



PRECISION COATINGS, INC.

PRODUCT DATA

DTM 14000 Series Non-Sanding Primer

DESCRIPTION:

- Multi-purpose epoxy modified primer
- Interior and Exterior surfaces
- May be used as a Primer Sealer
- 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 (# 14600), Gray (# 14500), Black (# 14200) |
| % SOLIDS by volume | 40% as packaged, 38% as applied |
| SPRAYABLE VOC as applied | 250 g/l (less water & exempt compounds) |
| COMPONENTS | DTM 14000 Series Non-Sanding Primer (resin) 4 parts 14610 Non-Sanding 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 | 4:1 (4 parts primer : 1 part converter) |
| RECOMMENDED DRY FILM THICKNESS | 1.5 mils to 3.0 mils |
| COVERAGE | 406 – 203 sqft at recommended DFT (no loss) |

SURFACE PREPARATION:

DTM 14000 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. 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 4 parts DTM 14000 Series Non-Sanding Primer with 1 part 14610 DTM Non-Sanding 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 1.5 to 3.0 mils DFT. May be brushed or rolled for field service applications. Use a natural bristle brush or ¼ inch to ½ 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 ½ 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 14000 Series Non-Sanding Primer system.

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

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P E R F O R M A N C E D A T A

*DTM 14000 Series
Non-Sanding Primer*

| TEST METHOD | SYSTEM (7 day, ambient temp. cure) | RESULTS |
|--|---|---|
| ASTM D-3359 Adhesion | Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.5 mils DFT DTM 14000 Primer 1.5 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 2.5 mils DFT DTM 14000 Primer 1.5 mils DFT PC3/PC-03 Topcoat | Gloss - 95% retention after 2012 hours delta E color change - 0.47 after 2012 hours No blistering, rusting, checking or cracking |
| ASTM B-117 Salt Fog | Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.5 mils DFT DTM 14000 Primer 1.5 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 2.5 mils DFT DTM 14000 Primer 1.5 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 2.5 mils DFT DTM 1400 Primer 1.5 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 2.5 mils DFT DTM 14000 Primer 1.5 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 2.5 mils DFT DTM 14000 Primer 1.5 mils DFT PC3/PC-03 Topcoat | 180 degree bend, 1/4" mandrel - pass |

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| ASTM D-3359 Adhesion | Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.5 mils DFT DTM 14000 Primer 1.5 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 2.5 mils DFT DTM 14000 Primer 1.5 mils DFT PC4/PC-04 Topcoat | Gloss - 92% retention after 2012 hours delta E color change - 0.62 after 2012 hours No blistering, rusting, checking or cracking |
| ASTM B-117 Salt Fog | Cold Rolled Steel Solvent wipe 02150 Metal Conditioner 2.5 mils DFT DTM 14000 Primer 1.5 mils DFT PC4/PC-04 Topcoat | No face corrosion nor blistering after 1000 hours |
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