

B32 DTM PRIMER R4

DEFINITION

2K high solids acrylic primer filler. Its modern formulation, anti-corrosive pigment content and chemical resistance ensure good isolating properties which allows it to be applied directly over a variety of substrates. At the same time emphasizing its versatility of application it has excellent leveling properties and is easy to sand. All these characteristics make **DTM PRIMER R4** a perfect base for excellent finishing results.

DTM PRIMER R4 is an environmentally friendly product due to its low VOC content.

PHYSICAL CHARACTERISTICS

Nature:	Acrylic 2K
Colour:	Dark grey
Specific weight:	1,5 kg/l at 20°C
VOC:	459 g/l DTM PRIMER R4 450 g/l Mixing application Sanding version 513 g/l Mixing application Non sanding version 2004/42/EC - IIB(c1)(540) 513g/l
Yield:	10 m²/l 150 microns

AUXILIARY PRODUCTS

Primer hardener standard
Wet on wet additive

SURFACE PREPARATION

SANDING PROCESS		Putty	Paint OEM
	P240	✓	✓
	Degreaser	✓	✓

NON SANDING PROCESS		Putty	Paint OEM
	P400	✓	✓
	Degreaser	✓	✓

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Sanding and non Sanding process		Steel	Aluminium	Electrolytic galvanized steel	Electro-zinc coated galvanized steel	Cataphoresis	Inox
	Degreaser	✓	✓	✓	✓	✓	✓

MIXING RATIO

		Sanding		Non Sanding	
		Vol	Weight	Vol	Weight
	DTM PRIMER R4	100	100	100	100
	Primer hardener standard	25	17	50	33
	Wet on wet additive	-	-	33	21
	F/4 at 20°C	42"		16"	
	Primer hardener standard	20'		20'	

APPLICATION METHOD

		Sanding	Non Sanding	
	HVLP	1,7 - 1,9 mm	1,2 - 1,4 mm	
		2 - 3 bar	2 - 2,5 bar	
	Distance	15 - 20 cm	15 - 20 cm	
	Coats	2	2	0,5 +1
	20°C	5'	3'	-
Dry film thickness		150 microns	30 microns	

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DRYING TIMES

		Sanding	Non Sanding
 20°C	Primer hardener standard	-	Min. 15' Max. 60'
 20°C	Primer hardener standard	5 h	-
 60°C	Primer hardener standard	30'	-
 OC - 80cm	FLASH OFF Primer hardener standard	5'	5'
	FULL BAKE Primer hardener standard	7'	7'

SANDING

		 ORBIT		
INITIAL		3	P360	P360
FINAL			P600	P600

EQUIPMENT CLEANING

Clean with a cleaning thinner before the pot life has expired.

SAFETY

Follow instructions of product label. For more information check the Safety Data Sheets. Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

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STORAGE

Store the product in a ventilated place far from direct exposure to sunlight. Keep between +5°C and +30°C.

GUARANTEE

One year in unopened original packaging.