

Technical Data Sheet

Euro Classic DTM Primer is a 2K primer surfacer that can be applied directly to bare metal surfaces. It is quick drying and easy to sand wet or dry. 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.

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	✓
OEM E-Coat**	✓	Plastic Part - Primed ++		OEM Finish & Old Paint Work - Reversible	
Fiberglass/SMC Unbroken 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 may be 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: 4:1
 As a Primer 4 Part Primer (7341, 7344, 7361, 7364, 7371, 7374)
 Surfacer 1 part Activator (7354, 7357)

By Volume 4:1:1
 As a Primer 4 Part Primer (7341, 7344, 7361, 7364, 7371, 7374)
 Sealer or 1 part Activator (7354, 7357)
 Rollable Primer 1 part Urethane Grade Reducer (6700 or 6700-F Series)

Pot Life 3 hours (@77°F (25°C) and 50% relative humidity)

* Use reducer according to shop conditions. For tinting instructions and the use of additives, please refer to next page.

FLASH TIMES/DRY TIMES



Flash Between Coats 5-10 minutes
 Dry to Sand 1-6 hours
 Dry to Recoat w/o Sanding 20 minutes up to 4 hours
 Force Drying 30 minutes @140°F (60°C)

SURFACE PREPARATION



Wash surface with soap and washer. Rinse well and wipe dry with a clean cloth. Solvent clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe completely dry. See next page for sanding information.

* 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	1.4 - 1.8 mm	1.4 - 1.8 mm
Air Pressure	10 PSI @ aircap	30-40 PSI @ gun
Mil Thickness: 1.5-2.5 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.
- If mixed with other components, mixture may be hazards of all combined components.
- See next page for more detailed production application.

Technical Data Sheet

SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.8 mm	1.4-1.8 mm	1.0-1.2 mm	1.4-1.8 mm
Air Pressure	40-50 PSI (@gun)	30-40 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	10 PSI	N/A

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

SURFACE PREPARATION

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.

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.

Additives: Fisheye Remover (6737) - Can be used at a rate of ¼ to ½ oz per sprayable quart.
 Universal Urethane Flex Additive (9194) - Do not use.
 Kicker (6417): Do not use.

APPLICATION & FILM BUILD

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.

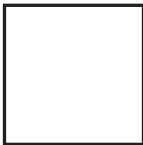
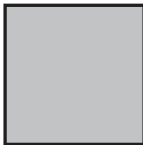





As a sealer: Stir primer thoroughly before use. Mix 4 parts primer with 1 part activator 7354/7357 with 1 part Urethane Grade Reducer (6700 or 6700-F Series). Flash 20-30 minutes and no longer than 4-6 hours before topcoating.

Film Build: 1.5-2.5 mils per coat (dry film thickness)

PRODUCT SPECIFICATIONS

Weight per gallon: 12.49	Shelf Life: 3 years
RTS Solids by Weight: 4:1 - 66% 4:1:1 - 57%	Approximate Coverage: 4:1 - 708 ft ² /gal @ 1 mil 4:1:1 - 590 ft ² /gal @ 1 mil
Color: White (7361/7364), Gray (7341/7344), Black (7371/7374), Activator (7354/7357)	Size: Gallon (7341/7361/7371), Quart (7344/7354/7364/7374), ½ pint (7357)

STAR SHADE MIX RATIOS

SS1	SS2	SS3	SS4	SS5	SS6	SS7
						
7361/7364 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

Recommendations:

- 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 featheredge 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 you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

Technical Data Sheet

REGULATORY

Category: Primer Sealer/Primer Surfacer	7341/7344	7361/7364	7371/7374	7354/7357
VOC Actual	1.0#/gal (120 g/l)	1.05#/gal (126 g/l)	1.04#/gal (125 g/l)	2.44#/gal (293 g/l)
VOC Regulatory	1.62#/gal (194 g/l)	1.60#/gal (192 g/l)	1.63#/gal (196 g/l)	3.25#/gal (389 g/l)
Weight % of Volatiles	31.56	28.29	30.55	60.41
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	23.79	20.25	22.15	32.03
Volume % of Exempt Compounds	38.21	34.56	36.15	24.76
Density of Material #/gal	12.87	13.03	12.40	8.61
VOC Actual RTS (4:1)	1.29#/gal (154 g/l)	1.33#/gal (159 g/l)	1.32#/gal (158 g/l)	
VOC Regulatory RTS (4:1)	2.0#/gal (239 g/l)	1.97#/gal (236 g/l)	2.0#/gal (240 g/l)	
VOC Actual RTS (4:1:1) 6700 Series Reducer	2.31#/gal (277 g/l)	2.35#/gal (281 g/l)	2.34#/gal (281 g/l)	
VOC Regulatory RTS (4:1:1) 6700 Series Reducer	3.29#/gal (394 g/l)	3.22#/gal (386 g/l)	3.26#/gal (391 g/l)	
VOC Actual RTS (4:1:1) 6700-F Series Reducer	1.07#/gal (129 g/l)	1.11#/gal (133 g/l)	1.1#/gal (132 g/l)	
VOC Regulatory RTS (4:1:1) 6700-F Series Reducer	2.0#/gal (239 g/l)	1.97#/gal (236 g/l)	2.0#/gal (240 g/l)	