



Euro Classic DTM Primer

7341, 7344, 7361, 7364, 7371, 7374

Euro Classic DTM Primer is a 2K primer surfacer that can be applied directly to bare metal surfaces. It 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. This primer can also be tinted using Transtar's "Star Shade" system for a better match.



Mix Ratio

As a primer surfacer 4:1 - 4 parts primer to 1 part activator

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

Pot life: 3 hrs (@77°F (25°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

- Bare steel
- Primer - self-etching
- Fiberglass/SMC gel coat
- Raw plastic - rigid (SMC, BMC)
- Bare galvanized
- 1K primer
- Body filler
- OEM finish & old paint work - non-reversible
- Bare aluminum
- 2K primer
- OEM E-Coat

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: Steel and galvanized should be sanded using an 80 grit abrasive. Aluminum should be sanded with 150-180 grit abrasive.

Body filler should be sanded with 80 grit followed by 120-180 grit abrasive.

Existing finishes and OEM E-Coat should be sanded with 180-240 grit.

As a sealer, finish sand with 400-600 grit. Featheredge all broken film areas. Clean all sanded areas with SCAT and wipe dry with a clean cloth before priming.

Application: As a primer surfacer: Stir primer thoroughly before use. Mix 4 parts primer with 1 part activator 7354/7357. Apply 2 - 3 medium wet coats, allowing 5 - 10 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.

As a rollable primer: Stir primer thoroughly before use. Mix 4 parts primer with 1 part activator 7354/7357 with 1 part Urethane Grade Reducer (6700 or 6700-F Series).

Using a small roller apply even strokes. Allow 5 - 7 minute flash time before applying additional coats.

As a sealer: Stir primer thoroughly before use. Mix 4 parts primer with 1 part activator 7354/7357 with 1 part Urethane Grade Reducer (6700 or 6700-F Series). Flash 20-30 minutes before base/clear recoat.

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% 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. See chart below for more details.

Kicker (6417) Do not use.

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

Flex Additive (9194) Do not ue.



Flash Times/Dry Times

Flash between coats..... 5-10 min

Dry to sand..... 1-6 hrs

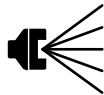
Recoat w/o sand 20 min up to 1 hr

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



Gun Set-up

Siphon feed..... 1.4 - 1.8 mm	Gravity feed..... 1.4 - 1.8 mm
Pressure feed 1.0 - 1.2 mm	HVLP/LVLP 1.4 - 1.8 mm



Air Pressure

Siphon feed (@ gun) 40 - 50 psi	Gravity feed (@ gun) 30 - 40 psi
Pressure feed (@ gun)..... 40 - 50 psi	HVLP/LVLP (@ aircap)..... 10 psi

Fluid Pressure

Pressure feed 10 psi



Product Specifications

Color (7341/7344)..... Gray	Size (7341/7361/7371) Gallon
(7361/7364)..... White	(7344/7354/7364/7374) Quart
(7371/7374)..... Black	(7357)..... 1/2 pint
(7354/7357)..... Activator	Weight per gallon..... 12.49 #/gal
Approx. coverage (4:1)..... 708 ft ² /gal @ 1 mil	RTS solids by weight (4:1)..... 66%
(4:1:1) 590 ft ² /gal @ 1 mil	(4:1:1) 57%
Shelf life..... 3 years	

Regulatory

7341, 7344

Category	Primer/Primer Sealer	Wt % of volatiles.....	31.56
VOC actual	1.0#/gal (120 g/l)	Wt % of water	0
VOC regulatory	1.62#/gal (194 g/l)	Wt % of exempt compound	23.79
Density	12.87 #/gal	Vol % of exempt compound	38.21
Regulatory ready to use			
4:1	2.0#/gal (239 g/l)		
4:1:1 w/6700 series.....	3.29#/gal (394 g/l)		
4:1:1 w/6700-F series	2.0#/gal (239 g/l)		

7354, 7357

Category	Primer/Primer Sealer	Wt % of volatiles.....	60.41
VOC actual	2.44#/gal (293 g/l)	Wt % of water	0
VOC regulatory	3.25#/gal (389 g/l)	Wt % of exempt compound	32.03
Density	8.61 #/gal	Vol % of exempt compound	24.76








7361, 7364

Category	Primer/Primer Sealer	Wt % of volatiles.....	28.29
VOC actual	1.05#/gal (126 g/l)	Wt % of water	0
VOC regulatory	1.60#/gal (192 g/l)	Wt % of exempt compound	20.25
Density	13.03 #/gal	Vol % of exempt compound	34.56
Regulatory ready to use			
4:1	1.97#/gal (236 g/l)		
4:1:1 w/6700 series.....	3.22#/gal (386 g/l)		
4:1:1 w/6700-F series	1.97#/gal (236 g/l)		

7371, 7374

Category	Primer/Primer Sealer	Wt % of volatiles.....	30.55
VOC actual	1.04#/gal (125 g/l)	Wt % of water	0
VOC regulatory	1.63#/gal (196 g/l)	Wt % of exempt compound	22.15
Density	12.40 #/gal	Vol % of exempt compound	36.15
Regulatory ready to use			
4:1	2.0#/gal (240 g/l)		
4:1:1 w/6700 series.....	3.26#/gal (391 g/l)		
4:1:1 w/6700-F series	2.0#/gal (240 g/l)		

Star Shade Mix Ratio

SS1	SS2	SS3	SS4	SS5	SS6	SS7
						
7341/7344 as packaged	2 parts 7361 1 part 7341	1 part 7361 2 parts 7341	7341/7344 as packaged	2 parts 7341 1 part 7371	1 part 7341 2 parts 7371	7371/7374 as packaged



Limitations & Precautions

- Primer must be shaken for a minimum of 10 minutes.
- Primer should not be mixed with other primer surfacers. Keep container closed when not in use. Do not transfer contents to other containers for storage.
- On feathered edge areas, to prevent lifting of basecoats you can also seal with a coat of 7300 Series Euro Classic DTM Primer mixed 4:1:1.
- 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.

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