluminum and galvanized. Fiberglass (unless the gelcoat is broken), Body filler, Self Etching Primer (TDS209), Epoxy Primers (TDS208).

NOTE: Kwik Prime will provide excellent adhesion and protection if applied direct to bare steel.



SURFACE PREPARATION:

Before sanding, wash all surfaces thoroughly with soap and water. Rinse well and dry with a clean cloth. Solvent 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 120-180 grit. (Sand existing finishes with 180 grit). Featheredge all broken film areas. Wipe all sanded areas with SCAT and wipe dry with a clean cloth before applying Kwik Prime.

APPLICATION & MIXING:

Activate primer according to mix ratios on page 1 dependant on your use (4:1 or 4:1:1). Keep activator tightly closed when not in use to avoid moisture contamination. Stir Kwik Prime thoroughly before use. Apply 2 - 3 medium wet coats, allowing 2 - 5 minutes flash time between coats, using the gun settings listed below. In temperatures below 68°F (20°C), allow a 10 - 15 minute flash time between coats to insure proper cure.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.4 - 1.8 mm	40 - 50 PSI (at gun)	n/a
Gravity Feed	1.4 - 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):	4:1 60% 4:1:1 53%
SHELF LIFE:	Primer: One year (unopened); Activator: One year (unopened)
MIX RATIO:	4:1:1; 4 parts primer, 1 part activator, 1 part reducer for Hi-Build, mix 4:1
ACTIVATOR:	Kwik Prime Actiator #6454/6457
REDUCER:	Up to 20% by volume, if desired, using Urethane Grade Reducer or Zero VOC Reducer suitable for shop conditions.
POT LIFE:	3 hours @ 70°F (21°C) and 50% Relative Humidity
FILM BUILD:	1.5 - 2.0 mils per coat @ 4:1:1 and 2.0 - 2.5 mils per coat @ 4:1
FORCE DRYING:	30 minutes @ 140°F (60°C)
COVERAGE @ 1 mil:	4:1 620 ft ² /gal 4:1:1 516 ft ² /gal.

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.

2K Kwik Prime 6441, 6444

REGULATORY:

Category: Primer	Individual Component 6441/6444	Individual Component 6454/6457	Ready to Use 4:1	Ready to Use 4:1:1 (6700 Series)
VOC Actual	2.8#/gal (340 g/l)	5.9#/gal (705 g/l)	3.5#/gal (413 g/l)	4.1#/gal (494 g/l)
VOC Regulatory	3.6#/gal (427 g/l)	5.9#/gal (705 g/l)	4.1#/gal (494 g/l)	4.8#/gal (571 g/l)
Weight % of Volatiles	35.71	76.32		
Weight % of Water	0	0		
Weight % of Exempt Compounds	11.48	0		
Volume % of Exempt Compounds	20.35	0		
Density of Material	11.88	7.71		

TECHNICAL TIPS:

TINTING:

Can be tinted up to 10% by volume with basecoat mixing toners. Use Transtar's "Star Shade" tint system for optimal hiding capabilities. This system utilizes black, white, and gray primers. Refer to application guide for details.

PERFORMANCE ADDITIVES

6417 Kicker (TDS700) – Do not use.

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) – Do not use.

NOTES:

- On featheredge areas, it is best to use a sealer to prevent lifting by basecoats.

ADVANTAGES:

- 1 Step Direct to Metal Use
- Fast Dry Times
- Superior Corrosion Resisting Properties
- Isocyanate-free
- Easy Sanding Wet or Dry
- Excellent Hold Out
- Tintable

COMPETITION:

DuPont 4001S, 4004S, 4007S

PPG NCP 270, 271

U-Tech, BMP 46

Matrix, MP4-2K

Sikkens, Auto Nova Filler

COMPARE TO THESE 2K URETHANE PRIMERS:

PPG K200

DuPont Uroprime 1120S/1140S

Sherwin Williams UltrafilRM

Diamont DP20