

ViterThane DTM270 Primer/Finish

Product Description	A two pack polyurethane, one coat* finish for use on steelwork.				
Features & Use	<ul style="list-style-type: none"> A two pack polyurethane 'Direct To Metal' one coat system with maximum performance and high durability characteristics Allows quick turnaround due to rapid film hardening with excellent chemical and solvent resistance Suitable for commercial and industrial usage where a high gloss, durable finish is required, such as the ACE market Easily cleaned gloss surface 				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Gloss				
Volume Solids	53 ± 2% depending on colour				
VOC Content	410 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	75 µm	142 µm	7.1 m ² /litre	
	Maximum*	100 µm	188 µm	5.3 m ² /litre	
* See Product Notes Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 75 microns DFT	+10°C	+23°C	+35°C	
	Dust Free	2½ hr	1½ hr	1 hr	
	Hard Dry	12 hr	8 hr	5 hr	
	Overcoating	Minimum	24 hr	12 hr	10 hr
		Maximum	4 days	3 days	2 days
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	BS, RAL and shades to order				
Mix Ratio/ Product Code	12DTM270-	Base	4 parts by volume		
	12DTM270-ACT-	Hardener	1 part by volume		
Pot Life	3 hours at 23°C				
SG	1.39 kg/lit mixed, varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23°C – 60°C				

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Surface Preparation	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns 														
Mixing	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.</p>														
Thinner / Cleaner	<p>Axalta Thinner TH600 (formerly called Thinner No.6)</p>														
Application Conditions	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C.</p>														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="451 869 692 936">Method</th> <th data-bbox="692 869 940 936">Airless Spray</th> <th data-bbox="940 869 1187 936">Conventional Spray</th> <th data-bbox="1187 869 1339 936">Brush</th> <th data-bbox="1339 869 1490 936">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 936 692 987"></td> <td data-bbox="692 936 940 987">Yes</td> <td data-bbox="940 936 1187 987">Yes</td> <td data-bbox="1187 936 1339 987">Yes</td> <td data-bbox="1339 936 1490 987">Yes</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes
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<ul style="list-style-type: none"> Airless Spray: Output fluid pressure at tip 1800-2500 psi, Tip Size: 11-15 thou (0.28-0.38mm) Air assisted airless: Use tip 11-15 thou (0.28-0.38mm), 40-80° angle and 1500-2500 psi Conventional spray: thin up to 5-10%, using 50-60 psi pressure and 1.4-1.8mm tip size Brush and roller are recommended for small touch-up areas only, as the best cosmetic finish will be achieved by spray and film build may not be achieved 															
Product Notes	<ul style="list-style-type: none"> For dry film thicknesses above 75µm, a mist coat followed by a wet-on-wet fuller coat is recommended to achieve film build High humidity and condensation will impair gloss if exposed during application and curing Contains isocyanates – refer to Safety Data Sheet *Colours such as yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required, relative to only one coat of a grey or red oxide, so that yellows, bright reds and oranges may not be suitable as one coat systems 														
Health & Safety	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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