



WORLD CLASS™ DTM PRIMER

TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

World Class™ DTM Primer is a direct to metal (DTM) Non Isocyanate Primer Surfacer. World Class DTM Primer is lead and chromate free and provides superior bare metal adhesion and corrosion protection without the need of an etch primer.

FEATURES

- 2.1 Mixed VOC
- Outstanding adhesion on metal, fiberglass, aluminum
- Excellent corrosion control
- Builds quickly, sands easily
- Excellent color holdout
- Rollable or sprayable
- Can be mixed as a filler, surfacer or sealer
- Isocyanate, chromate and lead free

SUITABLE SUBSTRATES

- Bare metal and aluminum
- Sanded OEM finish
- Polyester body filler and glaze
- SMC
- Fiberglass
- Gelcoat

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
50121	World Class DTM Primer	Neutral Gray	Gallon
50124	World Class DTM Primer	Neutral Gray	Quart
50134	World Class DTM Primer Activator	Clear-Amber	Quart
50136	World Class DTM Primer Activator	Clear-Amber	1/2 Pint

RTS weight solids:	67.0%
RTS volume solids:	45.0%
RTS VOC:	Max 2.10 lb/gal (252g/L)
Pot life @ 70°F (21°C) and 50% RH:	2 Hours
Coverage at 2 mils:	360 sq.ft./gal
Air dry time (to sand):	1 – 2 hours



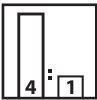
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HANDLING AND APPLICATION



PREPARATION:

Sand all surfaces to be primed with P180 – P320 grit. After sanding, blow off with clean, dry, compressed air. Next, clean surface to be primed with SEM Solve or **XXX Universal Surface Cleaner**.



MIXING:

Shake or stir thoroughly. Mix by volume: 4 to 1 – primer filler, 4 to 1 to 1 – primer surfacer, 4 to 1 to 2 – primer sealer

Primer Purpose/Type	World Class DTM Primer	DTM Primer Activator	Urethane Reducer	Tip Recommendation
Filler	4 Parts	1 Part	–	1.6 - 1.8
Surfacer	4 Parts	1 Part	1 Part	1.4 - 1.8
Sealer	4 Parts	1 Part	2 Parts	1.3 - 1.4

*Reduction will result in a smoother surface when rolling product. If reducing, use a high quality urethane reducer.

*Exempt solvent must be used in VOC restricted areas.

APPLICATION:



ROLLING

Use a premium high density foam roller or equivalent. Using a nap roller will result in an undesirable finish.

1. Roll one medium-wet coat. Allow to flash completely.
2. Apply 1 – 3 coats depending on desired film build.
3. Topcoat without sanding between 1 and 16 hours. If after 16 hours, sand per top coat instructions.
4. For sanding of primer, allow to dry 1 – 2 hours.



SPRAYING

Set air pressure to:	8-10 psi at the cap for HVLP equipment
	35-45 psi for non-HVLP

Note: Use a gun equipped with a 1.3 – 1.9 fluid nozzle, depending on reduction. See chart.

1. Spray one medium-wet coat keeping the gun 5 – 7" from the substrate. Allow to flash dry, approximately 10 – 15 minutes.
2. Spray subsequent coats allowing full flash.
3. Allow to dry for 1 – 2 hours prior to sanding.
4. Topcoat without sanding between 1 and 16 hours.



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CLEANUP:

Use XXX Gun Cleaner or appropriate cleaning materials compliant with VOC regulations in your area.



STORAGE:

World Class DTM Primer should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **World Class DTM Primer** is 5 years and **DTM Primer Activator** is 3 years when stored under normal conditions.

Note: Activator is amber in color and will darken over time; this does not affect product performance.

RELATED PRODUCTS:

Part:	Product Name:	Size:
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
77763	XXX Universal Gun Cleaner	20 oz. Aerosol
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart

Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.



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