



GLOBAL  
REFINISH  
SYSTEM



AUTOMOTIVE REFINISH

# Product Information

Direct to Metal Primer Surfacer/Sealer

## UniPrime<sup>®</sup> DTM

D8040 WHITE

D8043 RED

D8041 BLACK

D8044 YELLOW

D8042 GRAY

D8045 BLUE

UniPrime<sup>®</sup> DTM is a two-pack primer surfacer/sealer for use under Global topcoat colours. It can be applied directly to sanded aluminum, galvanized steel or cold rolled steel, without a pretreatment or wash primer application. UniPrime<sup>®</sup> DTM primer surfacer/sealer is available in six stand alone bases which may be blended together to obtain a wide variety of colors. UniPrime<sup>®</sup> DTM must be activated with D8240 DTM Hardener. UniPrime<sup>®</sup> can also be reduced and sprayed as a sealer.

### Preparation of Substrate:



In all cases, wash with soap and water, then use the appropriate Global cleaner. See GLG-142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.



#### Original Paintwork and Electrodeposition Primer

**Surfacer** - Must be sanded using European P280 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 grade paper (wet). Minimum of 1 – 1.5 mils. Exposed bare metal should be prepared as described below.

**Sealer** – A minimum dry film build of 1.0 – 1.5 mils is required when spraying as a sealer.



Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using European P180 / U.S. 180 to European P280 / U.S. 240 grit paper.

**Surfacer** - Must be clean, rust-free and abraded before application. A minimum dry film build of 2.0 mils after sanding is required when spraying as a surfacer.

**Sealer** – 2 coats of UniPrime<sup>®</sup> DTM **MUST** be used over bare metal when mixed as a sealer. A Minimum film build of 2.0 mils is required over properly prepared bare metal substrates.

Polyester Body Fillers should be dry sanded using European P280 / U.S. 240 grit paper. UniPrime<sup>®</sup> DTM is only recommended over polyester body fillers as a surfacer. Do not apply UniPrime<sup>®</sup> DTM as a sealer over polyester body fillers.

Fibre Glass and SMC should be dry sanded using European P280 / U.S. 240 grit paper.

Ensure that the substrate is thoroughly cleaned and dried after preparation work.

## APPLICATION GUIDE

### Mixing Ratio:

#### Surfacer



**UniPrime® DTM**  
**D8240 Hardener**

**2 vols**  
**1 vol**

*Note: 10% acetone may be added to the RTS UniPrime® DTM to improve flow properties and extend potlife. If VOC is not a concern, 10% of the appropriate temperature range Global D-Series thinner may be added to improve flow and potlife.*

#### Sealer



**UniPrime® DTM**  
**D8240 Hardener**  
**Global D-Series Thinner**

**2 vols**  
**1 vol**  
**½ vol max**

### Thinner Selection

Retarder (Up to 25%)  
Fast Compliant  
Medium Compliant  
Compliant

### Temperature

Up to 18°C / 65°F  
18° - 25°C / 65° - 77°F  
25° - 35° C / 77° - 95°F  
Over 35°C / 95°F  
Very Warm  
Cool  
Medium  
Warm

### Thinner

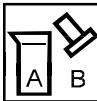
D870  
D871  
D872  
D873  
D8700  
D8764  
D8774  
D8767

### Potlife:



Surfacer 30 minutes @ 20°C / 68°F  
45 minutes @ 20°C / 68°F with 10% acetone or global thinner  
Sealer 45 minutes @ 20°C / 68°F

### Additives:



None

### Tinting:



DTM Primer Surfacer and Sealer colors may be blended together.  
**See DTM Swatch Deck – DOX431**  
DTM Primer cannot be tinted with any other product.

### Spraygun set-up:



1.4 – 1.6 mm or equivalent

### Spray pressure:

HVLP at air cap 0.7 bar / 10 PSI  
Conventional at spray gun 2.5 - 3.5 bar / 35-45 PSI

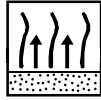
### Number of coats:



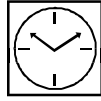
2 - 4 coats as a surfacer  
1 - 2 coats as a sealer

## APPLICATION GUIDE (Continued)

### Drying times:



Between coats @ 20°C / 68°F 5 – 10 minutes  
 Before stoving @ 20°C / 68°F 10 minutes



Dust-free  
 20°C / 68°F: Surfacers 20 minutes  
 Sealers 20 minutes



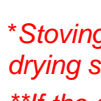
Tape  
 20°C / 68°F: Surfacers 90 minutes  
 Sealers 60 minutes



Dry to sand  
 20°C / 68°F: Surfacers 1 – 2 hours  
 Sealers 1 – 2 hours



Dry to sand  
 60°C / 140°F: Surfacers 20 – 30 minutes\*  
 Sealers 20 – 30 minutes\*



Dry to sand IR medium  
 Surfacers 10 – 20 minutes  
 Sealers 10 – 20 minutes



Dry to Topcoat (Sealer)  
 20°C / 68°F: 1Coat 30 minutes minimum\*\* 2 Coats 60 minutes minimum\*\*  
 60°C / 140°F: 15 minutes 15 minutes

\*Stoving times are for quoted metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.

\*\*If the sealer is allowed to dry more than 6 hours, it must be scuffed and reapplied before color application.

### Overcoat:



Surfacers – Overcoat with any Global sealer or topcoat.  
 Sealers – Overcoat with any Global topcoat.

### Performance Guidelines:

The use of HVLP spray equipment can increase transfer efficiency by about 10% depending on the make and model of equipment used.

### Technical Data:

#### Total dry film build

Minimum build:

Surfacers 50µm / 2.0 mils  
 Sealers 25µm / 1.0 mils

Maximum:

Surfacers 150µm / 6.0 mils  
 Sealers 75µm / 3.0 mils

Theoretical coverage RTS unreduced 21.2 m<sup>2</sup> per l / 860 sq. ft. per US gal.

Percent solids by volume RTS unreduced 53.5 m<sup>2</sup> per l / 860 sq. ft. per US gal.

### VOC:

#### Surfacers

D804X 371 gms per litre / 3.1 lbs per US gal.

D804X:D8240 (2:1) 395 gms per litre / 3.3 lbs per US gal.

D804X:D8240 (2:1) Less exempt solvents 359 gms per litre / 3.0 lbs per US gal.

D804X:D8240:Acetone (2:1:+10%) 359 gms per litre / 3.0 lbs per US gal.

Less exempt solvents

D804X:D8240:D872 (2:1:+10%) 458 gms per litre / 3.9 lbs per US gal.

#### Sealer

D804X:D8240:Compliant Thinner or Acetone (2:1:½) 359 gms per litre / 3.0 lbs per US gal.

Less exempt solvents

D804X:D8240:D872 (2:1:½) 481 gms per litre / 4.0 lbs per US gal.

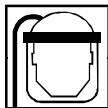
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## Health and Safety:

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### See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

-The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.



-Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.



-Follow spray equipment manufacturer's instructions to prevent personal injury or fire.

-Provide adequate ventilation for health and fire hazard control.

-Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.



-Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.

-Always observe all applicable precautions and follow good safety and hygiene practices.

### Emergency Medical or Spill Control Information (304) 843-1300; In Canada (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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# Global At A GLANCE

## Uniprime® DTM

### Direct to Metal Primer Surfacer

**Mix: MIX UniPrime® DTM**

Surfacer



**DTM Primer** : **8240 Hardener**  
2 : 1

Note: 10% acetone may be added to the RTS UniPrime® DTM. If VOC is not a concern, 10% of the appropriate temperature range Global D-Series thinner may be added.

Sealer



**DTM Primer** : **8240 Hardener** : **Global D Series Thinner**  
2 : 1 : ½

Thinner Selection	Temperature	Thinner
	Up to 18°C / 65°F	D870
	18° - 25°C / 65° - 77°F	D871
	25° - 35° C / 77° - 95°F	D872
	Over 35°C / 95°F	D873
Retarder (Up to 25%)	Very Warm	D8700
Fast Compliant	Cool	D8764
Medium Compliant	Medium	D8774
Compliant	Warm	D8767

**Pot life:**



Surfacer	30 minutes @ 20°C / 68°F 45 minutes @ 20°C / 68°F with 10% acetone or Global thinner
Sealer	45 minutes @ 20°C / 68°F

**Air Pressure:**



HVLP:	0.7 bar / 10 PSI
Conventional:	2.5 - 3.5 Bar / 35 - 45 PSI at the gun
Fluid tip:	1.4 - 1.6 mm or equivalent

**Application:**



Apply:	2 - 4 coats as a surfacer 1 - 2 coats as a sealer
Between coats:	5 - 10 minutes
Before stoving:	10 minutes

**Dry Times:**



Dust-free	Surfacer 20 minutes	Sealer 20 minutes
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Tape	Surfacer 90 minutes	Sealer 60 minutes
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Dry to sand	Surfacer 1 - 2 hours	Sealer 1 - 2 hours
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Dry to sand	Surfacer 20 - 30 minutes*	Sealer 20 - 30 minutes*
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Dry to sand IR medium	Surfacer 10 - 20 minutes	Sealer 10 - 20 minutes
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Dry to Topcoat (Sealer)	1 Coat	2 Coats
20°C / 68°F:	30 minutes minimum**	60 minutes minimum**
60°C / 140°F:	15 minutes	15 minutes

\*Stoving times are for quoted metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.

\*\*If the sealer is allowed to dry more than 6 hours, it must be scuffed and reapplied before color application.

Warning: Do not use sealer applications over polyester body filler substrates. Use surfacer applications only for these substrates.