









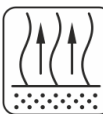
TECHNICAL INFORMATION

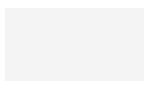




FOR PROFESSIONAL USE ONLY

MULTI DTM 4:1 ACRYLIC PRIMER		
PRODUCTS		
MULTI DTM 4:1 Acrylic Primer Hardener 1:4 for MULTI DTM Thinner for acrylic products		
PRODUCT DESCRIPTION		
<p>High-quality 2-component multifunctional acrylic primer with the addition of anti-corrosion agents, intended for car repairs. Thanks to the use of advanced technology and high-class ingredients, MULTI DTM has a very wide range of applications. It works perfectly both as a filling undercoat and an insulating primer. It can be applied directly to metal, providing excellent corrosion protection for areas ground to bare steel. It insulates very well difficult substrates and putty areas from varnish coatings, protecting them against the effect of the so-called mapping. An additional advantage of the primer is the possibility of applying the "wet on wet" technique, without the need for sanding.</p> <p>The undercoat is available in 3 colors: gray, white and black. Mixing the available colors in the right proportions allows you to obtain 2 additional colors, which allows you to work in the full spectrum grey system and select the recommended base color for the target base color.</p> <p>Benefits:</p> <ul style="list-style-type: none"> • Excellent anti-corrosion protection of steel. • Strong adhesion to various types of surfaces. • Very good insulating and filling properties. • Very short curing time. • Can be applied using the "wet on wet" technique. • Working in the spectral grey system. 		
		COLOUR: white, grey, black
		GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS	
VOC for mixture = 539 [g/l] for the mixture 4+1+20% The share of VOC is below 540 g/l. These products meet the EU directive (2004/42/EC/II B) that sets the VOC value for its category (C), at 540 g/l. The requirements of the directive are not met for the wet on wet version.	
SURFACE PREPARATION	
Acrylic primer MULTI DTM 4:1 can be applied over: <ul style="list-style-type: none"> • Bare steel and aluminum after matting and degreasing • Zinc coated, galvanized steel. • Polyester laminates (GFK/GRP). • Wash primers. • 2-pack polyester putties, polyester spraying fillers. • 2-pack acryl fillers. • 2-pack epoxy fillers. • Old finishes in good condition. 	Good Surface preparation is necessary to achieve the best results of repairs. Recommended abrasive paper with gradation as follows: - Sanding by hand (dry) : P280÷P400; (wet) P400-P800. - Sanding by machine (dry) : P240÷P400.

APPLICATION PROCESS			
	USE		SPRAYING VISCOSITY
	For car repairs as a filling or grounding primer for sanding or wet on wet		40 ÷ 30 seconds at 20°C for the filling version (at 5-10% thinner) 25 ÷ 20 seconds at 20°C for the grounding version (at 15-20% thinner) 19 ÷ 17 seconds at 20°C for wet on wet version (at 25-30% thinner)
	DRY SANDING Grinding Machine: P360÷P500. Hand Sanding: P320÷P500.		WET SANDING Grinding Machine: P600÷P1000. Hand Sanding: P800÷P1000. Wet on wet does not require sanding!

	MIXING RATIO by volume by weight		NUMBER OF LAYERS:	
	Primer 4 parts 100 Hardener 1 part 17,4 Thinner 5-10% as filling primer 15- 20% as grounding primer 25-30% as wet on wet Stir thoroughly until achieving homogenous mixture.		grinding version: 1 ÷ 2 layers filling version - about 80 µm for a single dry layer. grounding version - approx. 50 µm for a single dry layer. Parameters for the RP gun Nozzle: 1.6 ÷ 2.0 mm; pressure: 2.0 ÷ 2.2 bar. Parameters for the HVLP gun Nozzle: 1.5 ÷ 1.7 mm; pressure: 2.0 bar.	wet on wet version: 1.5 layers approx. 30 µm for a single dry layer. Parameters for the RP gun Nozzle: 1.2 ÷ 1.4 mm; pressure: 2.0-2.2 bar. Parameters for the HVLP gun Nozzle: 1.3 ÷ 1.5 mm; pressure: 2.0 bar.
	POT LIFE approx. 15 minutes at 20°C for the filling and grounding version approx. 20 minutes at 20°C for wet on wet version		EVAPORATION TIME	
	HARDENING TIME At 20°C: Grounding version / 50 ÷ 100 µm / ready to sand after 1.5 ÷ 2.5 h. Filling version / 80 ÷ 160 µm / ready to sand after 2 ÷ 3 h. Curing time at an object temperature of 60°C Grounding version / 50 ÷ 100 µm / ready to sand after baking for 15 ÷ 20 minutes and cooling the coating (about 1h). Filling version / 80 ÷ 160 µm / ready for grinding after baking for 20 ÷ 30 minutes and cooling the coating (about 1h). Temperature lower than 20°C is extending hardening time.		between layers: 5-10 minutes before applying solvent base: approx. 20 minutes before applying water base: approx. 30 minutes Evaporating time depends on temperature and layer thickness.	IR DRYING Grounding version /50-100 µm/: 6-8 minutes under short wave. Filling version /80-160 µm/: 8-10 minutes under short wave. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.

COLOURS			
COLOUR	SHADE OF GREY	MIXING RATIO % BY WEIGHT	RECOMMENDED BASE COLOR
	RAL 9003	100% white	orange, white, yellow
	RAL 7040	100% grey	red (shades of red)
	RAL 7045	13 : 87 (black : grey)	light grey, light green, light blue, dark red
	RAL 7015	64,3 : 35,7 (black : grey)	grey, blue, dark green
	RAL 9004	100% black	black

In order to obtain the color RAL 7015 and 7045, the black and gray primer should be mixed in the following proportions by volume					
RAL 7045	100 ml	250 ml	500 ml	750 ml	1000 ml
BLACK	13 ml	33 ml	67 ml	100 ml	134 ml
GREY	87 ml	217 ml	433 ml	650 ml	866 ml

RAL 7015	100 ml	250 ml	500 ml	750 ml	1000 ml
BLACK	65 ml	162 ml	325 ml	487 ml	649 ml
GREY	35 ml	88 ml	175 ml	263 ml	351 ml

In order to obtain the color RAL 7015 and 7045, the black and gray primer should be mixed in the following weight proportions					
RAL 7045	141 g (100 ml)	353 g (250 ml)	706 g (500 ml)	1059 g (750 ml)	1413 g (1000 ml)
BLACK	18 g	46 g	92 g	138 g	184 g
GREY	123 g	307 g	614 g	921 g	1229 g

RAL 7015	140 g (100 ml)	348 g (250 ml)	697 g (500 ml)	1045 g (750 ml)	1393 g (1000 ml)
BLACK	90 g	224 g	448 g	672 g	896 g
GREY	50 g	124 g	249 g	373 g	497 g

FURTHER WORK

2K acrylic fillers can be directly over coated with:

- 2K top coats.
- 1K base coats.

And also:

- 2K polyester putties
- 2K acrylic primers

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar
- When working with 2K products, it is recommended to use personal protection. equipment. Protect the eyes and respiratory system.
- Clean the guns and equipment immediately after use.
- The rooms should be well ventilated.

Caution: To maintain safety, always follow the instructions given in the MSDS for the products.

STORAGE

Store the product components between 15 to 25 °C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. Close the container after use.
2. Protect the hardener from frost and dampness

WARRANTY PERIOD

MULTI DTM 4:1	– 12 months from the production date.
Hardener 1:4 for MULTI DTM	– 12 months from the production date.

PRODUCTS	NR ART
MULTI DTM 4:1	(0,8l + 0,2l): 14700; 14701; 14702 (3,6l): 14696; 14697; 14698
Hardener 1:4 for MULTI DTM	14699 (0,9l)
Thinner for acrylic products	300002258; 300002260 (1l; 5l)

LIMITATION OF LIABILITY:

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and evaluation of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information is based on meticulous laboratory tests and many years of experience. An established position on the market does not release us from continuous quality control of our products. However, we are not responsible for the final effects of improper storage or use of our products, and for work that is not in line with good craftsmanship.

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