AUTOMOTIVE REFINISH

GLOBAL REFINISH SYSTEM

Product Information

Direct to Metal Primer Surfacer/Sealer

UniPrime® DTM

D8040 WHITE
D8041 BLACK
D8042 GRAY
D8043 RED
D8044 YELLOW
D8045 BLUE

UniPrime® DTM is a two-pack primer surfacer/sealer for use under Global topcoat colours. It can be applied directly to sanded aluminum, galvanized steel or cold rolled steel, without a pretreatment or wash primer application. UniPrime® DTM primer surfacer/sealer is available in six stand alone bases which may be blended together to obtain a wide variety of colors. UniPrime® DTM must be activated with D8240 DTM Hardener. UniPrime® can also be reduced and sprayed as a sealer.

Preparation of Substrate:

In all cases, wash with soap and water, then use the appropriate Global cleaner. See GLG-142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Original Paintwork and Electrodeposition Primer
Surfacer - Must be sanded using European P280 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 grade paper (wet). Minimum of 1 – 1.5 mils. Exposed bare metal should be prepared as described below.
Sealer – A minimum dry film build of 1.0 – 1.5 mils is required when spraying as a sealer.

Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using European P180 / U.S. 180 to European P280 / U.S. 240 grit paper.
Surfacer - Must be clean, rust-free and abraded before application. A minimum dry film build of 2.0 mils after sanding is required when spraying as a surfacer.
Sealer – 2 coats of Uniprime® DTM **MUST** be used over bare metal when mixed as a sealer. A Minimum film build of 2.0 mils is required over properly prepared bare metal substrates.

Polyester Body Fillers should be dry sanded using European P280 / U.S. 240 grit paper. Uniprime® DTM is only recommended over polyester body fillers as a surfacer. Do not apply Uniprime® DTM as a sealer over polyester body fillers.

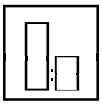
Fibre Glass and SMC should be dry sanded using European P280 / U.S. 240 grit paper.

Ensure that the substrate is thoroughly cleaned and dried after preparation work.

APPLICATION GUIDE

Mixing Ratio:

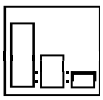
Surfacer



UniPrime® DTM	**2 vols**
D8240 Hardener	**1 vol**

Note: 10% acetone may be added to the RTS UniPrime® DTM to improve flow properties and extend potlife. If VOC is not a concern, 10% of the appropriate temperature range Global D-Series thinner may be added to improve flow and potlife.

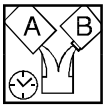
Sealer



UniPrime® DTM	**2 vols**
D8240 Hardener	**1 vol**
Global D-Series Thinner	**½ vol max**

Thinner Selection	***Temperature***	***Thinner***
	Up to 18°C / 65°F	D870
	18° - 25°C / 65° - 77°F	D871
	25° - 35° C / 77° - 95°F	D872
	Over 35°C / 95°F	D873
Retarder (Up to 25%)	Very Warm	D8700
Fast Compliant	Cool	D8764
Medium Compliant	Medium	D8774
Compliant	Warm	D8767

Potlife:

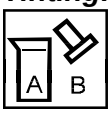


Surfacer	30 minutes @ 20°C / 68°F 45 minutes @ 20°C / 68°F with 10% acetone or global thinner
Sealer	45 minutes @ 20°C / 68°F

Additives:

None

Tinting:



DTM Primer Surfacer and Sealer colors may be blended together.
See DTM Swatch Deck – DOX431
DTM Primer cannot be tinted with any other product.

Spraygun set-up:

1.4 – 1.6 mm or equivalent

Spray pressure:

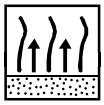
HVLP at air cap	0.7 bar / 10 PSI
Conventional at spray gun	2.5 - 3.5 bar / 35-45 PSI

Number of coats:

2 - 4 coats as a surfacer
1 - 2 coats as a sealer

APPLICATION GUIDE (Continued)

Drying times:



Between coats @ 20ºC / 68ºF		5 – 10 minutes
Before stoving @ 20ºC / 68ºF		10 minutes

Dust-free	Surfacer	20 minutes
20ºC / 68ºF:	Sealer	20 minutes
Tape	Surfacer	90 minutes
20ºC / 68ºF:	Sealer	60 minutes

Dry to sand	Surfacer	1 – 2 hours
20ºC / 68ºF:	Sealer	1 – 2 hours

Dry to sand	Surfacer	20 – 30 minutes*
60ºC / 140ºF	Sealer	20 – 30 minutes*
Dry to sand IR medium	Surfacer	10 – 20 minutes
	Sealer	10 – 20 minutes

	1Coat	*2 Coats*
Dry to Topcoat (Sealer)		
20ºC / 68ºF:	30 minutes minimum**	60 minutes minimum**
60ºC / 140ºF	15 minutes	15 minutes

**Stoving times are for quoted metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.*

***If the sealer is allowed to dry more than 6 hours, it must be scuffed and reapplied before color application.*

Overcoat:

Surfacer – Overcoat with any Global sealer or topcoat.
Sealer – Overcoat with any Global topcoat.

Performance Guidelines:

The use of HVLP spray equipment can increase transfer efficiency by about 10% depending on the make and model of equipment used.

Technical Data:

Total dry film build

Minimum build:	
Surfacer	50µm / 2.0 mils
Sealer	25µm / 1.0 mils
Maximum:	
Surfacer	150µm / 6.0 mils
Sealer	75µm / 3.0 mils
Theoretical coverage RTS unreduced	21.2 m² per l / 860 sq. ft. per US gal.
Percent solids by volume RTS unreduced	53.5 m² per l / 860 sq. ft. per US gal.

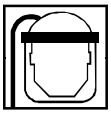
VOC:

Surfacer	
D804X	371 gms per litre / 3.1 lbs per US gal.
D804X:D8240 (2:1)	395 gms per litre / 3.3 lbs per US gal.
D804X:D8240 (2:1) Less exempt solvents	359 gms per litre / 3.0 lbs per US gal.
D804X:D8240:Acetone (2:1:+10%) Less exempt solvents	359 gms per litre / 3.0 lbs per US gal.
D804X:D8240:D872 (2:1:+10%)	458 gms per litre / 3.9 lbs per US gal.
Sealer	
D804X:D8240:Compliant Thinner or Acetone (2:1:½) Less exempt solvents	359 gms per litre / 3.0 lbs per US gal.
D804X:D8240:D872 (2:1:½)	481 gms per litre / 4.0 lbs per US gal.

Health and Safety:

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

-The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.



-Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.

-Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
-Provide adequate ventilation for health and fire hazard control.
-Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.

–Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
–Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information (304) 843-1300; In Canada (514) 645-1320

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Global At A GLANCE

Uniprime® DTM

Direct to Metal Primer Surfacer

Mix:

MIX UniPrime® DTM

Surfacer

DTM Primer		8240 Hardener
2	:	1

Note: 10% acetone may be added to the RTS UniPrime® DTM. If VOC is not a concern, 10% of the appropriate temperature range Global D-Series thinner may be added.

Sealer

DTM Primer		8240 Hardener		Global D Series Thinner
2	:	1	:	½

Thinner Selection	***Temperature***	***Thinner***
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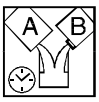
Pot life:



Surfacer	30 minutes @ 20°C / 68°F 45 minutes @ 20°C / 68°F with 10% acetone or Global thinner
Sealer	45 minutes @ 20°C / 68°F

Air Pressure:

HVLP:	0.7 bar / 10 PSI
Conventional:	2.5 - 3.5 Bar / 35 - 45 PSI at the gun
Fluid tip:	1.4 - 1.6 mm or equivalent

Application:

Apply:	2 - 4 coats as a surfacer 1 - 2 coats as a sealer
Between coats:	5 - 10 minutes
Before stoving:	10 minutes

Dry Times:

Dust-free 20ºC / 68ºF:	Surfacer	20 minutes
	Sealer	20 minutes
Tape 20ºC / 68ºF:	Surfacer	90 minutes
	Sealer	60 minutes
Dry to sand 20ºC / 68ºF:	Surfacer	1 – 2 hours
	Sealer	1 – 2 hours
Dry to sand 60ºC / 140ºF	Surfacer	20 – 30 minutes*
	Sealer	20 – 30 minutes*
Dry to sand IR medium	Surfacer	10 – 20 minutes
	Sealer	10 – 20 minutes

Dry to Topcoat (Sealer)	*1Coat*	*2 Coats*
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**Stoving times are for quoted metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.*

***If the sealer is allowed to dry more than 6 hours, it must be scuffed and reapplied before color application.*

Warning: Do not use sealer applications over polyester body filler substrates. Use surfacer applications only for these substrates.