



DTM Primer

32-0231

DTM Primer is a 2K high-build, urethane primer surfacer that can be applied directly to bare metal surfaces. It provides corrosion protection along with excellent fill and build properties.



Mix Ratio

As a primer 4:1 - 4 parts primer (32-0231) to 1 part activator (40-0244)

As a sealer 4:1:1 - 4 parts primer to 1 part activator to 1 parts reducer*

Pot life: 2-3 hrs (@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
- Fiberglass/SMC gel coat
- Bare steel
- Body filler
- OEM finish & old paint work - reversible and non-reversible
- 1K primer
- Plastic part - primed
- Bare galvanized
- Raw plastic - rigid (SMC, BMC)
- 2K primer
- OEM E-Coat
- Bare aluminum

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: OEM and refinish paints and lacquers: Must be cured and sanded. Refinish lacquers require entire panel repair.

Body filler, fiberglass, SMC: Must be sanded.

As a sealer: Sanded and degreased existing finish and primers.

Application: Primer: Stir DTM Primer thoroughly before use. Mix 4 parts primer to 1 part activator. Apply 2 -3 medium wet coats, allowing 10 - 15 minutes flash time between coats.

Non-Sanding Sealer: Mix 4 parts primer to 1 part activator to 1 part reducer. Apply 1 medium wet coat. Flash for 20 minutes before topcoating. If applying 2 coats of 32-0231, flash for 30 minutes before topcoating. Denib with 600 wet or dry. After two hours, it will be necessary to sand the sealer with 500-600 grit sandpaper to ensure good basecoat adhesion.

Film build: 1.5-2.0 mils per coat (dry film thickness). Do not exceed 6 mils dry film thickness total.

Tinting & Additives

Tinting Not recommended.
 Kicker (6417) Not recommended.
 Fisheye Remover (6737) .. Can be used at a rate of 1/4 to 1/2 oz per sprayable quart.
 Flex Additive (9194) May be used, refer to TDS for mixing recommendations.



Flash Times/Dry Times

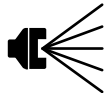
As a primer
 Flash between coats..... 10-15 min
 Dry to sand..... 1-3 hrs
 Force drying 30 min @ 140°F (60°C)

As a sealer
 To recoat 20 min
 Denib 20-30 min
 Dry to recoat w/o sand... 2 hrs
 Force drying 30 min @ 140°F (60°C)



Gun Set-up

Siphon feed..... 1.6 - 2.0 mm	Gravity feed..... 1.6 - 1.8 mm
Pressure feed 1.0 - 1.2 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 (32-0231)..... Light gray	Size (32-0231) Gallon
(40-0244)..... Activator	(40-0244) Quart
Weight per gallon..... 12.2 #/gal	Shelf life 3 years
Approx. coverage (primer) .. 647 ft ² /gal @ 1 mil	
(sealer) ... 541 ft ² /gal @ 1 mil	
RTS solids by weight (primer) 58.6%	
(sealer using 6700 series) 52.1%	
(sealer using 6700-F series) 50.3%	

Regulatory

32-0231

Category	Primer	Wt % of volatiles.....	35.09
VOC actual	1.39#/gal (167 g/l)	Wt % of water	0
VOC regulatory	2.23#/gal (267 g/l)	Wt % of exempt compound	23.62
Density	12.2 #/gal	Vol % of exempt compound	37.36
Regulatory ready to use			
4:1	2.07#/gal (248 g/l)		
4:1:1 w/6700 series.....	3.46#/gal (415 g/l)		
4:1:1 w/6700-F series	2.07#/gal (248 g/l)		

40-0244

Category	Primer	Wt % of volatiles.....	70.72
VOC actual	0.34#/gal (41 g/l)	Wt % of water	0
VOC regulatory	0.94#/gal (113 g/l)	Wt % of exempt compound	67.47
Density	10.52 #/gal	Vol % of exempt compound	63.73



Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- Observe flash times to provide good cure times to reduce shrinkage.
- Best adhesion results are achieved if topcoated within 8 hours, best holdout is achieved if primer is allowed to cure overnight.
- When using over lacquer, always complete the entire panel. Spot repairs may lift around the repair.
- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (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.

LIMITED WARRANTY

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