



# True Finish Acrylic Urethane Primer

## 4951-01

**Acrylic Urethane Primer is an acrylic urethane primer surfacer. It sands easily wet or dry and can be directly topcoated with alkyd enamels, acrylic enamels, lacquers, acrylic urethane enamels and base coat/clear coat systems.**



### Mix Ratio

4:1:1 – 4 parts 4951-01 primer to 1 part 5911-04 activators to 1 part 6700 or 6700-F Series Urethane Grade Reducer\*.

Pot life: 2-3 hours (@70°F (21°C) and 50% R.H.).

\* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.



### Suitable Substrates

- Primer - self etching
- Plastic part - primed
- Fiberglass/SMC/Unbroken gel coat
- OEM finish & old paint work - reversible & non-reversible
- 1K Primer
- OEM E-Coat
- 2K Primer
- Body filler

*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:** 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:

Aluminum and galvanized metal: Must be pretreated with an etching or epoxy primer.  
 OEM and Refinish Paints: Must be cured and sanded. Sand with 180 grit.  
 OEM and Refinish Lacquers: Must be sanded. Not recommended for spot repairs over lacquers, as lifting may occur.  
 Body Filler: Must be sanded. Sand with 180 grit.  
 Fiberglass and SMC: Must be sanded. Sand with 180 grit.

**Application:** Apply 2-3 medium wet coats, allowing 5 minute flash between coats. Film build: 1.5-2.0 mils per coat (dry film thickness). Do not exceed 6 mils dry film thickness total.

**Tinting & Additives**

Tinting ..... Can be tinted up to 10% with basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels.

Kicker (6417) ..... Can be used at a rate of 1/2 oz per sprayable quart. Accelerated products should never be used direct-to-metal.

Fisheye Remover (6737) .. Can be used at a rate of 1/4 or 1/2 oz per sprayable quart.

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



**Flash Times/Dry Times**

Flash between coats ..... 5 min

Dry to sand ..... 1-3 hrs

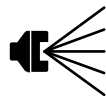
Dry to recoat ..... 45 min

Force drying ..... 30 min @ 140°F (60°C)



**Gun Set-up**

Siphon feed ..... 1.6 - 1.8 mm	Gravity feed ..... 1.6 - 1.8 mm
Pressure feed ..... 1.6 - 1.8 mm	HVLP/LVLP ..... 1.6 - 1.8 mm



**Air Pressure**

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

**Fluid Pressure**

Pressure feed ..... 8 - 10 psi



**Product Specifications**

Color ..... Gray	Size (4951-01) ..... Gallon
Shelf life ..... 3 years	(5911-04) ..... Quart
RTS solids by weight ..... 51%	Weight per gallon ..... 11.53 #/gal
Approx. coverage ..... 511 ft <sup>2</sup> /gal @ 1 mil	

**Regulatory**

**4951-01**

Category ..... Primer	Wt % of volatiles ..... 36.57
VOC actual ..... 3.36#/gal (403 g/l)	Wt % of water ..... 0
VOC regulatory ..... 3.86#/gal (463 g/l)	Wt % of exempt compound ..... 7.38
Density ..... 11.53 #/gal	Vol % of exempt compound ..... 12.87
Ready to use	
RTU actual with 6700 ..... 4.36#/gal (523 g/l)	
RTU regulatory with 6700 .. 4.77#/gal (572 g/l)	
RTU actual with 6700-F ..... 3.12#/gal (374 g/l)	
RTU regulatory with 6700-F .. 4.17#/gal (500 g/l)	

**5911-04**

Category ..... Primer	Wt % of volatiles ..... 68.75
VOC actual ..... 5.24#/gal (628 g/l)	Wt % of water ..... 0
VOC regulatory ..... 5.24#/gal (628 g/l)	Wt % of exempt compound ..... 0
Density ..... 7.63 #/gal	Vol % of exempt compound ..... 0



### Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- This product provides adhesion and corrosion protection when used over noted (checked) substrates - when properly cleaned, sanded and applied.
- When priming over lacquer, it is recommended to coat the complete panel.
- 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.

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### 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.

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