

## GENERAL INFORMATION

80-222 Low VOC DTM Primer/Surfacer/Sealer-White is a premium non-Iso 2-pack direct to metal primer with multiple mixing ratios for filling and sealing applications.

## MIXING RATIO



### High Build Primer:

4 : 1 : 1 Primer + DTM Hardener + Reducer

### Sealer:

4 : 1 : 2 Sealer + DTM Hardener + Reducer

Depending on whether you use this product as Primer or Sealer you select the applicable mixing ratio.

## COMPONENTS



80-220 DTM HB Hardener  
 1-141 Uni Thinner Fast  
 1-151 Uni Thinner Medium  
 1-161 Uni Thinner Slow  
 1-171 Uni Thinner Very Slow  
 1-1000 Thinner Zero VOC

Check local regulations for VOC compliance guidelines.

## GUN SETUP



PRIMER	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,5-1,9	1,4-2/20-30
Conventional Gun	1,5-1,9	1,4-2/20-30
SEALER	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,5	1,7-2,4/25-35
Conventional Gun	1,3-1,5	1,7-2,4/25-35

Air pressure mentioned in table is base on inlet air.

## APPLICATION



### High Build Primer:

1 - 3 coat 2,2-3,2 mil

### Sealer:

1 coat 0,8-1,3 mil

## ADDITIVES



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## SURFACE PREPARATION



Good preparation is vital in order to obtain the best possible result. Remove all sanding debris with compressed air, sanding vacuum and clean with Silicon Remover wipe on and wipe dry. Final sanding before application depending on substrate.



## FLASH OFF AND DRY TIMES



Flash/Bake/Air Dry Times	Primer Surfacer	Primer Sealer
Flash Time	10 - 15 minutes	10 - 20 minutes
To Sand Air Dry	60 - 90 minutes	Nib Sand 10 minutes
To Sand Bake 155°F (68°C)	10 - 15 minutes	-
To Topcoat Air Dry	30 minutes	10 - 20 minutes
To Topcoat Without Sanding	24 hours maximum	4 hours maximum



## NEXT LAYER



MM 900 - 9999 WaterBase 900+ Series.

## 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:

<https://sds.de-beer.com>

## SUBSTRATES



Properly cleaned and sanded Aluminum, Steel, Galvanized Steel or sand blasted Steel. Properly cleaned and sanded fiberglass, SMC, E-Coat, OEM finish. Properly cleaned and sanded OEM E-Coat.

No etching required.

## CLEANUP



Cleaning the Equipment / Per local regulations.

## POTLIFE



### High Build Primer:

20 - 30 minutes

### Sealer:

45 - 60 minutes

## PHYSICAL DATA

RTS REGULATORY DATA:		
FOR Canada(2.1 LBS./GAL Compliance)		
4 : 1 : 1		
1-1000 Thinner Zero VOC		
	lb./gal	g/L
Actual VOC	1.25 Max	150 Max
Regulatory VOC (less water and exempt solvents)	2.1 Max	250 Max
Density	10-12	1200-1400
	WT%	VOL%
Total Solids Content	45-55	30-40
Total Volatile Content	45-55	60-70
Water	0	0
Exempt Compound Content	30-40	45-45
Coating Category	Primer Surfacer	

RTS REGULATORY DATA:		
FOR Canada(2.1 LBS./GAL Compliance)		
4 : 1 : 2		
1-1000 Thinner Zero VOC		
	lb./gal	g/L
Actual VOC	1.0 Max	125 Max
Regulatory VOC (less water and exempt solvents)	2.1 Max	250 Max
Density	10-12	1200-1440
	WT%	VOL%
Total Solids Content	45-55	30-40
Total Volatile Content	45-55	60-70
Water	0	0
Exempt Compound Content	35-45	50-55
Coating Category	Primer Sealer	

## STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

## NOTES



**INFORMATION:** If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Refer to the Color Focus Formula Retrieval software for compliant color formula and thinner selection instruction. Confirm compliance with state and local air quality rules before use.