

Technical Product Data



PRECISION COATINGS

PRECISION DTM 1400 Series Non-Sanding Modified Epoxy Primer

Description

Multi-purpose epoxy modified primer
Interior and exterior surfaces
May be used as a primer sealer

Adhesion to a wide variety of substrates
Fast topcoat time
Corrosion inhibitive pigments

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 1400 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
THEORETICAL COVERAGE	406 – 203 sq ft at recommended DFT (no loss)

SURFACE PREPARATION

DTM 1400 Primer may be applied over properly prepared substrates including carbon steel, aluminum, galvanized steel and previously coated surfaces. Good painting practices require that before applying coatings a test or mock-up be performed to ensure that adhesion, appearance and color meet the expectations of the owner. Coating performance is proportional to the degree of surface preparation performed. All surfaces must be clean, dry and free of oil, grease, dirt, salt deposits or other contamination. Recommended preparation is as follows:

Steel – Clean the surface of all foreign material SSPC-SP1 followed by SSPC-SP2, SP3, SP6, SP7, SP11, SP14 or SP15. Two or more coats of DTM 1400 may be required to cover profile. Precision's 02150 Metal Conditioner may be used to clean and treat steel substrates to eliminate oil, soap film, grease, and flash rusting.

Aluminum - Remove all contaminants per SSPC-SP1 and abrade using hand tool, power tool or SSPC-SP16 to obtain a profile equivalent to 220 grit sandpaper.

Galvanized Steel – Preparation shall meet ASTM D6386 –10. Remove all contaminants per SSPC-SP1, check for the presence of chromates or other passivation treatments per SSPC-SP16. If passivation treatment exists, brush-off blast cleaning per SSPC-SP16 is required. Complete removal of chromates or other passivating treatments must be confirmed by testing (SSPC-SP16 or ASTM B 201) prior to coating application.

Coated Surfaces – On previously coated surfaces, ensure that the existing coating is properly and fully bonded to the substrate. Physically abrade the existing coated surfaces thoroughly and completely with 180 to 240 grit or equivalent abrasive paper or scuff pad. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

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INSTRUCTIONS – MIX RATIO

Stir or shake thoroughly to ensure uniform mixture. Mix 4 parts DTM 1400 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 acetone or PCI's 16050 VOC Exempt Reducer.

APPLICATION

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.

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
Pressure Pot	1.1 mm- 1.3 mm	29 PSI - 58 PSI

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. Acetone may be used to clean spray equipment. PCI's 17000 Gun Cleaner is a VOC exempt cleaner and is recommended for cleaning application equipment used to apply the DTM 1400 Series Non-Sanding Primer system. Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Precision Coatings experience and research and is believed to be reliable. As Precision Coatings has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.

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PERFORMANCE DATA

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 1400 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 1400 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 1400 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 1400 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 1400 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 1400 Primer 1.5 mils DFT PC3/PC-03 Topcoat	180 degree bend, 1/4" mandrel - pass

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