

Technical Data Sheet

DTM PRE-TREATMENT WIPE

Description: Chromium Free conversion coating packaged in Ready to Use / Pre-Saturated Wipes. **Pre-Treatment Wipes** produce a conversion coating forming chemical bonds with metal surfaces enhancing adhesion and corrosion resistance of applied primers, paints and paint systems.

Product & Additives:	PRODUCT	ITEM #	SIZE
	DTM Pre-Treatment Wipes	129005	Each

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.*



Suitable substrates: **DTM Pre-Treatment Wipes** can be applied over properly prepped aluminum alloys, both billet and cast.

Mixing Ratio: **DTM Pre-Treatment Wipes** are ready to use. They can be used until the solution has dried and does not wet the surface any longer. To prevent pre-mature drying out of the Pre-Treatment Wipe, store the wet Pre-Treatment Wipe in a plastic zip-lock bag until the next use.



Proper Preparation:

Step 1: Removal of the existing finish by media blasting or chemical stripping is the preferred method. Media should not exceed P220 grit in coarseness. P220-P320 is recommended. For finish sanding with a DA, P280-P320 grit dry is recommended. A maroon scuff pad can be used in hard to reach areas.

Step 2: After media stripping or mechanical sanding blow excessive dirt and dust from surface. Wash thoroughly with a mild detergent and medium bristle brush. Scrub areas until all foreign matter is removed, rinse with fresh clean water. Air or blow dry.

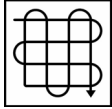
Step 3: Degrease surface using the wipe-on/wipe-off or spray on/ wipe-off method with one of the WG series wax and grease removers. Change rags frequently. **The surface must be dry and free from grease, oil and other foreign matter contaminants.**



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Application:



Hand apply the pre-treatment solution by way of a tight 50- 75% overlap motion. Apply a double wipe application, this could be a vertical and then immediately with a horizontal stroke motion.

Complete wetting (sheeting) of the metal surface is necessary to allow the solution to react with the base metal. If the liquid coating beads on the surface and does not completely wet the surface repeat the cleaning process and re-apply the pre-treatment solution again.

Flash Times:



This wet layer should be on the surface for minimum of 1 minute to form a conversion coating on the bare metal.

Bare substrate color change indicates proper application once drying periods have been completed.

Dry Times:



Allow complete drying of the pretreated surface at ambient air temperature. If desired the use of clean forced air (at low velocity) can be used to accelerate drying.

Recoating:



Recoat: with 2K Epoxy Primer Grey or Black.

Use a tack cloth before continuing with a paint coating.

Recoat time is maximum of 8 hours. Normal surface cleaning is required prior to priming. Do not expose object to outside weathering before recoating.

Product Storage:

Stock unopened or used products in approved closed containers with proper labeling. Store up to 12 months in moderate temperatures between 40°F --- 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).

Protect from freezing. If frozen, product will be irreversibly damaged and should not be used.

Wipes that are dried out completely cannot be rejuvenated and should not be re-moistened or used.

Theoretical Coverage:

9-12 Sq. ft.

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