

# DTM Epoxy Primer

## Technical Data Sheet #40



### Components

- 40 1:1 DTM Light Gray Epoxy Primer / Sealer
- 401 1:1 DTM Light Gray Epoxy Activator
- VOC Compliant Reducer

### Mix by Volume

#### (As a Medium Build Primer)

- 1 Part 40 DTM Light Gray Epoxy Primer / Sealer
- 1 Part 401 DTM Light Gray Epoxy Activator

#### (As a Sealer)

- 1 Part 40 DTM Light Gray Epoxy Primer / Sealer
- 1 Part 401 DTM Epoxy Primer Activator
- ¼ Part VOC Compliant Reducers

### Pot Life

- 16 hours @ 75°F
- Clean equipment immediately after use

### Equipment Setup

| Gun Type        | Fluid Tip | Air Pressure             |
|-----------------|-----------|--------------------------|
| HVLP            | 1.4–1.6mm | 8–10 PSI at cap          |
| High Efficiency | 1.4–1.6mm | 27–32 PSI Inlet Pressure |

**Note:** These are starting points for spray gun recommendations. Refer to spray gun manufacturers recommendations for proper setup and operation. Additional adjustments may be necessary

### Application

#### (As a Primer)

- Apply in single wet coats, allowing 15 minutes flash between coats.
- Apply 1–2 coats, depending on desired film build keeping within the sanded repair area
- A light coat of body filler may be applied over 1 coat of Epoxy Primer after 2 hours at 75°F. If 2 coats of epoxy primer are applied, wait overnight before applying filler.

#### (As a Sealer)

- Apply 1 single wet coat with reduction to create a uniform base.
- Allow to flash for 45–60 minutes at 75°F before applying topcoats.
- Scuff sand with P400 grit or finer prior to applying surfacer, sealer or topcoats if primer has been allowed to dry for more than 24 hours.

### Time to Sand (Primer Option)

**Note:** Epoxy primers normally do not sand well until completely dry.

- Air dry overnight at 75°F for best results.
- Final sand with P400–P600 grit sandpaper before topcoating.

#### (Sealer Option)

- Sealer option does not require sanding if topcoated within maximum recoat period.
- If needed, Air Dry: 45–60 minutes

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at 75°F before sanding to remove debris.

### Time to Topcoat (Primer Option)

- Allow a minimum of 1 hour per coat and a maximum of 24 hours at 75°F.
- Between 24–72 hours, primer must be sanded prior to topcoating
- After 72 hours, primer must be sanded and recoated with a single coat prior to topcoating.

### (Sealer Option)

- Minimum of 45 minutes dry time and a maximum of 6 hours at 75°F prior to topcoating.
- Between 6–24 hours, primer must be sanded prior to topcoating.
- After 24 hours, primer must be sanded and recoated with a single coat prior to topcoating.

### Performance Tips

- Shop and surface temperatures should be maintained above 75°F prior to work.
- Ensure proper metal conditioning and preparation procedures are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions for topcoats are followed.
- Ensure accurate measuring is followed during mixing.

### Clean-up

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

### Disposal

Dispose of all paint and paint related materials in accordance with state and local regulations.

### Safety & Health

Read and follow all technical product information, labels, and SDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

**Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Safety Data Sheets (SDS) supplied with the materials.**

**KEEP OUT OF REACH OF CHILDREN**