



PRECISION COATINGS, INC.

P R O D U C T D A T A

DTM 13000 Series High Build Primer

DESCRIPTION:

- Multi-purpose epoxy modified primer
- Interior and Exterior surfaces
- Spray, brush or roll application
- High solids, High film build
- Exceptional adhesion to a wide variety of substrates
- No critical recoat time
- Low VOC – 250 grams per liter
- Superior protective properties
- All colors are lead and chromate free

TECHNICAL DATA:

AVAILABLE COLORS	White (# 13600), Gray (# 13500), Black (# 13200)
% SOLIDS by volume	60% as packaged, 54% as applied
SPRAYABLE VOC as applied	250 g/l (less water & exempt compounds)
COMPONENTS	DTM 13000 Series High Build Primer (resin) 3 parts 13510 High Build Primer Converter (cure) 1 part
POT LIFE	3 hours @ 70° F, 21° C
SHELF LIFE	one year (unopened)
REDUCERS	optional: use PCI's 16050 VOC Exempt Reducer
FLASH POINT	65° F, 18° C
MIX RATIO	3:1 (3 parts primer : 1 part converter)
RECOMMENDED DRY FILM THICKNESS	2.0 mils to 6.0 mils
COVERAGE	433 – 144 sqft at recommended DFT (no loss)

SURFACE PREPARATION:

DTM 13000 Series Primer may be applied over properly prepared substrates including steel, aluminum, galvanizing, coated surfaces, concrete, masonry block, and wood. Recommended preparation is as follows:

Steel – Clean the surface of all foreign material SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7. PCI's 02150 Metal Conditioner may be used to clean and treat steel substrates to eliminated oil, soap film, grease, and flash rusting.

Aluminum & Galvanizing – Clean the surface of all foreign material SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7. PCI's 02150 Metal Conditioner may be used to clean and treat aluminum and galvanizing to eliminate oil and soap film.

Concrete & Masonry – Surface must be cured, clean, dry, free of contamination and disintegrated or chalky materials. SSPC-SP13 may be used for surface preparation of concrete and masonry block.

Coated surfaces – Physically abrade existing coated surfaces. PCI's Paint Prep may also be used to treat existing finishes, including polyurethane finishes. Paint prep eliminates the need for abrasion. The existing finish must be tightly adhered to the substrate.

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INSTRUCTIONS – MIX RATIO:

Stir or shake thoroughly to ensure uniform mixture. Mix 3 parts DTM 13000 Series High Build Primer with 1 part 13510 DTM High Build Primer Converter.

Reduction is not necessary. However, activated primer may be reduced up to 10% by volume using PCI's 16050 VOC Exempt Reducer.

APPLICATION FOR “SOLID COLORS” & “METALLIC COLORS”: Apply using 40-55 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max. for HVLP spray guns. Apply 1-3 medium wet coats until desired coverage and flow is reached. Allow a 5 to 10 minute flash time between coats. Recommended film thickness is 2.0 to 6.0 mils DFT. May be brushed or rolled for field service applications. Use a natural bristle brush or ¼ inch to ¾ inch nap, phenolic core roller.

SPRAY GUN SET-UP & PRESSURE:

<u>Type</u>	<u>Fluid Tip</u>	<u>Spraying Pressure</u>
Siphon Feed	1.6mm – 1.8mm	40-65-PSI
Gravity Feed	1.6mm – 1.8mm	40-65 PSI
HVLP Siphon	1.6mm – 1.8mm	max. 10 PSI @ the air cap
HVLP Gravity	1.6mm – 1.8mm	max. 10 PSI @ the air cap
Airless Spray	.015” - .025”	2500 PSI 100 mesh filter
Brush – natural bristle		
Roller – ¼ to ¾ inch nap, phenolic core		

DRY TIMES:

Dry times @ 70°F (21°C) and 50% RH

Dust Free	5 minutes
Tack Free	1 hour
Dry Time	24 hours
Recoat	May be recoated after 1 hour. Sanding or light abrasion may be necessary after 72 hours.

CLEAN UP:

Clean all spray equipment immediately after use. PCI's 17000 Gun Cleaner is a VOC exempt cleaner and is recommended for cleaning application equipment used to apply the DTM 13000 Series High Build Primer system.

Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Precision Coatings, Inc. experience and research and is believed to be reliable. As PCI has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.

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PERFORMANCE DATA

DTM 13000 Series High Build Primer

TEST METHOD	SYSTEM (7 day, ambient temp. cure)	RESULTS
ASTM D-3359 Adhesion	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC3/PC-03 Topcoat	100% retention (no tape off)
ASTM D-4587 QUV Resistance Accelerated Weathering	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC3/PC-03 Topcoat	Gloss - 98% retention after 2012 hours delta E color change - 0.33 after 2012 hours No blistering, rusting, checking or cracking
ASTM B-117 Salt Fog	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC3/PC-03 Topcoat	No face corrosion nor blistering after 1000 hours
ASTM D-2287 Humidity Resistance	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC3/PC-03 Topcoat	No blistering, cracking, softening or delamination after 1000 hours
ASTM D-1308 Chemical Resistance 24 hour spot test	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC3/PC-03 Topcoat	87 octane unleaded gasoline - rating 5 no effect 10% Sulfuric Acid - rating 5 no effect
ASTM D-5402 Chemical Resistance solvent rubs	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC3/PC-03 Topcoat	Xylene - 200 double rubs no effect Methyl ethyl ketone (MEK)-200 double rubs no effect 87 octane unleaded gasoline - 200 double rubs no effect.
ASTM D-522 Flexibility	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC3/PC-03 Topcoat	180 degree bend, 1/4" mandrel - pass

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TEST METHOD	SYSTEM (7 day, ambient temp. cure)	RESULTS
ASTM D-3359 Adhesion	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.4 mils DFT PC4/PC-04 Topcoat	100% retention (no tape off)
ASTM D-4587 QUV Resistance Accelerated Weathering	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.4 mils DFT PC4/PC-04 Topcoat	Gloss - 96% retention after 2012 hours delta E color change - 0.75 after 2012 hours No blistering, rusting, checking or cracking
ASTM B-117 Salt Fog	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.4 mils DFT PC4/PC-04 Topcoat	No face corrosion nor blistering after 1000 hours
ASTM D-2287 Humidity Resistance	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.6 mils DFT PC4/PC-04 Topcoat	No blistering, cracking, softening or delamination after 1000 hours
ASTM D-1308 Chemical Resistance 24 hour spot test	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.4 mils DFT PC4/PC-04 Topcoat	87 octane unleaded gasoline - rating 5 no effect 10% Sulfuric Acid - rating 5 no effect
ASTM D-5402 Chemical Resistance solvent rubs	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.4 mils DFT PC4/PC-04 Topcoat	Xylene - 200 double rubs no effect Methyl ethyl ketone (MEK)-200 double rubs no effect 87 octane unleaded gasoline - 200 double rubs no effect.
ASTM D-522 Flexibility	Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.7 mils DFT DTM 13000 Primer 1.4 mils DFT PC4/PC-04 Topcoat	180 degree bend, 1/4" mandrel - pass

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