



# METALOCK DTM HIGH BUILD PRIMER

## TECHNICAL DATA SHEET



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

DISTRIBUTED BY:  
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## 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	1/2 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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Pot life:	@ 70°F (21°C) and 50% R.H. 12 hours
Coverage at 2 mils:	325 sq.ft./gl

Please refer to [www.semproducts.com](http://www.semproducts.com) for physical properties and VOC information. 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:

#### METAL AND ALUMINUM:

Clean with **SEM Solve** or **Zero VOC Surface Cleaner**. Apply to 180 grit sanded or sandblasted metal 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 **Zero VOC Surface Cleaner**.

#### SMC AND FIBERGLASS:

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

#### Note:

When using Metalock 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 **Metalock DTM High Build Primer** and Metalock Hardener before use.

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

4 Parts	1 Part
Metalock DTM High Build Primer	Metalock Hardener

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

4 Part	1 Part	1 Part
Metalock DTM High Build Primer	Metalock Hardener	SR or SRX Reducer

**SRX Reducer** must be used to maintain VOC < 2.1 #/gl (250 g/l)

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



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**Note:**

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

**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

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, **Metallock** must be sanded with 180 grit or finer sand paper.

**CLEANUP:**

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

**STORAGE:**

**Metallock 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 **Metallock DTM High Build Primer** and Metallock Hardener is 3 years when stored under normal conditions.

**RELATED PRODUCTS:**

Part:	Product Name:	Size:
38331	Scuff & Clean	Gallon
38338	Scuff & Clean	Pint
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	Aerosol
38354	Plastic & Leather Prep	Quart
38371	SEM Solve	Gallon
38373	SEM Solve	Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
40401	Zero VOC Surface Cleaner	Gallon
40404	Zero VOC Surface Cleaner	Quart



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SR104	Fast Reducer	Quart
SR204	Medium Reducer	Quart
SR304	Slow Reducer	Quart
SRX14	Fast Exempt Reducer	Quart
SRX24	Medium Exempt Reducer	Quart
SRX34	Slow Exempt Reducer	Quart

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### Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

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Users should review the Material Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and product label are available upon request.