



AXIS 2.1 DTM PRIMER GRAY

APR1255-1, APR1255-4

Version: 2.0 Date of issue: 07/10/2019 Revision Date: 08/16/2019 Supersedes: 07/10/2019

TECHNICAL DATASHEET

AXIS 2.1 DTM PRIMER GRAY is a high solids VOC compliant 2K 4:1 acrylic coating that can be used as a multi-role coating.

- High solids content.
- Easy to sand with great holdout.
- Protective sealant properties eliminate the need for epoxy sealants.
- Tintable with 10% mixing base.
- Excellent adhesion direct to metal and over OEM paint, e-coat, fiberglass, most plastics and polyester filler.
- Triple Tight Tin fits on a standard mixing bank.

Application Guide

Tools Required



Personal Protective Equipment (see Safety Data Sheet), P180 – P600 abrasives, HVLP Gun, solvent/water-based degreasers, Etch Primer

Surface Preparation



Degreaser

Original Paint

Galvanised

Aluminum

Bare Steel

GRP, SMC, Fiberglass

Polyester Body Filler

OEM E-Coat

Fast/Slow Solvent-Based Degreaser

Fast/Slow Solvent-Based Degreaser

Fast/Slow Solvent-Based Degreaser

Fast/Slow Solvent-Based Degreaser

Water-Based Degreaser

Fast/Slow Solvent-Based Degreaser

Fast/Slow Solvent-Based Degreaser

Abrasion

P280 (dry), P320 (wet)

P180*

P180*

P180

P240 (dry)

P240 (dry)

Light abrasion

AXIS 2.1 DTM PRIMER GRAY is multifunctional and has superb adhesion to all the substrates above.

For best results, good preparation is essential. Abrade with grit paper as stated above for each respective substrate. Clean and degrease removing dirt, oil, grease and wax with a cleaning solution, such as a solvent/water-based degreaser (please check local VOC regulations).

Abrade with grit paper as stated above for each respective substrate.

Re-clean, dry and degrease the abraded substrate ready for application.

*For optimum results on galvanised steel and aluminium surfaces, apply 1-2 light even coats of an Etch-Primer as per manufacturer's instructions.

Mixing ratio



		Parts by Volume	Final Volume			
			250 ml	500 ml	750 ml	1000 ml
APR1255-1, APR1255-4	Primer Base	4	328 g	655 g	983 g	1310 g
BPR2261-4, BPR2261-6	Fast Activator (41-68°F)	1	53 g	106 g	159 g	212 g
BPR2271-4, BPR2271-6	Medium Activator (59-95°F)		55 g	111 g	166 g	221 g
BPR2281-4, BPR2281-6	Slow Activator (77-113°F)		58 g	116 g	174 g	232 g

Gun Application



	High Build Primer	Primer Surfacer	Wet-on-Wet
Mixing Ratio	4:1	4:1:1	4:1:2
Viscosity (Zahn #2)	50 – 70 s	20 – 22 s	16 – 18 s
Working Pot-Life at 68°F	1 - 2 hours	1 – 2 hours	2 – 3 hours
Gun Tip Size	1.7 - 2 mm	1.6 - 1.8 mm	1.3 – 1.7 mm
Air Pressure at Gun	1.8 - 2 bar (26 - 29 PSI)	1.8 - 2 bar (26 - 29 PSI)	1.8 - 2 bar (26 - 29 PSI)








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Coats 	Number of Coats	1 - 2	2 - 3	1 – 2
	Flash-off at 68°F between coats	15 minutes	10 minutes	10 minutes
	Flash-off at 68°F prior forced drying	15 minutes	10 minutes	10 minutes
	Dry Film Build	180 µm (7 MIL)	100 - 120 (4-5 MIL)	30 – 60 µm (1-2 MIL)
	Approximate Theoretical Coverage* @ 1 MIL DFT	802 ft²/Gal	667 ft²/Gal	574 ft²/Gal
Drying Time 	Air Drying Sandable at 20°C	3 - 4 hours	3 - 4 hours	2 – 3 hours
	Force Drying Sandable at 60°C (surface temperature)	30 minutes	30 minutes	30 minutes
Sanding 	Dry Sanding	P320 - P400	P320 - P400	P320 - P400
	Wet Sanding	P500 – P800	P500 – P800	P500 – P800
Over-Painting 	AXIS 2.1 DTM PRIMER GRAY can be overpainted with most water-based or solvent-based paint systems or solid colors.			
Technical information				
Physical properties 	Appearance	Viscous, Liquid.		
	Color	Gray		
	Specific gravity / density	≈ 1.645 (1.6 - 1.69) g/cm³		



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VOC Information



APR1255	Unmixed		
As Packaged Regulatory VOC	268 g/l (2.24 lb/gal)		
As Packaged Actual VOC	203 g/l (1.69 lb/gal)		
Percent Solids	76 wt%		
Volatiles	24.0 wt%		
Water Content	0 wt%		
Water Content	0 vol%		
Exempt Compounds	11.7 wt%		
Exempt Compounds	24.3 vol %		
% HAPS	6.3 wt%		
Specific gravity / density	1638 g/l (13.7 lbs/gal)		
Mixed with BPR2261 Fast Activator	4:1	4:1:1	4:1:2
	APR1255:BPR2261	APR1255: BPR2261:Reducer*	APR1255:BPR2261:Reducer*
As Applied Regulatory VOC	248 g/l (2.1 lbs/gal)	234 g/l (2.0 lbs/gal)	234 g/l (2.0 lbs/gal)
As Applied Actual VOC	170 g/l (1.4 lbs/gal)	127 g/l (1.1 lbs/gal)	111 g/l (0.9 lbs/gal)
Percent Solids	70.63 wt%	60.51 wt%	55.46 wt%
Volatiles	29.4 wt%	39.5 wt%	44.5 wt%
Water Content	0 wt%	0 wt%	0 wt%
Water Content	0 vol%	0 vol%	0 vol%
Exempt Compounds	18.2 wt%	30.1 wt%	36.0 wt%
Exempt Compounds	31.7 vol%	45.6 vol%	52.4 vol%
% HAPS	5.4 wt%	4.3 wt%	4.0 wt%
Specific gravity / density	1522 g/l (12.7 lbs/gal)	1362 g/l (11.4 lbs/gal)	1301 g/l (10.8 lbs/gal)
Mixed with BPR2271 Medium Activator	4:1	4:1:1	4:1:2
	APR1255:BPR2271	APR1255: BPR2271:Reducer*	APR1255:BPR2271:Reducer*
As Applied Regulatory VOC	248 g/l (2.1 lbs/gal)	222 g/l (1.8 lbs/gal)	222 g/l (1.8 lbs/gal)
As Applied Actual VOC	170 g/l (1.4 lbs/gal)	118 g/l (1.0 lbs/gal)	105 g/l (0.9 lbs/gal)
Percent Solids	70.43 wt%	57.92 wt%	53.59 wt%
Volatiles	29.6 wt%	42.1 wt%	46.4 wt%
Water Content	0 wt%	0 wt%	0 wt%
Water Content	0 vol%	0 vol%	0 vol%
Exempt Compounds	18.5 wt%	33.3 wt%	38.3 wt%
Exempt Compounds	31.3 vol%	46.9 vol%	52.8 vol%
% HAPS	5.4 wt%	3.9 wt%	3.6 wt%
Specific gravity / density	1531 g/l (12.8 lbs/gal)	1342 g/l (11.2 lbs/gal)	1289 g/l (10.7 lbs/gal)
Mixed with BPR2281 Slow Activator	4:1	4:1:1	4:1:2
	APR1255:BPR2281	APR1255:BPR2281:Reducer*	APR1255:BPR2281:Reducer*
As Applied Regulatory VOC	248 g/l (2.1 lbs/gal)	248 g/l (2.1 lbs/gal)	248 g/l (2.1 lbs/gal)
As Applied Actual VOC	170 g/l (1.4 lbs/gal)	142 g/l (1.2 lbs/gal)	121 g/l (1.0 lbs/gal)
Percent Solids	69.85 wt%	62.78 wt%	57.01 wt%
Volatiles	30.1 wt%	37.2 wt%	43.0 wt%
Water Content	0 wt%	0 wt%	0 wt%
Water Content	0 vol%	0 vol%	0 vol%
Exempt Compounds	19.1 wt%	27.3 wt%	34.0 wt%
Exempt Compounds	31.4 vol%	42.9 vol%	51.0 vol%
% HAPS	5.4 wt%	4.8 wt%	4.4% by weight
Specific gravity / density	1542 g/l (12.9 lbs/gal)	1430 g/l (11.9 lbs/gal)	1350 g/l (11.2 lbs/gal)
<p>These values are based on theoretical calculations. Batch-to-batch variations may lead to small differences in VOC values. Please be aware that the addition of additives such as a Reducer will lead to changes in VOC content.</p> <p>* 4:1:1 and 4:1:2 values have been based on mixing with a generic "Low VOC fast" reducer. Please ensure you use a reducer that will not cause your final mix to exceed local VOC limits.</p>			

Shelf Life & Storage



Equipment Cleaning	Clean gun immediately after use with a thinner or gunwash. Please choose gun-cleaner products which are VOC compliant in your area.		
Important Remarks	Activated material should not be returned to the original can of non-activated material. Do not use activated product beyond pot life. After 10 minutes standing, the paint may need mild agitation to reliquify before 2nd and 3rd coat applications.		
Order Code	Format	Shelf Life	Comment
APR1255-1 AXIS 2.1 DTM PRIMER GRAY	1 US Gallon Tin	2 years	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
APR1255-4 AXIS 2.1 DTM PRIMER GRAY	1 QT Tin	2 years	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.

Axis Performance Coatings™ - Liberty Bell Equipment Corp.
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BPR2261-4 AXIS 2.1 DTM FAST CATALYST	1 QT Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
BPR2261-6 AXIS 2.1 DTM FAST CATALYST	250ml Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
BPR2271-4 AXIS 2.1 MEDIUM CATALYST	1 QT Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
BPR2271-6 AXIS 2.1 MEDIUM CATALYST	250ml Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
BPR2281-4 AXIS 2.1 DTM SLOW CATALYST	1 QT Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
BPR2281-6 AXIS 2.1 DTM SLOW CATALYST	250ml Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.

Store in a well-ventilated place. Keep cool. Keep container tightly closed. Store locked up.

Recommended storage temperature 41 - 77°F

IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.

This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. AXIS PERFORMANCE COATINGS disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the AXIS PERFORMANCE COATINGS website at WWW.AXISCOATINGS.COM. AXIS PERFORMANCE COATINGS is not responsible for the results obtained by others over whose methods we have no control and thereof AXIS PERFORMANCE COATINGS is not liable for consequential or incidental damages including loss of profits.