



# METALOCK DTM HIGH BUILD PRIMER

## TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

### DESCRIPTION

Metalock™ DTM High Build Primer is a two component epoxy primer for use on metal, aluminum, SMC and fiberglass.

### FEATURES

- Superior adhesion
- Outstanding corrosion protection
- Exceptional filling properties
- High build formula
- Sealer mixing option
- Easy to sand

### SUITABLE SUBSTRATES

- Steel
- Aluminum
- Plastic
- SMC
- Fiberglass
- OEM finish
- Primer

### TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
ML010	Metalock DTM High Build Primer Kit	Gray	Kit
ML014	Metalock DTM High Build Primer	Gray	Quart
MLH16	Metalock Hardener	Clear to Amber	Half Pint
<b>RTS weight solids:</b>		60%	
<b>RTS volume solids:</b>		40.5%	
<b>Regulatory VOC (ML014):</b>		0.63 #/gl (76 g/l)	
<b>Actual VOC (ML014):</b>		0.32 #/gl (38 g/l)	
<b>Regulatory VOC (MLH16):</b>		5.45 #/gl (654 g/l)	
<b>Actual VOC (MLH16):</b>		4.47 #/gl (536 g/l)	
<b>Regulatory VOC MIXED:</b>		2.01 #/gl (242 g/l)	
<b>Actual VOC MIXED:</b>		1.15 #/gl (138 g/l)	



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<b>Pot life:</b>	@ 70°F (21°C) and 50% R.H. 12 hours
<b>Coverage at 2 mils:</b>	325 sq.ft./gal

Use VOC calculator to determine VOC of mixtures. Check local VOC regulations to ensure compliance of all products in your area.

## HANDLING AND APPLICATION

### PREPARATION:

#### STEEL AND ALUMINUM:

Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Apply to 180 grit sanded or sandblasted steel or aluminum. If rust or corrosion is present, grind or sandblast until all rust and corrosion have been removed. Blow off and clean again with **SEM Solve** or **XXX Universal Surface Cleaner**.

#### SMC AND FIBERGLASS:

First, clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Next, sand with 180 grit sand paper. Blow off dust and re-clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Blow off again to ensure the surface is completely dry. Do not saturate exposed fibers.

#### Note:

When using **Metallock** as a sealer, sand the surface with 320 grit sandpaper or finer.

### MIXING:

For best results, use at approximately 70°F (21°C).

Thoroughly mix **Metallock DTM High Build Primer** and **Metallock Hardener** before use.

#### AS A HIGH BUILD PRIMER, MIX BY VOLUME:

4 Parts	1 Part
Metallock DTM High Build Primer	Metallock Hardener

#### AS A PRIMER SEALER, MIX BY VOLUME:

4 Part	1 Part	1 Part
Metallock DTM High Build Primer	Metallock Hardener	High quality urethane reducer

**Metallock** is ready to spray once mixed and does not require an induction period.

#### Note:

**Metallock Hardener** may appear yellow or darken over time. This is normal and will not affect the product's performance.



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## APPLICATION:

Product Name:	Fluid Tip	Coats	Flash Time between
High Build Primer	1.7-2.0	2 Medium	10-15 minutes
Primer Sealer	1.3-1.5	1 Medium	10-15 minutes

<b>Air Pressure:</b>	6-9 psi at the cap with HVLP equipment
	25-45 psi for non HVLP equipment

<b>Time to Apply Body Filler:</b>	24 hours
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Allow a minimum of 2 hours dry time before sanding. Allow a minimum of 1 hour before top-coating. Dry times may vary depending on film build and shop conditions.

If waiting longer than 24 hours to recoat, **Metalock** must be sanded with 180 grit or finer sand paper.

## CLEANUP:

Use appropriate cleaning materials compliant with VOC regulations in your area.

## STORAGE:

**Metalock DTM High Build Primer** and **Metallock Hardener** should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Metalock DTM High Build Primer** and **Metallock Hardener** is 3 years when stored under normal conditions.

## RELATED PRODUCTS:

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart