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TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

DTM MULTI 4:1

2K URETHANE PRIMER SEALER

PRODUCTS

DTM MULTI 4:1 – 2K Urethane Primer Sealer
Hardener 1:4 for DTM MULTI
Urethane Reducers INTER TROTON

PRODUCT DESCRIPTION

2K urethane DTM primer / sealer with anticorrosive pigments. Versatile product with direct application to metal, can be used either as an isolation or a high build primer depending on the amount of reducer added. Features high anticorrosive properties, short hardening time and great smooth finish. Suitable for wet-on-wet application with no sanding required. Available in grey, white and black.

COLORS: grey, white, black

GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS

VOC for mixture 4+1+20% = 539 [g/l] - 4.497 [lb/gal]
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

The urethane primer DTM MULTI 4:1 can be applied over:

- Bare steel and aluminum after matting and degreasing.
- Zinc coated, galvanized steel after matting and degreasing.
- Sanded polyester laminates (GFK/GRP).
- Wash primers.
- Polyester putties/body fillers and primers.
- Isolation primers.
- Old finishes in good condition after matting and degreasing.

Good surface preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

- sanding by hand (dry): P280÷P400; (wet) P400-P800.
- sanding by machine (dry): P240÷P400.

APPLICATION PROCESS

USE

For car repairs as a grounding primer for sanding (filling or priming option) and for the application with so-called wet-on-wet technique.

MIXING RATIO

	by volume	by weight
Primer	4 parts	100
Hardener	1 part	17.4
Reducer:		
filling option	5÷10%	
grounding option	15÷20%	
wet-on-wet option	25÷30%	

Stir thoroughly until achieving homogenous mixture.

NUMBER OF COATS & SPRAY GUN SETTINGS

Sanding option: 1÷2 coats

- filling version - about 80 µm (3.15 mil) per single dry coat.
- grounding version - approx. 50 µm (1.97 mil) per single dry coat.

Compliant (RP) spray gun: 1.6÷2.0 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar)
HVLP spray gun: 1.5÷1.7 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar).

Wet-on-wet option: 1.5 coats. approx. 30 µm (1.18 mil) per single dry coat.
Compliant (RP) spray gun: 1.2÷1.4 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar)
HVLP spray gun: 1.3÷1.5 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar).

SPRAYING VISCOSITY

Filling option (at 5÷10% reducer): 40÷30 sec at 20°C (68°F)/DIN4
Grounding option (at 15÷20% reducer): 25÷20 sec at 20°C (68°F)/DIN4
Wet-on-wet option (at 25÷30% reducer): 19÷17 sec at 20°C (68°F)/DIN4

HARDENING TIME

Hardening time at 20°C (68°F):

- Grounding version (50–100µm/2.0–3.9mil): ready for sanding after 1.5 ÷ 2.5 h.
- Filling version (80–160µm/3.1–6.3mil): ready for sanding after 2 ÷ 3 h.

Curing time at an object temperature of 60°C (140°F)

- Grounding version (50–100µm/2.0–3.9mil):

	**POT LIFE** **Filling option**: approx. 15 minutes at 20°C (68°F) **Grounding option**: approx. 15 minutes at 20°C (68°F) **Wet-on-wet option**: approx. 20 minutes at 20°C (68°F)		ready for sanding after baking for 15 ÷ 20 minutes and cooling the coating (about 1h). • Filling version (80–160µm/3.1–6.3mil): ready for grinding after baking for 20 ÷ 30 minutes and cooling the coating (about 1h). Temperature below 20°C (68°F) significantly increases the hardening time.
	**EVAPORATION TIME** Between coats: 5÷10 minutes Before applying solvent base: approx. 20 minutes Before applying water base: approx. 30 minutes Evaporating time depends on temperature and coat thickness.		
	**DRY SANDING** Machine sanding: P360÷P500. Hand sanding: P320÷P500. **Wet-on-wet doesn't require sanding!**		**IR DRYING** **Grounding version** 50–100 µm (2.0–3.9 mil) dry film thickness: 6÷8 minutes under short waves. **Filling version** 80–160 µm (3.1–6.3 mil) dry film thickness: 8÷10 minutes under short waves. Do not exceed 60°C (140°F) Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	**WET SANDING** Machine sanding: P600÷P1000. Hand sanding:: P800÷P1000. **Wet-on-wet doesn't require sanding!**		

FURTHER WORK

2K urethane primers can be directly over coated with:

- 2K top coats.
- 1K basecoats.

Also:

- 2K polyester putties and body fillers.
- 2K urethane 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.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

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 (59 to 77°F) in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. After each use the container with product should be immediately closed!

2. Protect the hardener from frost and dampness!

WARRANTY PERIOD

DTM MULTI 4:1 - Urethane Primer Sealer	– 12 months from the date of production
Hardener 1:4 for DTM MULTI	– 12 months from the date of production
Urethane Reducers INTER TROTON	– 24 months from the date of production

PRODUCTS	ART. No.
DTM MULTI 4:1 - Urethane Primer Selaer	(0.8l+0.2l): 14556, 14554, 14555 (3,75l): 14560, 14558, 14559
Hardener MEDIUM 1:4 for DTM Primer Sealer	(0,94l): 14561
Urethane Reducers INTER TROTON	300009942; 300009943 (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 application 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.

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All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the

constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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