



GENERAL INFORMATION

999DTM is a neutral-color Direct to Metal primer base formulated with a hybrid of epoxy and acrylic polymers, providing excellent adhesion, good corrosion resistance, productive dry times, and ease of sanding. 999DTM primer emits very low amounts of Volatile Organic Compounds (VOCs), Hazardous Air Polluting Solvents (HAPS), and contains no isocyanates.



1. COMPONENTS

- 999DTM Neutral Primer
- CPS1-5 Colorants
- DTMA Activator
- X01 Fast Exempt Uni-Solvent
- X02 Medium Exempt Uni-Solvent
- LVB100 Fast LV Reducer up to 80°F (27°C)
- LVBM100 Medium LV Reducer 80°F-90°F (27°C-32°C)
- LVBS100 Slow LV Reducer 90°F (32°C) and over
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- 173 Slow Uni-Solvent 85°-95°F (29°-35°C)
- 174 Very Slow Uni-Solvent 95°F (35°C) and over
- 171HP High Performance Reducer Fast
- 172HP High Performance Reducer Medium
- 173HP High Performance Reducer Slow
- 174HP High Performance Reducer Very Slow



2. MIXING RATIO

Mix three (3) parts 999DTM to one (1) part CPS 1-5 to make tinted primer.

Mix four (4) parts 999DTM tinted primer to one (1) part DTMA activator and reduce with one (1) part reducer for priming.

Mix four (4) parts 999DTM tinted primer to one (1) part DTMA activator and reduce with two (2) parts reducer for sealing.

Use X01, X02, LVB100 reducers for 2.1 VOC compliance.



3. POT LIFE @ 77°F (25°C)

2-3 Hours



4. CLEAN UP

Valspar Refinish 170 Series, LVB100 Series, X01, X02 reducers (check local regulations).



5. ADDITIVES

ACCELERATOR: DO NOT USE

FISHEYE: N/A

FLEX ADDITIVE: Not Required

Note: Do not spray when surface temperature is below 50°F (10°C).



6. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with 155 Surface Cleaner (steel) or 170 (steel/aluminum) and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with P320 grit sandpaper and or body fillers P180 or equivalent.
- Clean surface with 155 Surface Cleaner or 170 and wipe dry with clean cloth before product flashes.



7. SUBSTRATES

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel
- Properly cleaned and sanded fiberglass, SMC, E-Coat and OEM Finish
- Properly cleaned OEM E-Coat.



8. APPLICATION

- Spray one to three medium wet coats. as a primer
- Spray one to two medium wet coats as s sealer
- Allow 10-20 minutes between coats.



9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

| | |
|-----------------------------|------------------|
| Flash Time | 10-20 Minutes |
| To Sand | 60-90 Minutes |
| To Topcoat | 30 Minutes* |
| *To Topcoat without sanding | 12 hours maximum |

Note: Reduction may accelerate flash times.



10. GUN SET UP

CONVENTIONAL GUN

Gravity Feed 1.6 mm - 2.0 mm

Siphon Feed 1.8 mm - 2.0 mm

HVLP

Gravity Feed 1.4 mm - 1.8 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed 30-35 psi

Siphon Feed 30-40 psi

HVLP 20-30 psi

See spray gun manufacturer



11. PHYSICAL DATA (4:1:1) Base Color (Reduced)

| Solvent Mixed | VOC (4:1:1) |
|---|-------------------------|
| X Series Uni-Solvent / LVB100 Series Reducers | 2.1 lbs./gal. (Average) |
| 170 Series Uni-Solvent | 3.2 lbs./gal. (Average) |
| Weight Solids | 58.75% (Average) |
| Volume Solids | 42.52% (Average) |
| Recommended DFT | 0.5 - 4 mils. |
| Flash Point | -4°F |

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