124.04

DTM Bonding Primer

B66A00050 Off White

CHARACTERISTICS

DTM BONDING PRIMER is a waterborne, acrylic emulsion, adhesion-promoting bonding primer. Designed to be part of a system for coating pre-finished metal siding (such as those containing Fluorocarbon [Kynar®], Silicone Polyester, or Polyester Polymers), or other hard, slick, glossy surfaces, and previously painted surfaces.

For use over properly prepared pre-finished siding:

- Fluorocarbons (Kynar®)
- Polyester Polymers
- Silicone Polyesters
- Must be topcoated
- Outstanding application characteristics
- Suitable for use in USDA inspected facilities

Recommended for:

- Light industrial
- Pre-Finished Siding
- Manufacturing Facilities & New Construction

Finish:	0-5°@85°
Color:	Off White

Recommended Spreading Rate per coat:

Wet mils:	5.0-12.0
Dry mils:	2.2-5.3
Coverage:	133-320 sq.ft. per gallon
Theoretical Coverage:	705 sq. ft. per gallon @ 1 mil dry

Approximate spreading rates are calculated on volume solids and do not include any application loss.
Note: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 8.0 mils wet, @ 50% RH:

Drying, and recoat times are temperature, humidity, and film thickness dependent.

	@50°F	@77°F	@120°F
To touch	1 hour	40 minutes	20 minutes
To handle	6 hours	4 hours	2 hours
To recoat	8 hours	4 hours	2 hours
To cure	7 days	7 days	3 days

Tinting: **DO NOT TINT**

Extra White B66A00050

V.O.C. (less exempt solvents):
less than 50 grams per litre; 0.42 lbs. per gallon
As per 40 CFR 59.406

Volume Solids:	44 ± 2%
Weight Solids:	59 ± 2%
Weight per Gallon:	11.42 lb
Flash Point:	N.A
Vehicle Type:	Acrylic
Shelf Life:	36 months, unopened

COMPLIANCE

As of 08/11/2021, Complies with:

OTC	Yes
OTC Phase II	Yes
S.C.A.Q.M.D.	Yes
CARB	Yes
CARB SCM 2007	Yes
CARB SCM 2020	Yes
Canada	Yes
LEED® v4 & v4.1 Emissions	No
LEED® v4 & v4.1 V.O.C.	Yes
EPD-NSF® Certified	No
MIR-Manufacturer Inventory	No
MPI®	No

APPLICATION

Temperature:	
minimum	50°F / 10°C
maximum	120°F / 49°C
	air, surface, and material
	At least 5°F above dew point
Relative humidity:	85% maximum

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Reducer:	Water
Airless Spray:	
Pressure	2400 p.s.i.
Hose	1/4-3/8 inch I.D.
Tip	.017 - .019 inch
Filter	60 mesh
Conventional Spray:	
Gun	Binks 95
Fluid Nozzle	66
Air Nozzle	63 PB
Atomization Pressure	60 p.s.i.
Fluid Pressure	25 p.s.i.
Reduction:	As needed up to 12.5% by volume
Brush	Nylon-polyester
Roller Cover	3/8 inch woven

If specific application equipment is listed above, equivalent equipment may be substituted.

Apply paint at the recommended film thickness and spreading rate as indicated. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness, or porosity of the surface, skill, and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, over thinning, climatic conditions, and excessive film build.
Always check compatibility of the previously painted surface with the new coating by applying a test patch of 2-3 square feet. Allow to dry thoroughly for 1 week before checking adhesion.

Mix paint thoroughly to a uniform consistency with slow speed power agitation prior to use.

Stripe coat crevices, welds, and sharp angles to prevent early failure in these areas. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

During the early stages of drying, the coating is sensitive to rain, dew, high humidity and moisture condensation. Plan painting schedules to avoid these influences during the first 16-24 hours of curing. Product must be topcoated.

DTM Bonding Primer can be used on steel, aluminum, or galvanized. It does not provide any rust inhibitive protection. Corrosion resistant primers are recommended for best performance. Prime any bare steel within 8 hours or before flash rusting occurs.

SPECIFICATIONS

Fluorocarbon, Silicon Polyester, Polyester Polymers:

1 coat DTM Bonding Primer

1-2 coats Pro Industrial Acrylic

Or these other acceptable topcoats

Pro Industrial DTM Acrylic
Pro Industrial DTM Primer/Finish
Pro Industrial Multi-Surface Acrylic
Bond-Plex WB Acrylic
Metalatex Semi-Gloss
Sher-Cryl HPA

Previously Painted, Hard, Slick or Glossy Surfaces:

1 coat DTM Bonding Primer

1-2 coats Pro Industrial Acrylic

Or these other acceptable topcoats

Pro Industrial DTM Acrylic
Pro Industrial DTM Primer/Finish
Pro Industrial Multi-Surface Acrylic
Bond-Plex WB Acrylic
Metalatex Semi-Gloss
Sher-Cryl HPA

Always check compatibility of the previously painted surface with the new coating by applying a test patch of 2-3 square feet. Allow to dry thoroughly for 1 week before checking adhesion.

The systems listed above are representative of the product's use, other systems may be appropriate.

Other primers may be appropriate.

continued on back

DTM Bonding Primer

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (**NIOSH** approved) and proper containment and cleanup. For more information, call the National Lead Information Center at **1-800-424-LEAD** (in US) or contact your local health authority.

When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse.

Do not use hydrocarbon solvents for cleaning.

Remove all surface contamination by washing with an appropriate cleaner, rinse thoroughly and allow to dry. Existing peeled or checked paint should be scraped and sanded to a sound surface. Glossy surfaces should be sanded dull. Stains from water, smoke, ink, pencil, grease, etc. should be sealed with the appropriate primer-sealer. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Prefinished Siding Fluorocarbon, Silicon Polyester, Polyester Polymers- Remove oil, grease, dirt, oxides, and other contaminants from the surface by cleaning per SSPC-SP1 or water blasting per NACE Standard RP-01-72 (caution: excessive blasting pressure may cause warping, use caution). Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 2 - 3 square feet. Allow to dry thoroughly for 1 week before checking adhesion.

Previously Painted Surfaces - If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Always check compatibility of the previously painted surface with the new coating by applying a test patch of 2-3 square feet. Allow to dry thoroughly for 1 week before checking adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

SURFACE PREPARATION

Mildew- Prior to attempting to remove mildew, it is always recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised.

Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach-water solution.

PERFORMANCE

DTM Bonding Primer @ 3.0 mils D.F.T

(unless otherwise noted)

Density[1]:	
Result:	10.88-11.48
Flexibility:	
Method:	ASTM D522, 180° bend, 1/4” mandrel
Result:	Pass
Fineness of grind[1]:	
Method:	Hegman
Result:	5 minimum
pH[1]:	
Result	8.5-9.5
Sag Test[1]:	
Method:	ASTM D4400
Result:	14 mils minimum
Viscosity[1]:	
Method:	Krebs units
Result:	96-106 KU

[1] Standard test based on Certificate of Analysis

SAFETY PRECAUTIONS

Before using, carefully read **CAUTIONS** on label. Refer to the Safety Data Sheets (SDS) before use.

FOR PROFESSIONAL USE ONLY.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

CLEANUP INFORMATION

Clean spills, spatters, hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer’s safety recommendations when using solvents.

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