

GENERAL INFORMATION

80-223 Low VOC DTM Primer/Surfacer/Sealer-Black 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.

POTLIFE



High Build Primer:

20 - 30 minutes

Sealer:

45 - 60 minutes

CLEANUP



Cleaning the Equipment / Per local regulations.

PHYSICAL DATA

| RTS REGULATORY DATA: | | 4 : 1 : 2 |
|---|---------------|-------------------------|
| FOR Canada (2.1 LBS./GAL Compliance) | | 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 | |

| RTS REGULATORY DATA: | | 4 : 1 : 1 |
|---|-----------------|-------------------------|
| FOR Canada (2.1 LBS./GAL Compliance) | | 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 | 50-60 | 35-45 |
| Total Volatile Content | 40-50 | 55-65 |
| Water | 0 | 0 |
| Exempt Compound Content | 30-40 | 45-45 |
| Coating Category | Primer Surfacer | |

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 Volatile Organic Compound (VOC) Standards in low-VOC jurisdictions, for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use.