

TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

DTM PRIMER SEALER 4:1 MULTIFUNCTIONAL 2K URETHANE PRIMER	
PRODUCTS	
DTM Primer Sealer 4:1 - Multifunctional Urethane Primer Hardener 1:4 for DTM Primer Sealer Urethane Reducers MASTER	
PRODUCT DESCRIPTION	
High-quality 2K multifunctional urethane primer with the addition of anti-corrosion agents, intended for car repairs. Thanks to the use of advanced technology and high-class ingredients, DTM Primer Sealer 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/body fillers 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. The undercoat is available in 3 colors: grey, 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. • 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 gray system.	
	
COLORS: grey, white, black	
GLOSS GRADE: matt	

VOLATILE ORGANIC COMPOUNDS	
VOC for mixture 4+1+20% = 539 [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	
The multifunctional primer DTM PRIMER SEALER 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	MIXING RATIO		NUMBER OF COATS & SPRAY GUN SETTINGS
	by volume	by weight	
	Primer	4 parts	100
	Hardener	1 part	17.4
	Reducer:		
	filling option	5÷10%	
	grounding option	15÷20%	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).
	wet-on-wet option	25÷30%	
Stir thoroughly until achieving homogenous mixture.			

	SPRAYING VISCOSITY		HARDENING TIME
	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 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.
	POT LIFE		Curing time at an object temperature of 60°C (140°F) - Grounding version (50–100µm/2.0–3.9mil): 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).
	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.		Temperature below 20°C (68°F) significantly increases the hardening time.
	DRY 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: P360÷P500. Hand sanding: P320÷P500. Wet-on-wet doesn't require sanding!		
	Machine sanding: P600÷P1000. Hand sanding: P800÷P1000. Wet-on-wet doesn't require sanding!		

COLORS			
COLOR	SHADE OF GREY	MIXING RATIO % BY WEIGHT	RECOMMENDED BASE COLOR
	RAL 9003	100 % white	orange, white, yellow
	RAL 7040	100% grey	red (shade of red)
	RAL 7045	13 : 87 (black : grey)	lightgrey, 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 RAL 7015 and 7045 colours, the black and grey 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 RAL 7015 and 7045 colours, the black and grey primer should be mixed in the following proportions by weight

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

PRODUCTS	ART. No.
DTM Primer Sealer 4:1 - Multifunctional Urethane Primer	(0.8l+0.2l): 13639, 13653, 13654 ; 15295, 15297, 15296; 15300,15302,15301 (3,6l): 13658, 13660, 13659
Hardener MEDIUM 1:4 for DTM Primer Sealer	(0,9l): 13661
Hardener FAST 1:4 for DTM Primer Sealer	(0,9l): 15299
Hardener SLOW 1:4 for DTM Primer Sealer	(0,9l): 15304
Urethane Reducers MASTER	Medium - 300010232; 300009053 (1l; 5l) Fast- 15305; 13414 (1l; 5l) Slow- 15306; 15307 (1l; 5l)

LIMITATION OF LIABILITY

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