



GENERAL INFORMATION

DTM2035 Multi-Use Direct to Metal Primer surfacer/sealer is formulated to provide the ultimate in performance, productivity, versatility, adhesion, durability, moisture and corrosion resistance, and superior sanding and sealing characteristics.



1. COMPONENTS

- DTM2035 Primer
- DTMA2035 Activator
- X01 Fast Exempt Reducer
- X02 Medium Exempt Reducer
- 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

PRIMER- 4:1:1 (by volume)

Mix four (4) parts DTM2035 to one (1) part DTMA2035 activator and reduced with one (1) part solvents or reducers listed above.

USA VOC compliant rules:

For VOC 3.5 compliant use Exempt Reducers X01 or X02.
For VOC national rule use solvents or reducers listed above

SEALER- 4:1:2 (by volume)

Mix four (4) parts DTM2035 to one (1) part DTMA2035 activator and reduced with two (2) parts solvents or reducers listed above.

USA VOC compliant rules:

For VOC 3.5 compliant use Exempt Reducers X01 or X02.
For VOC national rule use solvents or reducers listed above.



3. POT LIFE @ 77°F (25°C)

45-60 Minutes



4. CLEAN UP

Uni-Solvent 171-174 or Exempt Reducers X01, X02 (check local regulations).



5. SURFACE PREPARATION

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



6. 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.

NOTE: Do not apply over Self Etching Primers



7. APPLICATION

Primer:

- Spray one to three medium wet coats
- Allow 10-15 minutes between or until surface has dulled to a matte finish
- Recommended Dry Film Thickness 1.0-4.0 mils (25-100 µm)

Sealer:

- Spray one medium coat
- Recommended Dry Film Thickness 0.6-1.0 mils (15-25 µm)

Note:

- Surface temperature should be 50-100°F (10-38°C) with less than 80% humidity preferred
- If primer is allowed to dry more than 24 hours before topcoating. Primer must be resanded



8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)	PRIMER	SEALER
Flash Time	10-15 Minutes	5-10 Minutes
To Sand	60-90 Minutes	Nib Sand 20 Minutes
To Topcoat	30 Minutes	20-30 Minutes
To Topcoat Without Sanding	N/A	8 Hours Maximum



9. GUN SET UP

CONVENTIONAL GUN	PRIMER	SEALER
Nozzle	1.5-1.9 mm	1.3-1.5 mm
Air Cap	1.5-1.9 mm	1.3-1.5 mm
Inlet Air Pressure	30-45 psi (2.0-3.1 bar)	30-45 psi (2.0-3.1 bar)

HVLP	PRIMER	SEALER
Nozzle	1.5-1.9 mm	1.3-1.5 mm
Air Cap	1.5-1.9 mm	1.3-1.5 mm
Inlet Air Pressure	20-30 psi (1.5-2.0 bar)	25-35 psi (1.7-2.5 bar)

See spray gun manufacturer info



10. PHYSICAL DATA

RTS REGULATORY DATA	4:1:1 (170 Reducer Line)		4:1:1 (Exempt Reducer Line)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
	Actual VOC	4.35 Max.	522 Max.	2.98 Max.
Regulatory VOC (less water and exempt solvents)	4.8 Max.	580 Max.	3.5 Max.	420 Max.
Density	9 - 13	1080 - 1560	9 - 13	1080 - 1560
	WT. %	VOL. %	WT. %	VOL. %
Total Volatile Content	35 - 50	50 - 70	35 - 50	50 - 70
Water Content	0	0	0	0
Exempt Compound Content	10 - 20	10 - 20	15 - 35	15 - 35



10. PHYSICAL DATA (Continued)

RTS REGULATORY DATA	4:1:2		4:1:2	
	(170 Reducer Line)		(Exempt Reducer Line)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
Actual VOC	4.35 Max.	523 Max.	2.98 Max.	357 Max.
Regulatory VOC (less water and exempt solvents)	4.6 Max.	550 Max.	3.5 Max.	420 Max.
Density	9 - 13	1080 - 1560	9 - 13	1080 - 1560
	WT. %	VOL. %	WT. %	VOL. %
Total Volatile Content	35 - 55	55 - 70	40 - 55	55 - 70
Water Content	0	0	0	0
Exempt Compound Content	5 - 15	5 - 15	15 - 35	15 - 35

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