



PRODUCT
DTM-HB624 (Gray)
 DTM-602(Catalyst)

Product Features:

- Fast dry, improves shop productivity
- Excellent color hold-out, improves color match
- Outstanding fill and build
- Easysanding
- No shrinkage
- DTM Excellent adhesion
- Easy tinting with primer tints or basecoat toner

Physical Properties:

Pot Life: 1-1.5 hours @ 75°F
 Flash Point: < 0°F TCC
 Dry Film Build: 2.5-4 mils
 Sprayable Viscosity (RTS): 21 " #2 Zahn Cup

Weight Solids (RTS): **72%**
 VOC (RTS): < 2.0 (lb./gal)
 Theoretical Coverage: 1100 sq. ft. @ 1 mil
 EPA VOC: 2.1 pounds per gallon

Substrates:

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

Mix Ratio:

4 : 1
4 Parts: 2.1 VOC DTM HB Primer
1 Part: DTM602 Catalyst

Dry Times (AIR):

Flash: 10 to 15 minutes
 Sand & Topcoat: Allow primer to dry 1-2 hours before sanding and top-coating.
 Note: All tests are performed at 75°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 with a pre-clean product

Spray Gun Setup:

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

2.1 DTM-HB624 Primer

Application:

1. Surface Prep: Wash with soap and water to remove contaminants and let dry. Wipe area with Wax and Grease Remover.
2. Sand with 150-220 grit abrasive and re-clean with Wax and Grease Remover.
3. Wipe area with a quality Wax and Grease Remover.
4. Restoration Projects- It is often recommended to use epoxy primers over large areas of sandblasted metal. DTM High Build is great to use over epoxy primers in those applications.
5. Mix 4 parts High Build DTM Primer with 1 part Activator DTM602. May be reduced using 1 part of compliant reducer. Do not shake longer than 1 minute.
6. Apply 2-3 wet coats using 50-60 psi at the gun. when using HLVP use 6-10 psi at the gun. Allow 10 - 15 minutes flash time between coats.
7. Allow to dry 1-2 hours before sanding. Film thickness, flash times and temperatures will affect sanding times. May be wet or dry sanded.
8. May be tinted up to 10% with primer tint or basecoat color.

FOR USE AS A SEALER- May be used as a sealer by reducing the pre activated primer by 10%-25% with compliant reducer or acetone. May be used to prime most properly prepared plastics. Should not be used with polyethylene or polypropylene plastics. Use a good quality lacquer thinner to thoroughly clean all equipment. Do not leave catalyzed primer in gun longer than 1 hour.

Tips of the trade:

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.

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.

