



PRODUCT

DTM605 (Gray) | DTM602 (Catalyst) 2.1 VOC DTM PRIMER SURFACER

Product Features:

- Compatible with a wide range of topcoats including waterborne basecoats
- Easy sanding
- High build
- Direct-to-metal application
- 2.1 VOC Compliant

Physical Properties:

Pot Life	2 hours @ 70°F
Flash Point:	60°F
Dry Film Build:	2 to 3 mils
Sprayable Viscosity (RTS):	24-25 " #2 Zahn Cup
Weight Solids (RTS):	59.96%
VOC (RTS):	< 2.1 (lb./gal)
Theoretical Coverage:	739.2 sq. ft. @ 1 mil
EPA VOC:	3.5 pounds per gallon

Substrates:

- Steel
- Aluminum
- Fiberglass
- Body Filler
- Some plastics
- OEM Finishes

Mix Ratio:

4 : 1

4 Parts:	2.1 VOC DTM Primer
1 Part:	Catalyst

Spray Gun Setup:

Type:	Gravity or Siphon Feed HVLP
Tip Size:	1.6 to 1.8 mm
Pressure:	7-10 PSI

Dry Times (AIR):

Flash:	10 to 15 minutes
Sand & Topcoat:	Allow primer to dry 2-3 hours before sanding and top-coating.
Note:	All tests are performed at 70°F, higher temperatures will provide faster drying times.

Dry Times (FORCE):

Flash:	5 to 10 minutes
Bake:	140°F for 25-35 minutes
Sand & Topcoat:	Allow substrate to cool to room temperature before sanding and top-coating.

Surface Preparation:

Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean dry cloth, then clean with a pre-cleaning product, using generous amounts and changing rags frequently prior to painting. Sand area as necessary to remove any rust or corrosion, and then repair all body damage. Dry sand old finishes by hand or machine with P320 to P400 grit paper or wet sand using P400 grit paper. Re-wipe vehicle with pre-clean product.



Application: Apply 2 to 3 medium wet coats. If spot priming, for best results apply first coat of 2.1 VOC DTM starting with the outer layer working yourself towards the center of the repair. Block sand primed bodywork with P400 grit or finer wet or dry sandpaper.

Tips of the trade: This primer does not need any reduction. At 85°F the primer takes 20 min to flash off, cooler temperatures will cause this time to increase. If spraying over ALUMINUM, sand with 80 grit DA paper and clean thoroughly with a rag soaked in pre-clean product until no black residue transfers to the rag. DO NOT use over galvanized steel.

Spray Gun Adjustment: Adjust the material flow according to product viscosity. Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut. Proper spray gun adjustment will determine the final finish, improper adjustment may cause orange peel, runs, poor drying and poor adhesion just to name a few defects.

Cold Shop Conditions: For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure

Clean Up: Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

**Application:
Product Safety Info:**

Before using any Custom Shop product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.