



DTM 1600 Series ***Waterborne Urethane Bonding Primer***

DESCRIPTION

Single component waterborne urethane bonding primer
Interior and exterior surfaces
Soap & Water Cleanup
Very Low Odor - Low VOC
Ultra-Violet resistant

Suitable for a variety of substrates including ferrous and non-ferrous metal, masonry, drywall, MDF,
Corrosion resistant
Excellent adhesion & chemical resistant
LEED NC 2009 compliant

TECHNICAL DATA

% SOLIDS by volume	40%
COATINGS VOC (as packaged)	less than 50 g/l (less water & exempt compounds)
SPRAYABLE VOC (as applied)	less than 50 g/l (less water & exempt compounds)
RESIN TYPE	urethane dispersion
COMPONENTS	single component
SHELF LIFE	one year (unopened)
FLASH POINT	144° F (62° C)
RECOMMENDED DRY FILM THICKNESS	1.0 mils to 3.0 mils DFT
THEORETICAL COVERAGE	641 – 213 sq ft at recommended DFT (no loss)

SURFACE PREPARATION

DTM 1600 may be applied directly over properly prepared substrates including steel, aluminum, galvanizing, and decorative metals such as copper and brass as well as concrete, masonry, wood, MDF, and drywall.

Steel – Clean the surface to ensure that the substrate is free of grease, oil, dirt, wax, mildew, or other contaminants and abrade with 220 grit sandpaper or finer (SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7). PCI's 02150 Metal Conditioner may be used to clean and treat steel substrates to eliminated oil, soap film, grease, and flash rusting.

Aluminum & Galvanizing – Clean the surface to ensure that the substrate is free of grease, oil, dirt, wax, mildew, rust, or other contaminants and abrade with 220 grit sandpaper or finer (SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7). PCI's 02150 Metal Conditioner may be used to clean and treat aluminum and galvanizing to eliminate oil and soap film.

Concrete, Masonry, Wood, MDF, Drywall – Surface must be clean, dry and free of any dirt, oil, dust, grease, oil, wax, mildew, disintegrated or chalky materials or other contaminants. Not recommended as a stain blocking primer for tannic acid or water stains.

PRECISION COATINGS

1940 E. Trafficway, Springfield, MO 65802
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INSTRUCTIONS

Stir or shake thoroughly to ensure uniform mixture.

Reduction is not necessary. However, paint may be reduced up to 5% by volume using tap water.

APPLICATION

May be applied by brush, roller or spray. If sprayed, 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 1.0 to 3.0 mils DFT.

SPRAY GUN SET-UP & PRESSURE

<u>Type</u>	<u>Fluid Tip</u>	<u>Spraying Pressure</u>
Siphon Feed	1.4mm – 1.7mm	40-65-PSI
Gravity Feed	1.3mm – 1.4mm	40-65 PSI
HVLP Siphon	1.6mm – 1.8mm	max. 10 PSI @ the air cap
HVLP Gravity	1.3mm – 1.5mm	max. 10 PSI @ the air cap
Pressure Pot	1.1 mm- 1.3 mm	29 PSI - 58 PSI
Airless Spray	.015" - .025"	2500 PSI 100 mesh filter

DRY TIMES

Dry times @ 70°F (21°C) and 50% RH

Dust Free	15 minutes
Dry to Touch	1 hour
Dry Time	24 hours
Full Cure	14 days
Recoat	Unlimited - no recoat time necessary Sanding will become necessary after 24 hours.

CLEAN UP

Clean all tools and spray equipment immediately after use with soap and warm water. Acetone may be used as a final rinse.

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, Inc. experience and research and is believed to be reliable. As PCI 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. 4.2011

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PERFORMANCE DATA

TEST METHOD	SYSTEM (30 day, ambient temp. cure)	RESULTS
ASTM D-3359 Adhesion	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.5 mils DFT DTM 1600 Primer 1.2 mils DFT PC6 Topcoat	100% retention (no tape off)
ASTM B-117 Salt Fog	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.5 DFT DTM 1600 Primer 1.2 mils DFT PC6 Topcoat	No face blistering after 100 hours No face corrosion after 100 hours
ASTM D-2287 Humidity Resistance	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.5 DFT DTM 1600 Primer 1.2 mils DFT PC6 Topcoat	No blistering, cracking, softening or delamination after 100 hours Gloss - 88% retention after 100 hours
ASTM D-1308 Chemical Resistance 24 hour spot test	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.5 DFT DTM 1600 Primer 1.2 mils DFT PC6 Topcoat	Water resistance – rating 5 no effect 2 % Sulfuric Acid (Acid Rain) – rating 5 no effect
ASTM D-4366 Pendulum Hardness	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.5 DFT DTM 1600 Primer 1.2 mils DFT PC6 Topcoat	Glass = 100s PC6 Waterborne Urethane 94s
ASTM D-522 Flexibility	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.5 DFT DTM 1600 Primer 1.2 mils DFT PC6 Topcoat	180 degree bend, 1/4" mandrel - pass

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