

2.1 VOC DTM PRIMER SURFACER

PRODUCT FEATURES

- Compatible with a wide range of topcoats including waterborne basecoats
- Easy Sanding
- High Build
- Direct-to-Metal Application
- 2.1 VOC Compliant



SUBSTRATES

Properly sanded and treated:

- Steel
- Aluminum
- Some Plastics
- Fiberglass
- Body Filler
- OEM Finishes

AVAILABILITY

2.1 DTM (Part A)		Unit	Per Case	Catalyst (Part B)		Unit	Per Case
APR-1300-1	Gray	GAL	2	BPR-1304-4	Catalyst	QT	4
APR-1300-4	Gray	QT	6	BPR-1260-6	Catalyst	HP	6

PHYSICAL PROPERTIES

Pot Life	2 hours @70°F	Humidity Resistant	Excellent
Flash Point	60°F	Color Holdout	Excellent
Dry Film Build	2 to 3 mils	Inter Coat Adhesion	Excellent
Sprayable Viscosity (RTS)	24-25 " #2 Zahn Cup	Reparability Catalyzed	Excellent
Weight Solids (RTS)	59.96 %	Adhesion to Bare Metal	Excellent
VOC (RTS)	< 2.1 (lb./gal)	Theoretical Coverage @ 1 mil (A+B)	
		Gray	739.2 sq ft

2K PRIMER

DRY TIMES



@ 70°F

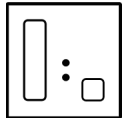
Air Dry

Flash	10 to 15 minutes
Sand & Topcoat	Allow primer to dry 2-3 hours before sanding and topcoating.
Note	All test are performed at 70°F, higher temperatures will provide faster drying times.

Force Dry

Flash	5 to 10 minutes
Bake	140° F for 25 to 35 minutes
Sand & Topcoat	Allow substrate to cool to room temperature before sanding and topcoating.

MIX RATIO (HI-BUILD)



4 Parts Primer	2.1 VOC DTM
1 Part Catalyst	Catalyst

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.6 to 1.8 mm	7-10 PSI
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COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure.

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish, improper adjustment may cause orange peel, runs, poor drying and poor adhesion just to name a few defects.

SURFACE PREPARATION

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean dry cloth, then clean with AXIS PRE-CLEAN, using generous amounts and changing rags frequently prior to painting.
- Sand area as necessary to remove any rust or corrosion, and then repair all body damage.
- Dry sand old finishes by hand or machine with P320 to P400 grit paper or wet sand using P400 grit paper.
- Re-wipe vehicle with AXIS PRE-CLEAN.

APPLICATION

- Apply 2 to 3 medium wet coats. If spot priming, for best results apply first coat of 2.1 VOC DTM starting with the outer layer working yourself towards the center of the repair.
- Block sand primed bodywork with P400 grit or finer wet or dry sandpaper.

TIPS OF THE TRADE

- This primer does not need any reduction.
- At 85°F the primer takes 20 min to flash off, cooler temperatures will cause this time to increase.
- If spraying over ALUMINUM, sand with 80 grit DA paper and clean thoroughly with a rag soaked in AXIS PRE-CLEAN remover until no black residue transfers to the rag.
- DO NOT use over galvanized steel.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

PRODUCT SAFETY INFORMATION

Before using any AXIS Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.