

Technical Data Sheet

DTM Waterborne Primer is a gray, premium grade, 1K anti-corrosive waterborne primer surfacer that performs like a 2K product. It provides exceptional flow and leveling along with superior film build and sanding characteristics. This unique, ready to spray formula is fast drying and may also be used as a sealer. It offers excellent adhesion to a wide variety of substrates and can be directly topcoated with: solvent and waterborne basecoats, single stage urethanes, polyurethane enamels, acrylic enamels, synthetic enamels and acrylic lacquers. This primer provides exceptional corrosion resistance when applied direct to metal.

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	✓
Sanded OEM E-Coat**	✓	Plastic Part - Primed ++		OEM Finish & Old Paint Work - Reversible	✓
Fiberglass/SMC 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 maybe 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 Volume: As a Primer: Ready to Spray As a Sealer: Reduce 5% with Waterborne Thinner (50-0081)
 Reduction is not necessary. DO NOT add solvents.
 If needed, Waterborne Thinner, 50-0081, may be added at a max rate of 1 oz per quart
 Pot Life 24 hours (@70°F and 50% relative humidity) in a vented cup, unlimited in a sealed container

FLASH TIMES/DRY TIMES



Flash Between Coats	5-10 minutes			
As a Primer: To Sand @ 50% RH	60°F (15°C): 1.5-2 hours	70°F (20°C): 1-1.5 hours	85°F (30°C): 30 minutes	
As a Primer: To Sand @ 75% RH	60°F (15°C): 2-3 hours	70°F (20°C): 1.5-2 hours	85°F (30°C): 1-1.5 hours	
As a Primer: Force Drying	30 minutes @ 140°F (60°C)			
As a Sealer: Topcoating	45 - 60 minutes or 30 minutes after surface has flashed dull			

Note: For best results, allow primer to flash dull between coats.

SURFACE PREPARATION



Steel: finish with 180-220 grit
 Aluminum: finish with 150-220 grit
 Existing finishes: finish with 220-400 grit
 Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Wipe dry with clean cloth. Sand all areas that will be primed with DTM Waterborne Primer.
 * 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	1.7 - 2.0	1.7 - 2.0
Air Pressure	10 PSI @ aircap	20 - 30 PSI @ regulator
Mil Thickness: 1.5 - 2.0 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.
- See next page for more detailed product application.

Visit 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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SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.7 - 2.0	1.7 - 2.0	1.2 - 1.6	1.7-2.0 mm
Air Pressure	30 - 40 PSI	20 - 30 PSI	30 - 40 PSI	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10 - 15 PSI	N/A

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

SURFACE PREPARATION

Cleaning: Wash surfaces thoroughly with soap and water. Rinse well and dry with a clean, lint free cloth. Clean the surface using SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Wipe dry with a clean cloth.

Sanding: Finish sand all areas to be primed with 150-400 grit sandpaper based on recommendations on previous page for substrate you are priming over. For full panel and spot repairs, refer to SOP's 111 and 116.

TINTING & ADDITIVES

Tinting: Not recommended.

Additives: Fisheye Remover (6737) - Do not use.
Kicker (6417) - Do not use.

Universal Urethane Flex Additive (9194) - Do not use.

Waterborne Thinner (50-0081) - Use per instructions to maintain corrosion resistance. Note: Use of tap water can introduce minerals into the primer that can adversely effect corrosion resistance.

APPLICATION & FILM BUILD

Mixing: Stir thoroughly before use. Can be installed on a mixing bank. DO NOT MIX on a paint shaker. No reduction needed, ready to spray. Note: DTM Waterborne Primer has excellent anti-settling properties, so hand stirring is usually sufficient.

Application - As a Primer: Spray 1-3 medium wet coats. Allow a 5-10 minute flash (for best results, allow primer to flash dull between coats). Final coat should be allowed to dry 30 minutes after primer has flashed dull before wet or dry sanding (based on shop climate of 70°F (21°C) and 50% R.H.). Sand primed areas prior to topcoating according to topcoat manufacturer's recommendations.

Film Build: 1.5 - 2.0 mils per coat (dry film thickness) Note: When used direct to steel, minimum film build should be 2.0 mils (after sanding) for best corrosion protection.

Application - As a Sealer: Apply 1 coat of DTM Waterborne Primer and allow 45-60 minutes flash before topcoating or 30 minutes after primer has flashed dull (air movement is very helpful). Topcoat without sanding. For best results, reduce with 5% Waterborne Thinner 50-0081.

Critical Recoat Time: After 4 days, primer should be properly cleaned and lightly sanded (320-400 grit) prior to recoating.

PRODUCT SPECIFICATIONS

Weight per gallon: 10.5 -11 #/gal	Shelf Life: 3 years
RTS Solids by Weight: 54%	Approximate Coverage: 653 ft ² /gal @ 1 mil
Color: Gray	Size: Gallon (32-0051), Quart (32-0054)

REGULATORY

Category: Primer			
VOC Actual	0.51#/gal (61 g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	1.07#/gal (129 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	45.7	Density of Material #/gal	10.76
Weight % of Water	41.0		

Recommendations:

- DO NOT FREEZE. Product must be stored above 41°F (5°C). Do not apply material when temperature is below 60°F (15°C). Exposure to cold temperatures may cause material to thicken.
- DO NOT MIX ON A PAINT SHAKER.
- If the paint skins in the can, do not try to mix it in. Waterbased skins will not redissolve. Instead pull the skin out and dispose of it.
- Product will not "set up" in the cup, but avoid skinning over by keeping the cup covered.
- Good air movement greatly improves dry times. To increase speed of drying, apply cross draft only. Do not apply direct air to panel.

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