

Technical Data Sheet

No Mix DTM Primer is a direct to metal 2K primer surfacer. 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. No Mix DTM Primer is iso-free and eliminates the need for a self-etch primer.

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 parts LV-681 DTM Primer
1 part LV-694 DTM Primer Activator

Pot Life 3 hours (@70°F (21°C) and 50% relative humidity)

FLASH TIMES/DRY TIMES



Flash Between Coats 5-10 minutes
Dust Free 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 water. 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	1.4 - 1.8
Air Pressure	10 PSI @ aircap	30 - 40 PSI @ gun inlet
Mil Thickness:	1.5-2.5 mils per coat (dry film build)	

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 production application.

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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	8-10 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 No Mix basecoat toners. Use only unreduced basecoat when tinting. DO NOT tint with single stage urethane or acrylic enamels.

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

APPLICATION & FILM BUILD

Stir primer thoroughly before use. Mix 4 parts primer with 1 part activator LV-694. 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.

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

PRODUCT SPECIFICATIONS

Weight per gallon: 12.56	Shelf Life: 3 years
RTS Solids by Weight: 67%	Color: Gray
Approximate Coverage: 715 ft ² /gal @ 1 mil	Size: Gallon

REGULATORY

Category: Primer Sealer/Primer Surfacer	LV-681	LV-694
VOC Actual	1.0#/gal (120 g/l)	2.44#/gal (293 g/l)
VOC Regulatory	1.62#/gal (194 g/l)	3.25#/gal (389 g/l)
Weight % of Volatiles	30.58	60.41
Weight % of Water	0	0
Weight % of Exempt Compounds	23.79	32.03
Volume % of Exempt Compounds	38.21	24.76
Density of Material #/gal	12.56	8.61
VOC Actual RTS (4:1)	1.29#/gal (154 g/l)	
VOC Regulatory RTS (4:1)	2.0#/gal (239 g/l)	

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).

TRANSTAR AUTOBODY TECHNOLOGIES • 2040 HEISERMAN DRIVE, BRIGHTON, MI 48114 • (800) 824-2843

FAX (800) 477-7923 • EMAIL: info@tat-co.com