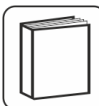
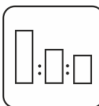


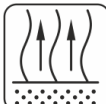
TECHNICAL INFORMATION

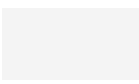
FOR PROFESSIONAL USE ONLY

MULTI DTM 4:1 MULTIFUNCTIONAL ACRYLIC PRIMER	
PRODUCTS	
MULTI DTM 4:1 – Multifunctional Acrylic Primer Hardener 1:4 for MULTI DTM 4:1 Primer Thinner for acrylic products	
PRODUCT DESCRIPTION	
High-quality 2K multifunctional acrylic primer with the addition of anti-corrosion agents, intended for car repairs. Thanks to the use of advanced technology and high-class MULTI DTM ingredients it has a very wide range of applications. It works perfectly both as a filling undercoat and an insulating primer. It can be applied directly to metal, providing excellent corrosion protection for areas ground to bare steel. It insulates very well difficult substrates and putty areas from varnish coatings, protecting them against the effect of the so-called mapping. An additional advantage of the primer is the possibility of applying the "wet on wet" technique, without the need for sanding. The undercoat is available in 3 colours: gray, white and black. Mixing the available colours in the right proportions allows you to obtain 2 additional colours, which allows you to work in the full spectrum gray system and select the recommended base colour for the target base colour. Benefits: • Excellent anti-corrosion protection of steel. • Strong adhesion to various types of surfaces. • Very good insulating and filling properties. • Very short curing time. • Can be applied using the "wet on wet" technique. • Working in the spectral gray system.	
	COLOURS: white, grey, black
	GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS	
VOC for the mixture (priming version) = 539 [g/l] for thinning = 4+1+20% These products meet the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l. The requirements of the directive are not met for the wet on wet version.	
SURFACE PREPARATION	
The multifunctional primer can be applied over: • Bare steel and aluminum after matting and degreasing. • Zinc coated, galvanized steel after matting and degreasing. • Sanded polyester laminates (GFK/GRP). • Polyester putties. • Polyester primers. • Isolation primers. • Old finishes in good condition after matting and degreasing.	Good surface preparation is necessary for achieving best results. Following sandpaper gradations are recommended: • sanding by hand (dry): P280÷P400; (wet) P400-P800. • sanding by machine (dry): P240÷P400.

APPLICATION PROCESS					
	USE				NUMBER OF LAYERS AND GUN PARAMETERS
	For car repairs as a grounding primer for sending (filling or priming option) and for the application with so-called wet-on-wet technique.				Grinding option: 1÷2 layers • filling version - about 80 µm for a single dry layer. • grounding version - approx. 50 µm for a single dry layer. Gun parameters: RP nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.5÷1.7 mm; Inlet pressure: 2.0 bars. Wet-on-wet option: 1.5 layers. Approx. 30 µm for a single dry layer. Gun parameters: RP nozzle: 1.2÷1.4 mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.3÷1.5 mm; Inlet pressure: 2.0 bars.
	MIXING RATIO	by volume	by weight		
	Primer	4 parts	100		
	Hardener	1 part	17,4		
	Thinner:				
	filling option	5÷10%			
	grounding option	15÷20%			
	wet-on-wet option	25÷30%			
	Stir thoroughly until achieving homogenous mixture.				

	SPRAYING VISCOSITY Filling option (at 5-10% thinner): 40÷30 seconds at 20°C/DIN4 Grounding option (at 15-20% thinner): 25÷20 seconds at 20°C/DIN4 Wet-on-wet option (at 25-30% thinner): 19÷17 seconds at 20°C/DIN4		HARDENING TIME Hardening time at 20°C: - Grounding version (50 ÷ 100 µm): ready for sanding after 1.5 ÷ 2.5 h. - Filling version (80 ÷ 160 µm): ready for sanding after 2 ÷ 3 h.
	POT LIFE Filling option: approx. 15 minutes at 20°C. Grounding option: approx. 15 minutes at 20°C. Wet-on-wet option: approx. 20 minutes at 20°C.		Curing time at an object temperature of 60°C - Grounding version (50 ÷ 100 µm): ready for sanding after baking for 15 ÷ 20 minutes and cooling the coating (about 1h). - Filling version (80 ÷ 160 µm): ready for grinding after baking for 20 ÷ 30 minutes and cooling the coating (about 1h).
	EVAPORATION TIME Between layers: 5÷10 minutes Before applying solvent base: approx. 20 minutes Before applying water base: approx. 30 minutes Evaporating time depends on temperature and layer thickness.		Temperature below 20°C significantly increases the hardening time.
	DRY SANDING Machine sanding: P360÷P500. Hand sanding: P320÷P500. Wet-on-wet doesn't require sending!		IR DRYING Grounding version (50÷-100 µm): 6÷8 minutes under short waves. Filling version (80÷160 µm): 8÷10 minutes under short waves. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000. Wet-on-wet doesn't require sending!		

COLOURES			
COLOUR	SHADE OF GREY	MIXING RATIO % BY WRIGHT	RECOMMENDED BASE COLOUR
	RAL 9003	100 % white	orange, white, yellow
	RAL 7040	100% grey	red (shade of red)
	RAL 7045	13 : 87 (black : grey)	lightgrey, light green, light blue, dark red
	RAL 7015	64,3 : 35,7 (black : grey)	grey, blue, dark greek
	RAL 9004	100% black	black

In order to obtain RAL 7015 and 7045 colours, the black and grey primer should be mixed in the following proportions by volume					
RAL 7045	100 ml	250 ml	500 ml	750 ml	1000 ml
BLACK	13 ml	33 ml	67 ml	100 ml	134 ml
GREY	87 ml	217 ml	433 ml	650 ml	866 ml

RAL 7015	100 ml	250 ml	500 ml	750 ml	1000 ml
BLACK	65 ml	162 ml	325 ml	487 ml	649 ml
GREY	35 ml	88 ml	175 ml	263 ml	351 ml

In order to obtain RAL 7015 and 7045 colours, the black and grey primer should be mixed in the following proportions by weight					
RAL 7045	141 g (100 ml)	353 g (250 ml)	706 g (500 ml)	1059 g (750 ml)	1413 g (1000 ml)
BLACK	18 g	46 g	92 g	138 g	184 g
GREY	123 g	307 g	614 g	921 g	1229 g

RAL 7015	140 g (100 ml)	348 g (250 ml)	697 g (500 ml)	1045 g (750 ml)	1393 g (1000 ml)
BLACK	90 g	224 g	448 g	672 g	896 g
GREY	50 g	124 g	249 g	373 g	497 g

FURTHER WORK

2K acrylic fillers can be directly over coated with:

- 2K top coats.
- 1K base coats.

Also:

- 2K polyester putties.
- 2K acrylic primers.

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. After each use the container with product should be immediately closed!
2. Protect the hardener from frost and dampness!

WARRANTY PERIOD

MULTI DTM 4:1 – Multifunctional Acrylic Primer
Hardener 1:4 for MULTI DTM 4:1 Primer

– 12 months from the date of production
– 12 months from the date of production

PRODUCTS	ART. NO.
MULTI DTM 4:1 – Multifunctional Acrylic Primer	(0,8l + 0,2l): 14700; 14701; 14702 (3,6l): 14696; 14697; 14698
Hardener 1:4 for MULTI DTM 4:1 Primer	14699 (0,9l)
Thinner for acrylic products	300002258; 300002260 (1l; 5l)
Thinner for acrylic products – slow	14712 (5l)
Thinner for acrylic products – fast	14713 (5l)

LIMITATION OF LIABILITY

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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Ząbrowo, Poland.