



## P-250 DTM Epoxy Primer

### PRODUCT DESCRIPTION:

P-250 DTM EPOXY PRIMER is a fast dry primer/sealer that has tremendous corrosion resistance and adhesion to almost any surface. This primer can be used on all properly prepared metals and plastics. P-250 DTM Epoxy Primer can be topcoated with all topcoat finishes including acrylic lacquer. The DTM Epoxy Primer is an excellent sealer when reduced 25-100% with R-102 or R-103 urethane reducer. When using as a sealer do not reduce with R-101 Fast Urethane Reducer.

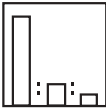


### Features:

- May be topcoated in 30-60 minutes
- Superior corrosion resistance in harsh environment
- Superior humidity resistance
- Excellent color holdout
- Superior adhesion to bare steel, sanded fiberglass and etched or sanded aluminum
- Tintable with 10% Acrylic Urethane & Acrylic Urethane Basecoat

### COMPATIBLE SUBSTRATES:

- Properly sanded or etched aluminum
- Properly cleaned steel
- Clean, deoxidized galvanized steel
- Properly cleaned, sanded stainless steel
- Clean, sanded fiberglass, SMC
- All other primers
- Automotive plastics except polyethylene



### MIXING INSTRUCTIONS - 2:1 or 2:1:(25% or up to 1 Part Reducer)

#### As a High Build Primer- 2:1

2 parts - P-250 DTM Epoxy Primer

**\*\*SHAKE THOROUGHLY BEFORE MIXING\*\***

1 Part - P-251 DTM Epoxy Primer Activator

#### As a Primer Sealer 2:1:(25% or up to 1 Part Reducer)

2 Parts - P-250 DTM Epoxy Primer

1 Part - P-251 DTM Epoxy Activator

25% or up to 1 Part - R-102, R-103 Urethane Reducer **\*\*Do NOT use R-101 Urethane Reducer\*\***

**SURFACE PREPARATION:**

Thoroughly remove all wax, grease, oil, corrosion and dirt. All corrosion should be removed and metal prepared as for any paint application. Old finishes must be properly sanded and cleaned with LC-101, LC-102 (or equivalent). Aluminum must be thoroughly sanded or sprayed with an etch primer before applying DTM Epoxy Primer.

**Applying Over Body Filler:** Sand area according to body filler manufacturer's recommendations. Sand OEM surfaces with 180-220 grit sandpaper. Re-clean with LC-102 Water Based wax and grease remover.

**Cold Rolled Steel, Galvanized Steel & Galvaneal:** Sand area with 180-220 grit sandpaper. Re-clean with LC-101 Solvent Wax and Grease Remover.

**Aluminum:** Scuff surface with a red scuff pad or equivalent. Blast with 80-100 Grit Aluminum Oxide or Garnet Media. Clean with LC-101 Solvent Wax and Grease Remover. Do not use coarse grit sandpaper.

**Factory E-coat:** Wash area with soap and warm water. Thoroughly clean area with LC-101 Solvent Wax and Grease Remover or LC-102 Water Based Pre-Clean. LC-102 must be used where VOC restrictions apply. Allow surface to dry thoroughly before applying primer.

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**APPLICATION INSTRUCTIONS:**

- Apply 1-2 full wet coats of P-250 DTM Epoxy Primer using a good quality spray gun
- Dry film build should be .75 to 1.0 Mil thick.
- Allow 10-15 minutes flash time between coats.
- Allow 30 minutes to one hour dry time before topcoating. Thinner coats will reduce dry time when sprayed as a primer.
- When sprayed as a sealer, only one full wet coat is normally needed and allow 30 minutes of dry time before topcoating. No sanding is required before topcoating if sprayed in the same day.

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**RECOMMENDED SPRAYING INSTRUCTIONS:**

- Conventional gravity 1.6 mm – 1.8 mm @ 35 – 45 psi at the gun.
- Siphon 1.3 mm – 1.8 mm @ 35 – 45 psi at the gun.
- HVLP 1.0 mm – 1.8 mm @ 8 – 10 psi at the gun cap.
- Open fan adjustment to achieve maximum atomization.
- Apply 1-2 coats as needed.
- Spray each coat with a medium wet coat.



**DRY TIMES:**



- Flash between Coats: 10"/37 minutes
- To topcoat when sprayed as a sealer : 50 minutes
- To topcoat without sanding when sprayed as a primer : 30 minutes - 1 Hour
- Flash between coats: 10"/37 minutes
- To topcoat when sprayed as a sealer : 50 minutes
- To topcoat without sanding when sprayed as a primer : 30 minutes - 1 Hour

**Sanding:**



Allow P-250 DTM Epoxy Primer to thoroughly cure before sanding. Allow 60 minutes @ 70°F (21°C) air dry for each coat of primer applied. For example - apply two coats, allow 2 hours dry time before sanding. Apply three coats, allow 3 hours before sanding. If applying basecoat directly over P-250, finish sand with 400-600 grit sandpaper if not topcoating in the same day.

**CLEANING:**



Use a good quality lacquer thinner or urethane reducer (LT-01 or R-101/R-102/R-103 Reducer) to thoroughly clean all equipment. Clean equipment immediately after use. Do not allow catalyzed material to remain in gun longer than 30 minutes.

**TECHNICAL DATA:**



Color:	Grey
Pot Life:	8 Hours Minimum B 92•H*43•E+
Mix Ratio:	2:1 High Build or 2:1:(25% or up to 1 part reducer)
Solids by Weight (Mixed):	72.7% "
Solids By Volume (Mixed):	33.8%
Sprayable Viscosity:	19 Sec. #2 Zahn
Induction Time:	5 Minutes
Approx. Coverage @ 1 mil	542 sq ft/gal
Weight Per Gallon - Primer	10.7 lbs/gal.
Weight Per Gallon - Catalyst	7.10 lbs/gal.
V.O.C. RTS (ready to spray)	4.7 lbs/gal or 570 g/l
Shelf Life	12 Months