# **DP236 White Low VOC DTM Primer**



#### as a Direct-to-Metal Primer-Surfacer

**Products** DP236 White Low VOC DTM Primer

851 Prep and Wash

910 Universal Prep Cleaner AM900 Aero-Max Pre-Kleano

PA20NB Low VOC Productive Primer Activator

RMH94 Low VOC Fast Hardener RMH96 Low VOC Medium Hardener RMH98 Low VOC Slow Hardener

RMR15 Low VOC Reducer

**VR Series Reducers** 

4:1:10%

## Surface **Preparation**

Substrate	Cleaning	Sanding	Cleaning
Bare steel	AM900	P180 - P220	AM900
Aluminum	AM900	P180 - P220	AM900
Galvanized	AM900	Red Scuff Pad	AM900

#### Mixing Ratio

### **High Speed Process**

3:1:1

4 parts DP236 3 parts DP236 1 part RMH94, RMH96 or RMH98 1 part RMH94 10% VR Reducer or RMR15 1 part PA20NB

Reduction may go up to 1 part

### Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP236	27.7	55.2	82.8	110.4	138.3	166.0	193.6	221.2
RMH94	6.8	13.6	20.4	27.2	34.1	40.9	47.8	54.6
PA20NB	7.5	15.0	22.4	29.9	37.4	45.0	52.4	59.9
	42.0	83.8	125.6	167.5	209.8	251.9	293.8	335.7
	grams							

#### **Application**

2 to 3 medium wet coats

5 minutes flash between coats

#### Drying

**High Speed Process - PA20NB** 

20°C/68°F 90 minutes 20 to 30 minutes

50°C/120°F N/A 20 minutes

60°C/140°F 20 minutes N/A **Infra Red short wave** 5 to 7 minutes N/A

### Sanding/ Polishina

Wet Sand - P320 to P500 grit Dry Sand - P320 to P500 grit

Remove sanding residue with AM900 or 910.

Check your local VOC regulations to determine which R-M cleaners are compliant in you area.

#### Notes

The surface preparation is critical for the success of DP236.

# **DP236 White Low VOC DTM Primer**



as a Direct-to-Metal Primer-Surfacer Technical Data

#### **Characteristics**

DP236 is a fast curing, VOC compliant primer that offers excellent sanding and reasonably long potlife. The primer is exceptional when baked or cured by infrared lamps. Excellent sag resistance and leveling. Provides good topcoat holdout and invisible repairs. Good adhesion direct to substrates such as galvanized, aluminum, steel, old paint, plastic, fiberglass, SMC and body filler.

#### **Technical Data**

Guilligai Data	
Viscosity	14-16 sec. #4 Ford cup
Fluid Tip (HE Gravity)	1.3-1.5 mm
Fluid Tip (HVLP Gravity)	1.5-1.7 mm
Air Pressure (HVLP/HE)	8-10 psi at air cap
Number of Coats	2 to 3 medium wet coats
Thickness	3.0-4.0 mils (before sanding)
Pot Life	60 minutes @ 20°C/68°F  with PA20NB 20 minutes @ 20°C/68°F
Coverage	317 sq ft/gal @ 2.0 mils
VOC as Applied	< 250 gms/ltr (< 2.1 lbs/gal)
	1

## Things to DO:

- Do use the appropriate NIOSH/MSHA respirator.
   Consult product label for details.
- Do measure the amount of hardener and reducer
   DO NOT ESTIMATE.
- Do allow DP236 to cure 1.5 hours before sanding.
- Do use only RMH94, RMH96 or RMH98
   Hardeners and VR Reducer or RMR15 in DP236.
- Do use DF21 Flex Agent when painting flexible parts. See Flexible Parts section of manual.

## Things NOT to DO:

- Do not use fisheye eliminator.
- Do not use if shop temperature is below 15°C/60°F.
- Do not use HR5 Jet5 or Jet95 in DP236.
- Do not use with etch primers.

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Material's Salety Data Sheet (MSDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the bypical Voldiello Grapic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.