



GLOBAL REFINISH  
SYSTEM

# Product Information

## UniPrime® DTM Direct to Metal Primer Surfacer (D8042 Gray)

### Product Description

UniPrime® DTM is a two-pack primer surfacer/sealer for use under Global topcoat colors. 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 gray. 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 EU-134 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 U.S. 240 / European P280 grit discs (dry) or U.S. 320 /European P360 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 U.S. 180 – 240 /European P180 – P280 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 U.S. 240 /European P280 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 U.S. 240 /European P280 grit paper.

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

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## APPLICATION GUIDE

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### Mixing Ratio:



*Surfacer*

UniPrime® DTM 8042    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.*

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*Sealer*

UniPrime® DTM 8042    2 vols  
D8240 Hardener    1 vol  
Global D-Series Thinner    1/2 vol max

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### Thinner Selection:

| Thinner      | Temperature                   |
|--------------|-------------------------------|
| D870         | Up to 65°F / 18°C             |
| D871         | Up to 65° – 77°F / 18° – 25°C |
| D872         | Up to 77° – 95°F / 25° – 35°C |
| D873         | Over 95°F / 35°C              |
| D8700        | Retarder (Up to 25%)          |
| D8764        | Fast Compliant, Cool          |
| D8774        | Medium Compliant, Medium      |
| <b>D8764</b> | Compliant, Warm               |

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### Pot life:



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

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### Additives:

None

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### 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.

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### Spraygun set-up:



*Fluid Tip*    1.4 – 1.6 or equivalent

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### Spray pressure:

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

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### Number of coats:



*Apply*    2 – 4 coats as a surfacer  
1 – 2 coats as a sealer

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### Flash off at 68°F / 20°C:








*Between Coats*    10 – 15 minutes  
*Before Force Dry*    10 minutes

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## APPLICATION GUIDE

### Drying Times:

|   |                                      | Surfacer          | Sealer                       |
|---|--------------------------------------|-------------------|------------------------------|
|  | <i>Dust Free</i><br>68°F / 20°C      | 20 minutes        | 20 minutes                   |
|  | <i>Tape Time</i><br>68°F / 20°C      | 90 minutes        | 60 minutes                   |
|  | <i>Dry to Sand</i><br>68°F / 20°C    | 1 – 2 hours       | 1 – 2 hours                  |
|  | 140°F / 60°C<br><i>IR medium</i>     | 20 – 30 minutes** | 20 – 30 minutes**            |
|  | <i>Dry to Topcoat</i><br>68°F / 20°C | -                 | 1 coat, 30 minutes minimum*  |
|   | 140°F / 60°C                         | -                 | 2 coats, 60 minutes minimum* |
|   |                                      |                   | 1 coat, 15 minutes**         |
|   |                                      |                   | 2 coats, 15 minutes**        |

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

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

### Overcoat/Recoat:



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: | <b>Surfacer</b> | 2.0 mils / 50µm |
|                | <b>Sealer</b>   | 1.0 mils / 25µm |

|          |                 |                  |
|----------|-----------------|------------------|
| Maximum: | <b>Surfacer</b> | 6.0 mils / 150µm |
|          | <b>Sealer</b>   | 3.0 mils / 75µm  |

**Theoretical coverage RTS unreduced** 860 sq. ft. per US gal. / 21.2 m<sup>2</sup> per litre

**Percent solids by volume RTS unreduced** 53.5

#### VOC:

##### Surfacer

D8042 3.1 lbs per US gal. / 371 gms per litre

D8042:D8240 (2:1) 3.3 lbs per US gal. / 395 gms per litre

D8042:D8240 (2:1)  
Less exempt solvents 3.0 lbs per US gal. / 359 gms per litre

D8042:D8240:Acetone  
(2:1:+10%) Less exempt solvents 3.0 lbs per US gal. / 359 gms per litre

D8042:D8240:D872 (2:1:+10%) 3.9 lbs per US gal. / 458 gms per litre

##### Sealer

D8042:D8240:Compliant Thinner or  
Acetone (2:1:½) Less exempt solvents 3.0 lbs per US gal. / 359 gms per litre

D8042:D8240:D872 (2:1:½) 4.0 lbs per US gal. / 481 gms per litre

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## 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.

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## Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320

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Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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