



PRODUCT FEATURES

- Compatible with a wide range of topcoats.
- Easy Sanding
- Ultra High Build
- Excellent Adhesion Over Bare Metal
- 2.1 VOC Compliant

SUBSTRATES

Properly sanded and cleaned:

- Steel
- Stainless Steel
- Aluminum
- Fiberglass
- Body Filler
- OEM Finishes
- Some Plastics

AVAILABILITY

<u>PART NO</u>	<u>DESCRIPTION</u>	<u>SIZE</u>	<u>PER CASE</u>
FPR-7931	2.1 VOC DTM 2K PREMIUM HIGH BUILD — Gray	GAL	2
FPR-7934	2.1 VOC DTM 2K PREMIUM HIGH BUILD — Gray	QT	6
FPR-79314	Catalyst	QT	4
FPR-79316	Catalyst	HP	6

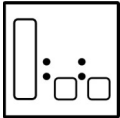
PHYSICAL PROPERTIES

Pot Life	2 hours	Humidity Resistant	Excellent
Flash Point	60° F	Color Holdout	Excellent
Dry Film Build	2.5 to 3 mils	Inter Coat Adhesion	Excellent
Sprayable Viscosity (RTS)	24-25 " #2 Zahn Cup	Reparability Catalyzed	Excellent
Weight Solids (RTS)	59.96 %	Theoretical Coverage @ 1 mil (A+B)	
VOC (RTS)	<2.1 (lb./gal)	Gray	739.2 sq ft

**DRY TIMES AT 70°F**

AIR DRY: Allow primer to flash for 10-15 minutes between coats. To sand & topcoat primer must be allowed to cure for 2 to 3 hours. All dry times are measured at 70°F, higher temperatures will provide faster drying times.

FORCED DRY: Purge 5 to 10 minutes, then bake at 140°F for 25 to 35 minutes. Allow primer to cool to room temperature before sanding and top coating.

**MIX RATIO**

To four (4) parts FPR-7931/7934 - DTM 2K PRIMER SURFACER add one (1) part FPR-79314/79316 Catalyst, and one (1) part Compliant Urethane Reducer

**SPRAY GUN ADJUSTMENT AND SETUP**

GUN TYPE: Siphon or Gravity feed HVLP

NOZZLE/TIP SIZE: 1.8 to 2.0 mm is required for proper atomization.

AIR PRESSURE: 45 to 55 PSI at the gun or 7-10 PSI at the cap.

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish, improper adjustment may cause orange

**COLD SHOP CONDITIONS**

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure. One-half (½) fluid ounces of ACCELERATOR per mixed quart may be added to improve cure response in adverse facility conditions.

**SURFACE PREPARATION**

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean dry cloth, then clean with PRE-CLEAN, using generous amounts and changing rags frequently prior to painting.
- Sand area as necessary to remove any rust or corrosion, and then repair all body damage.
- Dry sand old finishes by hand or machine with 320P to 400P grit paper or wet sand using 400P grit paper.
- Sand bare metal with 80 grit DA paper, then clean substrate with PRE-CLEAN to remove sanding dust.
- Prime galvanized steel with an Etching or Epoxy Primer prior to applying 7931 DTM 2K Primer Surfacer.

**APPLICATION**

- Apply 2 to 3 medium wet coats. If spot priming, for best results apply first coat of 2.1 VOC DTM 2K Primer Surfacer starting with the outer layer working yourself towards the center of the repair.
- Block sand primed bodywork with #400P grit or finer wet or dry sandpaper.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

PRODUCT SAFETY INFORMATION

Before using any FINISH-PRO product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.