

GENERAL INFORMATION

PF247B Optimum Surfacers DTM Black is a polyurethane high-solid primer designed to air dry at room temperature, offering excellent adhesion and corrosion resistance. This surfacer is suitable for a range of repair work on various automotive substrates. It can be applied directly to degreased and well-sanded steel and aluminium surfaces.

MIXING RATIO



5 : 1 Surfacers : H65 Optimum Hardener + 25% Uni Thinner

COMPONENTS



H65 Optimum Hardener
TA900 Uni Thinner Fast
TA910 Uni Thinner Medium
TA920 Uni Thinner Slow
TA930 Uni Thinner Very Slow
TA960 Uni Thinner Ultra Slow

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4 - 1,6	1,8 - 2,2 / 26 - 32
HE	1,4 - 1,6	1,8 - 2,0 / 26 - 29

ADDITIVES



APPLICATION



2 - 3 coats, 80 - 150 µm

No flash off or 1 minute flash off between coats.

POT LIFE AT 20°C (68°F)



15 - 20 minutes

FLASH-OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	LOW BAKE 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	0 - 1 minute	0 - 1 minute	0 - 1 minute
Flash off before bake	-	5 minutes	5 minutes
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	30 - 60 minutes	25 - 30 minutes	10 minutes
Dry to polish	-	-	-

Drying times based on 2 coat application, times may increase depending on layer thickness and conditions. Please refer to the next page for additional drying times and thinner selection guidance.

DRY TIMES AND DISTANCE IR



	Maximum 3 coats	Half-bake	Full-bake
Flash Time	5 minutes	3 minutes	4 minutes

Follow the IR equipment recommendations for optimal distance between object and IR-lamps.

SUBSTRATES



PF247B Optimum Surfacers DTM Black could be applied directly on degreased and well sanded/scuffed metal/steel, aluminium, old OEM system and body filler. Degreased e-coat - light-sanding is recommended.

SURFACE PREPARATION



Preclean the surface with TD20 Silicone Remover. Wipe on and wipe dry. Sand surface with P180 - P240 grit abrasive. Remove all sanding debris with compressed air. Sanding vacuum and clean with TD20 Silicone Remover. Wipe on and wipe dry. Final sanding with P400 and P500 before application of Basecoat.

Mask entire vehicle to eliminate unwanted overspray.

SUBSTRATES PLASTIC



Substrate	PF247B
ABS	Spray the PA65 1K Plastic Primer
PP/EPDM	Spray the PA65 1K Plastic Primer

NEXT LAYER



W00 - W999 Octobase Eco Plus System
F00 - F98 Octocoat HS420 System
B00 - B999 Octobase System
A00 - A98 Octocryl System

PHYSICAL DATA

EU REGULATIONS PF247B Optimum Surfacers DTM Black		
VOC Code		2004/42/IIIB(c)(540)510
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIIB/c. Primer - Surfacers/filler and general (metal) primer. EU limit values: 540 g/l (2007). This product contains a maximum of 510 g/l VOC.
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS) (sec)	19 - 21 Dincup 4 / 20°C
	Density (kg/l)	1,43
	Flash Point Closed Cup	10°C / 50°F
	Volume % Solids	42
	Economy	7 m²
	Gloss	Egg Gloss
	Colour	Black

PROTECTION



Use suitable respiratory protection
(we recommend the use of a fresh air supply respirator).

For more detailed information please visit the following link for the Safety Data Sheet:

[SDS Octoral](#)

CLEANUP



Gun Cleaner

STORAGE / SHELF LIFE



The up-to-date shelf life overview can be found by clicking on the following link:

[Shelf life overview Octoral](#)

NOTES



All reported product properties on the TDS are determined at a temperature of 20°C / 68°F unless specified otherwise.



Additional drying information

REPAIR SIZE	AIR DRY	AIR DRY	AIR DRY	AIR DRY	AIR DRY	AIR DRY	LOW BAKE	FORCE DRY	IR DRY
Application temperature	< 20°C	20 - 23°C	23 - 26°C	27 - 29°C	30 - 34°C	> 35°C	40°C	60°C	60°C
Spot repair	TA900	TA900	TA900	TA910	TA920	TA920	TA920	TA930	TA930
1 panel	TA900	TA900	TA910	TA910	TA920	TA930	TA930	TA930	TA930
Multi panels	TA900	TA910	TA910	TA920	TA930	TA960	TA930	TA930	TA930