



Technical Data Sheet

AUTOFIL DTM PRIMER

DESCRIPTION:

AutoKote Autofil DTM Primer is an isocyanate free, high build primer surfacer that offers exceptional corrosion protection when applied directly over properly prepared bare metal. Autofil DTM Primer also gives you superior adhesion to properly prepared OEM E-coat, OEM topcoats, body fillers, and any two component catalyzed substrate..

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Autofil DTM Primer	4501	Gallon
Autofil DTM Primer	4504	Quart
Autofil Primer Hardener	4604	Quart
Autofil Primer Hardener	4609	Half Pint

COMPATIBLE SUBSTRATES:

- Properly cleaned and sanded Steel, Sluminum, Galvanized, SMC, and Fiberglass.
- Sanded E-coat and two-component O.E.M. finishes
- Two-component catalyzed finishes
- Semi rigid and rigid body parts
- Polyester fillers and glazing putties

Note: Do not apply over thermoplastic lacquers or soft felixble parts.

SAFETY ASPECTS:



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

SURFACE PREPARATION:



1. Clean area to be primed thoroughly of all dirt, grease, wax, and oil using Autokote Pre-Kleen.
2. Sand area to be primed with #180 to #220 grit sandpaper.
3. Clean surface thoroughly using Autokote Final-Kleen.

MIXING RATIOS:



4 parts Autofil DTM Primer
1 part Autofil Primer Hardener

Note: May be reduced up to 20% with Autosolv Urethane Reducer.

Note: Do not use accelerators with this product.



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GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Gravity:	1.5 mm - 2.0 mm	35 - 45 psi @ gun
HVLP	1.5 mm - 2.0 mm	28 - 32 psi @ gun

DIRECTIONS:

1. Read all warnings and directions before using this product.
2. Catalyze Autofil DTM Primer 4:1 with Autofil DTM hardener. Autofil DTM Primer may be reduced up to 20% with Autosolv urethane reducer.
3. Apply 2 to 3 coats of Autofil DTM Primer allowing 10 to 15 minutes flash time between coats, depending on temperature. Longer flash times will ensure better color holdout.
4. Allow Autofil DTM Primer to properly cure before sanding and topcoating.

Note: Do not use Flex additives or accelerators.

FILM THICKNESS:

Approximately 1.5 -2.0 mils per single coat.

FLASH TIMES:

10 to 15 minutes.

PURGE TIME:

20 minutes.

DRYING TIMES:



METAL TEMP	DUST FREE	DRY TO SAND
70°F/21°C	N/A	1 hour per coat
140°F/60°C	N/A	35 minutes

Note: Dry to sand times will vary according to temperature and number of coats.

Note: For best appearance and holdout, allow to air dry overnight prior to sanding and topcoating.

SANDING:

When using as a primer surfacer:

Allow Autofil DTM Primer to cure thoroughly before sanding.

Sand primer surfacer with 180 to 220 grit sandpaper then finish sand according to next application:

320 to 400 grit for Sealer

320 to 400 grit for Single Stage Topcoat System

400 to 500 grit for Basecoat



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CLEANING EQUIPMENT: Clean equipment with AutoKote Lacquer Thinner.

TECHNICAL DATA:



Color		Medium Grey
Activator/Hardener		Autofil DTM Primer Hardener
Reducer		Urethane Reducer (Optional)
Mix Ratio		4:1 + <i>Optional 20% Reducer</i>
Pot Life		1 hours at 70°F (21°C)
Number of Coats		2 to 3 full wet coats
Flash Time		10 to 15 minutes
Dry Time	<i>Air Dry</i>	1hr @ 70°F/21°C per coat
	<i>Force Dry</i>	35 minutes @ 140°F/60°C
Gun Set-Up		Refer to Table on Page 2
Regulatory V.O.C.		1.94 lbs/gal (232 g/l)
Actual V.O.C.		1.12 lbs/gal (135 g/l)
% Solids by wt. RTS		55% @ 4:1 mix
Package Size		Gallon, Quart
Case Quantity		4 Gallons, 6 Quarts
Shelf Life		12 months unopened

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.

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