

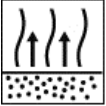





Technical Data Sheet



P400 DTM Primer- Sealer

| | | | | |
|-----------------------------|---|--|--|---|
| Features: | Versatile DTM Primer, fast drying & good filling properties, easy to sand | | | |
| Benefits: | Allows fast throughput in the body shop, ensures good topcoat finish | | | |
| Recommended Use: | Multi-purpose primer that has outstanding sanding properties, fast drying, and an excellent top finish | | | |
| Mixing Ratio: |  | <p>High Build Primer 4:1</p> <p>100% by vol. Toucan Primer</p> <p>25% by vol. Toucan Hardener</p> <p>Primer Filler 4:1:1</p> <p>100% by vol. Toucan Primer</p> <p>25% by vol. Toucan Hardener</p> <p>25% by vol. Toucan Reducer</p> <p>Primer Sealer 4:1:2</p> <p>100% by vol. Toucan Primer</p> <p>25% by vol. Toucan Hardener</p> <p>50% by vol. Toucan Reducer</p> | <p>Part #</p> <p>P400</p> <p>H306, H307, H308</p> <p>P400</p> <p>H306, H307, H308</p> <p>R10, R20</p> <p>P400</p> <p>H306, H307, H308</p> <p>R10, R20</p> | |
| Surface Preparation: | Clean with a universal cleaner, sand the surface to promote adhesion, and clean one more time with a Universal Cleaner | | | |
| Technical Data: | Specific Weight: | 1.536 kg/l | | |
| | Flash Point: | Closed cup: >25°C (>77°F) | | |
| | Solids Vol %: | 68.2% | | |
| | Coverage: | Ca. 8 m ² /L at 40 µm | | |
| | Viscosity (RTS): | 2 sec. at 20°C (68°F) | | |
| | Gloss: | Matt | | |
| | Color: | Grey | | |
| | V.O.C. Actual: | 454 g/l (3.8 lbs/gal) | | |
| | V.O.C. Regulatory: | 454 g/l (3.8 lbs/gal) | | |
| | V.O.C. Regulatory RTS (less water, less exempts): | 531 g/l (4.4 lbs/gal) | | |
| | Applicable Use Category: | Primer | | |
| Air Pressure & Nozzle Size: | | <p><u>Air Pressure</u></p> <p>HVLP: 25-40 psi (1.7-2.8 bar)</p> <p>Conventional: 45-60 psi (3-4 bar)</p> | <p><u>Nozzle Size</u></p> <p>HB Primer</p> <p>Primer Filler</p> <p>Sealer</p> | <p>2.0 mm</p> <p>2.0 mm</p> <p>1.7 mm</p> <p>1.7 mm</p> <p>1.3-1.7 mm</p> <p>1.3-1.5 mm</p> |
| | | For the best overall result, refer to the spray gun manufacturer's recommendations. | | |
| Application: |   | <p>Flash-off time of 5-15 minutes at 20°C (68°F) between coats.</p> <p>High Build: 2 – 3 full coats</p> <p>Sealer: 1 – 2 medium wet coats</p> | <p>Coat Thickness: 4.7 – 5.5 mil (120 - 140 µm)</p> <p>Coat Thickness: 2.5 – 4 mil (60- 100 µm)</p> | |
| Drying Times: |  | <p>At 20°C (68°F) 3-4 hours</p> <p>At 60°C (140°F) 30 minutes</p> | | |



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|--|--|-------------|--------------------------|--------------------------|
| Pot Life at 20°C (68°F): | 30 minutes | | | |
| Sanding:   | 600-800 wet by hand 400-500 Orbital sander | | | |
| Hardener Selection Guide: | Temperature Range | | | |
| | Product # | Description | 85°F-95°F (30°C-35°C) | 70°F-85°F (21°C-30°C) |
| | H306 | Slow | | |
| | H307 | Medium | | |
| | H308 | Fast | | |
| Remarks: | As primer filler on flexible plastics always use a flexing agent to make it flexible. Use directly on to TPA thermoplastic acrylics, galvanized sheet, or aluminum may result in cracking, lifting, blistering | | | |
| Packaging: | Size: 3.5 L, 1 L | | | |