

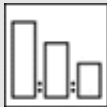


# Technical Data Sheet

## Primer Sealer

**Product: Automotive Art DTM Primer Sealer**  
**45-77 Black (2.1 VOC)**

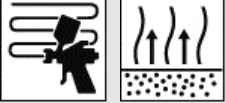


<b>Features:</b>	<ul style="list-style-type: none"> <li>High Solid content</li> <li>Direct to Metal, High quality resins</li> <li>Good top Finish</li> <li>Tintable with up to 10% with Motocryl</li> </ul>		
<b>Benefits:</b>	<ul style="list-style-type: none"> <li>Less spray coats needed</li> <li>Adheres to many types of metals including aluminum</li> <li>Ensures good topcoat finish a permanent shine</li> </ul>		
<b>Recommended Use:</b>	It is excellent for priming areas or complete vehicle, it can be applied to almost any metal or well cured old paint surfaces.		
<b>Materials for the job:</b>	<ul style="list-style-type: none"> <li>Automotive Art DTM LV Primer/Sealer 45-77</li> <li>Automotive Art Hardener (2.1 voc) 30-66, 30-76, 30-86</li> <li>Automotive Art Reducer (2.1 voc) 35-55, 35-60, 35-65</li> <li>Mixing stick, mixing tin and spray gun</li> </ul>	National Rule	30-62, 30-72, 30-82
<b>Physical properties:</b>	<b>Specific gravity (kg/l):</b> 1.67 <b>Flash point:</b> Closed cup: -20°C (-4°F) <b>Vol.% solids:</b> 75% <b>Coverage:</b> 8 m <sup>2</sup> /L/60 μm (2.4 mil) <b>Viscosity DINCP 4mm/20°C:</b> Airspray (sec) 20 - 22 <b>Gloss:</b> Matt <b>Color:</b> Black <b>V.O.C. (RTS):</b> 178 g/l (1.5 lbs/gal)		
<b>Pretreatment:</b>	Clean with Automotive Art Wax & Grease remover 20-95 Sand surface to promote adhesion and clean one more time with Wax & Grease remover		
<b>Cleaning the equipment:</b>	Lacquer Thinner 60-20		
<b>Shelf Life:</b>	Under normal storage conditions minimum two years (unopened tins).		
<b>Mixing ratio: For Application Hardener Reducer</b>	<b>High Build Primer 4:1</b>	<b>Primer Surfacer 4:1:1</b>	<b>Sealer 4:1:2</b>
	100% by vol. LV Primer 25% by vol. LV or NR Hardener	100% by vol. LV Primer 25% by vol. LV or NR Hardener 25% by vol. LV or NR Reducer	100% by vol. LV Primer 25% by vol. LV or NR Hardener 50% by vol. LV or NR Reducer
<b>Nozzle size:</b>	2.0 mm	1.7 mm	1.3 – 1.7





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<b>Spraying Pressure:</b>	HVLP: 2.0-3.0 bar (30-45 p.s.i.) See manufacturer info		High Pressure: 3-4 bar (45-60 p.s.i.)				
<b>Application:</b> 	Apply with spray gun using normal spraying motion. Apply one two three spray coats with a <i>flash off</i> time of 5-15 minutes between coats.						
<b>Drying time:</b> 	<b>Temperature</b>	<b>10°C (50°F)</b>	<b>15°C (60°F)</b>	<b>21°C (70°F)</b>	<b>26°C (80°F)</b>	<b>32°C (90°F)</b>	<b>38°C (100°F)</b>
	<b>Fast Hardener</b>						
	<b>Normal Hardener</b>						
	<b>Slow Hardener</b>						
<b>Guide Color:</b>	Refer to Guide Color Application.						
<b>Sanding:</b> 	P 600-800 Wet by hand			P 360-500 Dry by Orbital sander			
<b>Pot life at 20° C:</b>	30 minutes at 20°C						

