



Tufcote® 1853S™ / 1854S™ / 1856S™ Primer



GENERAL

DESCRIPTION

A single component, fast drying, alkyd primer that delivers good filling properties.

SUGGESTED USES

For use over properly treated substrates such as aluminum, steel and fiberglass. Treat bare steel with 5717S™ or 5718S™ conditioners. Treat aluminum with 225S™ or 226S™ conditioners.

COMPATIBLE COATINGS

Compatible with all Axalta Transportation topcoat systems.

NOT RECOMMENDED FOR

Immersion service and marginally treated metal substrates.
Do not use over galvanized metals.

DRY FILM CHARACTERISTICS

Chemical Resistance	VERY GOOD
Humidity Resistance over treated substrate	VERY GOOD
Weatherability with appropriate topcoat	VERY GOOD
Adhesion	VERY GOOD
Alkali Resistance	VERY GOOD
Solvent Resistance	VERY GOOD

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

MIX RATIO

Thoroughly mix prior to activation. The use of a Cyclone® shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

Component

Tufcote® 1853S™ Primer - Black
Tufcote® 1854S™ Primer - White
Tufcote® 1856S™ Primer - Gray

INDUCTION TIME

No induction is required.

POT LIFE

Indefinite



APPLICATION

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.



APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.
 Pressure Pot
 Gravity Feed
 Siphon Gun
 Airless Spray
 Air Assisted Airless

APPLICATION

- Pressure pot application is recommended to provide the best atomization and delivery. Fluid delivery is recommended at 10-12 fluid oz/min.
- Apply using a cross-coat technique, top-to-bottom, and then side-to-side. Each coat should be medium-wet. No flash time is required between coats.
- Paint heaters can help provide a smoother appearance by controlling the temperature and viscosity of the product, especially under adverse or changing conditions.

APPLICATION SOLVENTS

Ready-to-spray below 3.5 lbs. /gal VOC upon activation. Further reduction may result in greater than 3.5 lbs. /gal VOC.

CLEANUP SOLVENTS

3602S™ Lacquer Thinner
 106™ Lacquer Thinner
 107™ Low VOC Gun Cleaner
 108™ Low HAPS Cleaning Solvent



DRY TIMES

AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

Dry to touch:	30-45 minutes
Tack free:	1-2 hours
Print free:	2-3 hours

Note: Product must be sanded if force dried or allowed to dry for more than 16 hours.

FORCE DRY

30 min at 160-180°F (71-82°C)



PHYSICAL PROPERTIES

Maximum Service Temperature:	150°F (65°C) in continuous service 150°F (65°C) in intermittent heat
Weight Per Gallon (component only)	See below table
Weight Per Liter (component only)	See below table
Suggested Dry Film Thickness	1.5 – 2.0 mils
Gloss	Flat
Color	Black, White, Gray
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

RTS as packaged	1853S	1854S	1856S
Gallon Weight pounds per gallon	10.84	12.06	12.02
Gallon Weight grams per liter	1299	1445	1440
VOC AP pounds per gallon	3.4	3.4	3.4
VOC AP grams per liter	407	404	404
VOC LE pounds. per gallon	3.4	3.4	3.4



VOC LE grams per liter	407	404	404
Weight Solids	68.6%	72.1%	72.0%
Volume Solids	51.4%	51.7%	51.7%
Weight Volatiles	31.4%	27.9%	28.0%
Weight Water	0.0%	0.0%	0.0%
Volume Water	0.0%	0.0%	0.0%
Weight Exempt Solvents	0.0%	0.0%	0.0%
Volume Exempt Solvents	0.0%	0.0%	0.0%
Theoretical Coverage per RTS Gallon at 1 mil DFT	824 ft ² (76.6 m ²)	829 ft ² (77.0 m ²)	829 ft ² (77.0 m ²)

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
1.855.6.AXALTA
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In Canada:
1.800.668.6945
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