



GENERAL INFORMATION

DTM2004 primer is formulated with a hybrid of epoxy and acrylic polymers, which provide excellent adhesion, good corrosion resistance, productive dry times and ease of sanding. This primer emits very low amounts of Volatile Organic Compounds (VOC's), Hazardous Air Polluting Solvents (HAPS) and contain no isocyanates.



1. COMPONENTS

- DTM2004 DTM Surfacer/Sealer Gray
- DTMA DTM Activator
- LVBF100 Reducer Fast Low VOC
- LVBM100 Reducer Medium Low VOC
- LVBS100 Reducer Slow Low VOC
- 171 Reducer Fast
- 172 Reducer Medium
- 173 Reducer Slow
- 174 Reducer Very Slow
- 171HP Reducer High Performance Fast
- 172HP Reducer High Performance Medium
- 173HP Reducer High Performance Slow
- 174HP Reducer High Performance Very Slow
- X01 Reducer Fast Low VOC
- X02 Reducer Medium Low VOC



2. MIXING RATIO

AS PRIMER SURFACER - 4:1:1 (by volume)

- Mix four (4) parts DTM2004 Primer to one (1) part DTMA activator and reduce with one (1) part solvents or reducers listed above.

USA/Canada VOC compliant rules:

- For VOC 3.5 compliant use 170 or 170HP Series Reducers
- For VOC 2.1 compliant use Low VOC Reducers: X01, X02 or LVB100 Series Reducers

AS PRIMER SEALER - 4:1:2 (by volume)

- Mix four (4) parts DTM2004 Primer to one (1) part DTMA activator and reduce with two (2) parts solvents or reducers listed above

USA/Canada VOC compliant rules:

- For VOC 4.6 compliant use 170 or 170HP Series Reducers
- For VOC 2.1 compliant use Low VOC Reducers: X01, X02 or LVB100 Series Reducers



3. POT LIFE @ 77°F (25°C)

- 2-3 Hours



4. CLEAN UP

- Use Valspar Refinish Reducers listed above (check local regulations)



5. ADDITIVES

- ACCELERATOR: DO NOT USE
- FISHEYE: N/A
- FLEX ADDITIVE: Not Required

NOTE: Do not spray when surface temperature is below 50°F(10°C)



6. SURFACE PREPARATION

- Wash surface with mild detergent and water
- Rinse and dry surface
- Wipe surface with 155 Surface Cleaner (steel) or 170 Aqua Clean (steel/aluminum) and wipe dry with clean cloth before product flashes
- Sand and featheredge substrate with P320 grit sandpaper and or body fillers P180 or equivalent
- Clean surface with 155 Surface Cleaner or 170 Aqua Clean and wipe dry with clean cloth before product flashes



7. TOPCOATS

- N/A



8. TECH NOTES

- N/A



9. SUBSTRATES

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel
- Properly cleaned and sanded fiberglass, SMC, E-Coat and OEM Finish
- Properly prepared OEM E-Coat



10. APPLICATION

AS PRIMER SURFACER:

- Spray one (1) to three (3) medium wet coats

AS PRIMER SEALER:

- Spray one (1) to two (2) medium wet coats
- Allow primer sealer to flash dull between coats



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)	AS PRIMER SURFACER	AS PRIMER SEALER
Flash Time	10-15 Minutes	5-10 Minutes
To Sand	60-90 Minutes	Nib Sand 20 Minutes
To Topcoat	30 Minutes*	20-30 Minutes*
*To Topcoat without sanding	N/A	8 Hours Max

*Reduction may accelerate flash times



12. INFRARED CURE

- N/A



13. GUN SET UP

SEE PAGE 2



If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Confirm compliance with state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. **UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.



13. GUN SET UP (continued)

CONVENTIONAL GUN	
Gravity Feed	1.6 mm - 2.0 mm
Siphon Feed	1.8 mm - 2.0 mm
HVLP	
Gravity Feed	1.4 mm - 1.8 mm

AIR PRESSURES

Conventional @ Gun	
Gravity Feed	30-35 psi (2.0-2.5 bar)
Siphon Feed	30-40 psi (2.0-2.8 bar)
HVLP	
	20-30 psi (1.5-2.0 bar)
See spray gun manufacturer	



14. PHYSICAL DATA

FOR USA/Canada (3.5/2.1 LBS./GAL Compliance)

RTS REGULATORY DATA	4:1:1		4:1:1	
	(170 or 170HP Series Reducers)		(X01, X02 or LVB100 Series Reducers)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
Actual VOC	3.0 Max.	360 Max.	1.3 Max.	165 Max.
Regulatory VOC (less water and exempt solvents)	3.5 Max.	420 Max.	2.1 Max.	250 Max.
Density	10 - 12	1200 - 1440	10 - 12	1200 - 1440
	WT. %	VOL. %	WT. %	VOL. %
Total Solids Content	55 - 65	40 - 50	50 - 60	40 - 50
Total Volatile Content	35 - 45	50 - 60	40 - 50	50 - 60
Water	0	0	0	0
Exempt Compound Content	15 - 25	15 - 25	30 - 40	35 - 45
Coating Category	Primer Surfacer			

NOTE: US/Canadian Regulations allow for the use of exempt compounds for VOC calculations.



14. PHYSICAL DATA (continued)

FOR USA/Canada (4.6/2.1 LBS./GAL Compliance)

RTS REGULATORY DATA	4:1:2		4:1:2	
	(170 or 170HP Series Reducers)		(X01, X02 or LVB100 Series Reducers)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
Actual VOC	3.9 Max.	470 Max.	1.25 Max.	150 Max.
Regulatory VOC (less water and exempt solvents)	4.6 Max.	550 Max.	2.1 Max.	250 Max.
Density	10 - 12	1200 - 1440	10 - 12	1200 - 1440
	WT. %	VOL. %	WT. %	VOL. %
Total Solids Content	50 - 60	30 - 40	45 - 55	30 - 40
Total Volatile Content	40 - 50	60 - 70	45 - 55	60 - 70
Water	0	0	0	0
Exempt Compound Content	15 - 25	15 - 25	40 - 50	40 - 50
Coating Category	Primer Sealer			

NOTE: US/Canadian Regulations allow for the use of exempt compounds for VOC calculations.

FOR REST-OF-WORLD (outside US and Canada):

RTS REGULATORY DATA	4:1:1		4:1:2	
	(170 or 170HP Series Reducers)		(170 or 170HP Series Reducers)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
VOC	5.1 Max.	620 Max.	6.1 Max.	740 Max.
Density	10 - 12	1200 - 1440	10 - 12	1200 - 1440
	WT. %	VOL. %	WT. %	VOL. %
Total Solids Content	55 - 65	40 - 50	50 - 60	30 - 40
Total Volatile Content	35 - 45	50 - 60	40 - 50	60 - 70
Water	0	0	0	0
Coating Category	Primer Surfacer		Primer Sealer	

NOTES

If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Confirm compliance with state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. **UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.