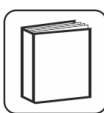
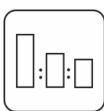


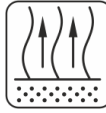
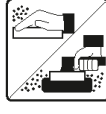
## TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
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| <b>DTM PRIMER SEALER 4:1</b><br>2K MULTIFUNCTIONAL URETHANE PRIMER VOC 2.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |
| <b>PRODUCTS</b><br>DTM Primer Sealer 4:1 – Multifunctional 2K Urethane Primer<br>Hardener 1:4 for DTM Primer Sealer<br>Urethane Reducers VOC ZERO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |
| <b>PRODUCT DESCRIPTION</b><br>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 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 colours: 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.<br>Benefits: <ul style="list-style-type: none"> <li>• Excellent anti-corrosion protection of steel.</li> <li>• Strong adhesion to various types of surfaces.</li> <li>• Very good insulating and filling properties.</li> <li>• Very short curing time.</li> <li>• Can be applied using the "wet on wet" technique.</li> </ul> |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |
| <b>COLORS:</b> grey, white, black<br><b>GLOSS GRADE:</b> matt                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |

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| <b>VOLATILE ORGANIC COMPOUNDS</b><br>VOC for the mixture = 247.2 g/l – 2.063 lb/gal. (<2.1 lb/gal)                                                                                                                                                                                                                                                                                                                                                                           |  |
| <b>SURFACE PREPARATION</b><br>The multifunctional primer can be applied over: <ul style="list-style-type: none"> <li>• Bare steel and aluminum after matting and degreasing.</li> <li>• Zinc coated, galvanized steel after matting and degreasing.</li> <li>• Sanded polyester laminates (GFK/GRP).</li> <li>• Wash primers.</li> <li>• Polyester primers.</li> <li>• Isolation primers.</li> <li>• Old finishes in good condition after matting and degreasing.</li> </ul> |  |
| Good surface preparation is necessary for achieving best results.<br><br>Following sandpaper gradations are recommended: <ul style="list-style-type: none"> <li>• sanding by hand (dry): P280÷P400; (wet) P400-P800.</li> <li>• sanding by machine (dry): P240÷P400.</li> </ul>                                                                                                                                                                                              |  |

| 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                                                                                                                                                                                                                                                                                                                                 | 20,3                                                                                |
|                                                                                    | 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                                                                                                                                                                                                                                                                                                   |                                                                                     |
|                                                                                    |                                                                                                                                            | <b>Sanding option:</b> 1÷2 coats <ul style="list-style-type: none"><li>filling version - about 80 µm (3.15 mil) per single dry coat.</li><li>grounding version - approx. 50 µm (1.97 mil) per single dry coat.</li></ul>                                                                                                               |                                                                                     |
|                                                                                    |                                                                                                                                            | <b>Spray gun parameters:</b><br><b>Compliant (RP) spray gun:</b> 1.6÷2.0 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar)<br><b>HVLP spray gun:</b> 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).                                                                                       |                                                                                     |
|                                                                                    |                                                                                                                                            | <b>Wet-on-wet option:</b> 1.5 coats. approx. 30 µm (1.18 mil) per single dry coat.<br><b>Spray gun parameters:</b><br><b>Compliant (RP) spray gun:</b> 1.2÷1.4 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar)<br><b>HVLP spray gun:</b> 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). |                                                                                     |

|                                                                                  |                                                                                                                                                                                                                                                                   |                                                                                   |                                                                                                                                                                                                                                                                                                                                                                              |
|----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <b>SPRAYING VISCOSITY</b><br><b>Filling option</b> (at 5÷10% reducer): 40÷30 sec at 20°C (68°F)/DIN4<br><b>Grounding option</b> (at 15÷20% reducer): 25÷20 sec at 20°C (68°F)/DIN4<br><b>Wet-on-wet option</b> (at 25÷30% reducer): 19÷17 sec at 20°C (68°F)/DIN4 |                                                                                   | <b>HARDENING TIME</b><br><br><b>Hardening time at 20°C (68°F):</b> <ul style="list-style-type: none"> <li>Grounding version (50 ÷ 100 µm): ready for sanding after 1h.</li> <li>Filling version (80 ÷ 160 µm): ready for sanding after 2h.</li> </ul>                                                                                                                        |
|  | <b>POT LIFE</b><br><b>Filling option:</b> approx. 45 minutes at 20°C (68°F)<br><b>Grounding option:</b> approx. 45 minutes at 20°C (68°F)<br><b>Wet-on-wet option:</b> approx. 1,5h at 20°C (68°F)                                                                |  |                                                                                                                                                                                                                                                                                                                                                                              |
|  | <b>EVAPORATION TIME</b><br>Between coats: 5÷10 minutes<br>Before applying solvent base: approx. 20 minutes<br>Before applying water base: approx. 30 minutes<br>Evaporating time depends on temperature and coat thickness.                                       |                                                                                   | Temperature below 20°C (68°F) significantly increases the hardening time.                                                                                                                                                                                                                                                                                                    |
|  | <b>DRY SANDING</b><br>Machine sanding: P360÷P500.<br>Hand sanding: P320÷P500.<br><b>Wet-on-wet doesn't require sanding!</b>                                                                                                                                       |                                                                                   | <b>IR DRYING</b><br><b>Grounding version</b> 50–100 µm (2.0–3.9 mil) dry film thickness: 6÷8 minutes under short waves.<br><b>Filling version</b> 80–160 µm (3.1–6.3 mil) dry film thickness: 8÷10 minutes under short waves.<br>Do not exceed 60°C (140°F)<br>Use as recommended by the equipment manufacturer.<br>Wait about 10 minutes before starting the heater drying. |
|  | <b>WET SANDING</b><br>Machine sanding: P600÷P1000.<br>Hand sanding: P800÷P1000.<br><b>Wet-on-wet doesn't require sanding!</b>                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                              |

## FURTHER WORK

2K urethane fillers can be directly over coated with:

- 2-pack urethane topcoats.
- 1-pack basecoats..

Also:

- 2K polyester body fillers / putties.
- 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:

- After each use the container with product should be immediately closed!
- Protect the hardener from frost and dampness!

## WARRANTY PERIOD

|                                                            |                                         |
|------------------------------------------------------------|-----------------------------------------|
| DTM Primer Sealer 4:1 - Multifunctional 2K 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                                          | – 24 months from the date of production |

| PRODUCTS                                                   | ART. No.                                                          |
|------------------------------------------------------------|-------------------------------------------------------------------|
| DTM Primer Sealer 4:1 - Multifunctional 2K Urethane Primer | (0,8l + 0,2l): 16607; 16701; 16700<br>(3,6l): 16702; 16704; 16703 |
| Hardener 1:4 for DTM Primer Sealer                         | (0,9l): 16705                                                     |
| Urethane Reducer MEDIUM VOC ZERO                           | 8562; 8561 (1l; 5l)                                               |
| Urethane Reducer FAST VOC ZERO                             | 7868; 8557 (1l; 5l)                                               |
| Urethane Reducer SLOW VOC ZERO                             | 2289; 9235 (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.

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 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.

TROTON Sp. z o.o.  
Ząbrowo, Poland.