

CIDTM94400/95500/96600 DTM PRIMER – TDS

DESCRIPTION

This two-component, urethane primer has excellent film-build and sands easily. Direct to Metal Primer is easy to spray and levels to an almost texture-free surface. It has excellent adhesion to bare steel and is available in White (94400), Gray (95500) and Black (96600).

MIX RATIO

Primer Surfacer (High Build)

- 4 Parts Direct to Metal Primer
- 1 Part CIDTMMA-95550 Medium Primer Activator
CIDTMSA-95580 Slow Primer Activator

Sealer

- 4 Parts Direct to Metal Primer
- 1 Part CIDTMMA-95550 Medium Primer Activator
CIDTMSA-95580 Slow Primer Activator
- 1 Part Zero VOC Reducer

NOTE: Pot Life is 45 minutes @ 72°F

SURFACE PREPARATION

- Wash area with soap and water, then thoroughly clean with wax and grease remover.
- Sand surface with 180 – 220 grit sandpaper.
- Re-clean area with wax and grease remover.

NOTE: Aluminum should be prepared by scuffing with a red scuff pad.

GUN SETUP

- | | | | |
|--------------|------|-------------|--------------------|
| • High Build | HVLP | 1.6mm-1.8mm | 8-10 psi @ gun tip |
| • Sealer | HVLP | 1.4mm-1.4mm | 8-10 psi @ gun tip |

APPLICATION

- HIGH BUILD – Apply 2-3 full wet coats with 10-15 minutes flash time between coats.
- SEALER – Apply 1 full wet coat and wait 30 to 45 minutes before applying topcoat. If allowed to sit more than 8 hours, then scuff before applying topcoat.

DRY TIMES

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|---------------------|----------------------|--|
| • Air dry | | |
| Flash between coats | 10-15 minutes | |
| Air dry | 1½ - 2 hours @ 75° F | |
| • Express dry | | |
| Cycle time | 30 minutes @ 140° F | |

SANDING

- Initially sand with 180-320 grit sandpaper.
- If applying a sealer over Direct to Metal Primer, sand primer with 320-400 grit sandpaper.
- If topcoating directly with basecoat, sand with 400-600 grit sandpaper.

HEALTH & SAFETY

Read all directions and warnings before use.

See Safety Data Sheet and labels for additional safety information and handling instructions.