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*From the Stars to your Cars*

Technical Data Sheet

## **2K DTM PRIMER**

**1350-100 (Black), 150 (Gray), 200 (White)**

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### **Product Description and Purpose**

2K DTM Primer is a high solids two component acrylic primer with outstanding filling properties. 2K DTM Primer is easy to sand and is recommended for repairs where fill is needed for straightening and block sanding. 2K DTM Primer, when topcoated directly, will provide for excellent gloss holdout while providing helpful range of white, gray, or black shade ground coats.

### **Quick Start Guide**

Product:	<b>2K DTM Primer</b>
Mix Ratio:	4 Parts 2K DTM Primer 1350-100, 150, or 200 1 Part Universal Primer Hardener 11-00
Number of layers:	1-3 depending on requirements (see optional mixing)
Items Needed:	2K DTM Primer and Universal Primer Hardener 11-00

## Acceptable Substrates

Automotive Panel surfaces to include:

Steel, Aluminum, Fiberglass, SMC, and various plastics and composites.

OEM Finishes, E-coated replacements, and OEM primed plastics

## Substrate Preparation

All surfaces shall be cleaned prior to performing sanding, or spraying activity.  
594-30 Wax and Grease Remover

Steel: Sand Dry P80-P120 Grit

Aluminum: Sand with 3M 7447 Pad (or equal) or P120-P220 Dry

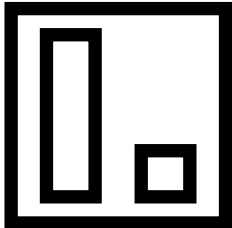
Fiberglass, SMC, OEM E-Coat, and OEM primed plastics\*:

Sand with P120-P220 Dry

OEM finishes: Sand with P180-P220 Dry or P220-P320 Wet

\*Note: Unprimed plastic parts use Orion Ionic Adhesion Promoter

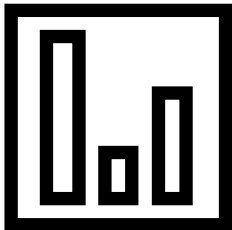
## Mixing Ratios and optional



When use as a sanding filler/surfacer:

4 Parts 2K DTM Primer 1350-100, 150, or 200

1 Part Universal Primer Hardener 11-00



When used as a sealer, or non-sanding filler:

4 Parts 2K DTM Primer 1350-100, 150, or 200

1 Part Universal Primer Hardener 11-00

2 Parts Urethane Reducer 594-UR60, 70, or 80

## Additives

Orion Automotive Finishes does not offer, or require, any additives for this product.

## **Application**

Application as a sanding surfacer/filler can be 2-3 coats depending on requirements. **Allowing thorough flash time will improve cure and speed overall dry times.**

Application as a sealer or non-sanding filler apply 1-2 single coats.

Spray gun Recommendations:

*Large areas where filling is desired*

Gravity feed Primer grade gun 1.8-2.0 Fluid tip @ 12-16 PSI inlet pressure

*Small repairs or use as a "wet on wet" sealer*

Topcoat grade gun 1.4-1.6 Fluid tip @ 14-20 PSI inlet pressure

## **Dry Times/Pot Life @ 77F/25C**

(Dry/flash times dependent on layer thickness)

Flash time between coats: 5-10 Minutes

Flash time to topcoat: 15-20 Minutes when dry to touch. If greater than 3 hours sand and continue or re-apply.

Dry to Sand: 30-40 minutes

Pot Life: 45 minutes

## **Recoating**

After dry and sanding Orion 1350 Series 2K DTM Primer can be top coated directly with itself or any Orion Brand Basecoat, or Single Stage product.

Recoating with 1350 Series 2K DTM Primer:

Sand with P220-P320 Wet or P180-P220 Dry

Recoating with Orion Basecoat:

Sand with P500-P800 Wet or P320-P500 Dry

## **Safety and Emissions Data**

Color: Black, Gray, or White

The appropriate selection of this product is based on many local factors and is ultimately most accurate when made by the customer. To assist in issues with regard to product selection please contact Orion Automotive Finishes.

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

**SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.**

**NOTE: Orion Automotive Finishes products are not recommended for use in temperatures below 65°F. Use below these temperatures will effect dry times and performance.**