



HIGH TECK TECHNICAL DATA SHEETS

HIGH SOLIDS DTM PRIMER/ SEALER/ACTIVATOR

77425-1 (GL) 2.1 VOC High Solids DTM Primer/Sealer - Gray
77425-4 (QT) 2.1 VOC High Solids DTM Primer/Sealer - Gray
77426-4 (QT) High Solids DTM Primer Activator
77426-16 (HP) High Solids DTM Primer Activator

TECHNICAL DATA SHEET & PROCESS GUIDE

Product Description: High Teck™ 2.1 VOC High Solids DTM Primer/Sealer is a 2K epoxy hybrid product that offers excellent adhesion, corrosion resistance, and easy sanding. Also has exceptional filling capabilities and productive dry times, sandable in as little as 60 minutes.

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77426-16 (HP) High Solids DTM Primer Activator



Sandable 60 min



Surface Preparation

- Clean all areas to be primed with compliant wax and grease remove to remove all contaminants
- Featheredge and sand the original finish
- Surface must be clean and dry

Rust and Oxidation must be removed prior to applying primer

Mixing Directions:

High Build Primer Filler:

Mix: 4 parts #77425 DTM Primer & 1 part #77426 Activator

Regular Build Primer Filler:

Mix: 4 parts #77425 DTM Primer & 1 part #77426 Activator & 1 part Urethane Reducer - Nat'l Rule exempt reducer for compliancy

Primer Sealer:

Mix: 4 parts #77425 DTM Primer & 1 part #77426 Activator & 2 parts Urethane Reducer - Nat'l Rule exempt reducer for compliancy

Clean Up

Clean spray equipment immediately after use with a virgin wash thinner

Substrates

Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel

Properly cleaned and sanded fiberglass, SMC, E-Coat, and OEM finish

First Aid:

In case of eye contact, immediately flush eyes with plenty of water for at least 15 minutes and get medical attention. For skin: Wash thoroughly with water. If difficulty in breathing is experienced, get medical attention immediately. If swallowed, do not induce vomiting, get medical attention immediately. See Safety Data Sheet.

Safety Information - For Industrial Use Only

Danger: Vapor harmful. May affect the brain or nervous system causing dizziness, headache, or nausea. May cause eye, skin, nose, and throat irritation. Harmful if swallowed. Precautions: Vapors may ignite explosively. Keep away from heat, sparks, and flame. Vapors may cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn of stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Prevent buildup of vapors by opening all windows and doors to achieve cross-ventilation. Use only with adequate ventilation. Do not breathe vapor or spray mist. Do not get in eyes, on skin or clothing. Wash thoroughly after handling. Wear solvent resistant gloves. The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

KEEP OUT OF REACH OF CHILDREN

Physical Properties

Pot Life: 2-3 hours at 77F

Accelerator: N/A

Fisheye: Flex N/A

Additive: Air Not required

Dry: at 77F

Flash Between Coats: 10-20 minutes

To Sand: 60-90 minutes To

Topcoat: 30 minutes*

VOC Reg: 204 g/l VOC

Actual: 141 g/l

VOC Content: 207.2 g/l | 1.73 lb/gl

Disposal/Safety: See SDS for this product

Note: Do not spray when surface temp is below 50F

Note: Reduction may accelerate flash times

* To Topcoat without sanding - 24 hours max

Gun Setup

	Air Pressure Conventional at Gun	Panel	Overall
Conventional			
Gravity feed 1.6mm-2.0mm	gravity feed	30-35psi	40-45psi
Siphon feed 1.8mm-2.0mm	siphon feed	30-40psi	45-55psi
HVLP 1.6mm-2.0mm	HVLP @ Cap	6-8psi	8-10psi

Note: The 77425 is NOT TINTABLE with any other paint system but it can be intermixed with High Teck #77423 WHITE and #77424 BLACK primers.