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

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.

ADDITIVES
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APPLICATION
High Build Primer:
1 - 3 coat 2,2-3,2 mil

Sealer:
1 coat 0,8-1,3 mil

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 1-951 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	Not Recommended	4 hours maximum

NEXT LAYER
MM 900 - 9999 WaterBase 900⁺ Series
MM 500 - 5999 BeroBase 500 Series
MM 2000 - 2099 BeroMix 2000 Series

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.

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

POTLIFE
High Build Primer:
20 - 30 minutes

Sealer:
45 - 60 minutes

CLEANUP
Cleaning the Equipment / Per local regulations.

Revision Date: November 2021

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PHYSICAL DATA

RTS REGULATORY DATA: FOR USA (3.5/2.1 LBS./ GAL Compliance)	4 : 1 : 1 Uni Thinner Series		4 : 1 : 1 1-1000 Thinner Zero VOC	
	lb./gal	g/L	g/L	lb./gal
Actual VOC	2.6 Max	315 Max	1.25 Max	150 Max
Regulatory VOC (less water and exempt solvents)	3.5 Max	420 Max	2.1 Max	250 Max
Density	10-12	1200-1400	10-12	1200-1400
	WT%	VOL%	WT%	VOL%
Total Solids Content	50-60	35-45		35-45
Total Volatile Content	40-50	55-65	40-50	55-65
Water	0	0	0	0
Exempt Compound Content	20-30	25-35	30-40	45-45
Coating Category	Primer Surfacer			

RTS REGULATORY DATA: FOR USA/Canada(4.6/2.1 LBS./GAL Compliance)	4 : 1 : 2 Uni Thinner Series		4 : 1 : 2 1-1000 Thinner Zero VOC	
	lb./gal	g/L	g/L	lb./gal
Actual VOC	3.45 Max	415 Max	1.0 Max	125 Max
Regulatory VOC (less water and exempt solvents)	4.6 Max	550 Max	2.1 Max	250 Max
Density	10-12	1200-1440	10-12	1200-1440
	WT%	VOL%	WT%	VOL%
Total Solids Content	45-55	30-40	45-55	30-40
Total Volatile Content	45-55	60-70	45-55	60-70
Water	0	0	0	0
Exempt Compound Content	20-25	25-30	35-45	50-55
Coating Category	Primer Sealer			

STORAGESHELFLIFE

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.

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