

# DP237 Dark Gray Low VOC DTM Primer

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



**Products** DP237 Dark Gray 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

| 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**

**4:1:10%**

4 parts DP237  
 1 part RMH94, RMH96 or RMH98  
 10% VR Reducer or RMR15  
 Reduction may go up to 1 part

**High Speed Process**

**3:1:1**

3 parts DP237  
 1 part RMH94  
 1 part PA20NB

**Mixing of small amounts for high speed process**

|        | 1 oz          | 2 oz          | 3 oz           | 4 oz           | 5 oz           | 6 oz           | 7 oz           | 8 oz           |
|--------|---------------|---------------|----------------|----------------|----------------|----------------|----------------|----------------|
| DP237  | 26.7          | 53.2          | 79.9           | 106.5          | 133.4          | 160.1          | 186.8          | 213.4          |
| 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           |
|        | 41.0<br>grams | 81.8<br>grams | 122.7<br>grams | 163.6<br>grams | 204.9<br>grams | 246.0<br>grams | 287.0<br>grams | 327.9<br>grams |

**Application**

2 to 3 medium wet coats  
 5 minutes flash between coats

**Drying**

**20°C/68°F** 90 minutes  
**50°C/120°F** N/A  
**60°C/140°F** 20 minutes  
**Infra Red short wave** 5 to 7 minutes

**High Speed Process - PA20NB**

20 to 30 minutes  
 20 minutes  
 N/A  
 N/A

**Sanding/  
Polishing**

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 DP237.



# DP237 Dark Gray Low VOC DTM Primer

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



### Characteristics

DP237 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

|                                 |                                                                 |
|---------------------------------|-----------------------------------------------------------------|
| <b>Viscosity</b>                | 13-15 sec. #4 Ford cup                                          |
| <b>Fluid Tip (HE Gravity)</b>   | 1.3-1.5 mm                                                      |
| <b>Fluid Tip (HVLP Gravity)</b> | 1.5-1.7 mm                                                      |
| <b>Air Pressure (HVLP/HE)</b>   | 8-10 psi at air cap                                             |
| <b>Number of Coats</b>          | 2 to 3 medium wet coats                                         |
| <b>Thickness</b>                | 3.0-4.0 mils (before sanding)                                   |
| <b>Pot Life</b>                 | 60 minutes @ 20°C/68°F<br>with PA20NB<br>20 minutes @ 20°C/68°F |
| <b>Coverage</b>                 | 317 sq ft/gal @ 2.0 mils                                        |
| <b>VOC as Applied</b>           | < 250 gms/ltr (< 2.1 lbs/gal)                                   |

### 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 DP237 to cure 1.5 hours before sanding.
- Do use only RMH94, RMH96 or RMH98 Hardeners and VR Reducer or RMR15 in DP237.
- 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 DP237.
- Do not use with etch primers.