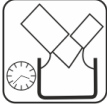


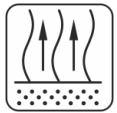
TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

DTM SPEED 4:1 2K URETHANE PRIMER	
PRODUCTS	
DTM SPEED 4:1 2K Urethane Primer Hardener 1:4 for 2K Urethane Primer DTM SPEED Urethane Reducers INTER TROTON	
PRODUCT DESCRIPTION	
2K urethane primer with very high solids content. New technology formulation developed to make the repair process quicker and easier. Features great leveling effect and super fast drying, which allows for sanding after only 60 minutes from application at 68°F. Compatible with both waterborne and solvent based paint systems. Available in grey, white and black.	
	
COLORS: white, grey, black	
GLOSS GRADE: matt	

VOLATILE ORGANIC COMPOUNDS	
VOC for mixture = 420 [g/l] – 3,505 [lb/gal] This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l.	
SURFACE PREPARATION	
DTM SPEED 4:1 2K Urethane Primer can be applied over: - Steel and aluminum after flatting and degreasing. - Zinc coated steel after flatting and degreasing. - Sanded polyester-glass laminates (GFK/GRP). - Polyester putties and body fillers. - Epoxy primers. - Wash primers. - Old finishes in good condition after flatting and degreasing	Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended: - Sanding by hand (dry or wet): P280÷P320 (GRP P400). - Sanding by machine (dry): P180÷P220.

APPLICATION PROCESS			
	USE		NUMBER OF COATS & SPRAY GUN SETTINGS
	For car repairs as a filling primer.		2÷3 coats. Approximately 70–90 µm (2.8–3.5 mils) per 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÷1.9 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar).
	MIXING RATIO by volume		HARDENING TIME
	Primer 4 parts Hardener 1 part Reducer 5% Stir thoroughly until achieving homogenous mixture.		Curing time for thick coat 150÷180 µm (5.9–7.1 mils) Approx 1 hour at 20°C (68°F) Approx 10 min at 60°C (140°F) Curing time for thick coat 180÷250 µm (7.1–9.8 mils) Approx 2 hours at 20°C (68°F). Temperature below 20°C (68°F) significantly increases the hardening time.
	SPRAYING VISCOSITY		IR DRYING
	30÷50 seconds at 20°C (68°F)/DIN4.		10÷15 minutes of short waves for the thickness of 150÷180 µm (5.9–7.1 mils). Do not exceed 60°C (140°F). Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	POT LIFE		DRY SANDING
	Approx. 65 minutes at 20°C (68°F).		Machine sanding: P360÷P500. Hand sanding: P280÷P320.

	EVAPORATION TIME Between coats: 5÷10 minutes Before baking: approx. 10 minutes Evaporation time depends on the temperature and the number of layers.		WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.
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FURTHER WORK	
DTM SPEED 4:1 2K Urethane Primer can be directly over coated with:	
• 2-pack urethane topcoats. • 1-pack basecoats.	
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: <i>To maintain safety, always follow the instructions given in the MSDS for the products.</i>	
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:	
<i>1. After each use the container with product should be immediately closed!</i>	
<i>2. Protect the hardener from frost and dampness!</i>	
WARRANTY PERIOD	
DTM SPEED 4:1 2K Urethane Primer	– 12 months from the date of production
Hardener 1:4 for 2K Urethane Primer DTM SPEED	– 12 months from the date of production
Urethane Reducers INTER TROTON	– 24 months from the date of production

PRODUCT	ART. No.
DTM SPEED 4:1 2K Urethane Primer	(0.8l+0.2l): 14771 (3.75l): 14772
Hardener 1:4 for 2K Urethane Primer DTM SPEED	(0.94l): 14774
Urethane Reducers INTER TROTON	300009942; 300009943 (1l; 5l)

LIMITATION OF LIABILITY
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