



## *From the Stars to your Cars*

OrionAutomotive Finishes

Technical Data Sheet

**2K DTS PRIMER FILLER \ 1350-100 (Black), 150 (Grey), 200 (White)**  
**Recommended for touch-up areas and intermediate coats only.**  
**(Was Called DTM, Change in Name Only, Same Product )**

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### Product description and purpose

2K DTS Primer is a high solids two component acrylic primer with outstanding filling properties. 2K Primer is easy to sand and is recommended for repairs where fill is needed for straightening and block sanding. 2K Primer, when topcoated directly, will provide for excellent gloss holdout and a helpful grey, black or white shade ground coat. Can be used as a Primer or Sealer.

### Quick Start Guide

Product:	<b>2K DTS Primer</b> <b>1350-100 (Black), 150 (Grey), 200 (White)</b>
Mix Ratio:	4 Parts 2K DTS Primer 1659-100, 150, or 200 1 Part Universal Primer Hardener 11-00PH
Number of layers:	2-3 Depending on Requirements
Items Needed:	2K DTS Primer and Universal Primer Hardener <u>Optional</u> - Orion Urethane Reducer 594-UR60, 70, or 80

## Acceptable Substrates

Panel surfaces to include:

Steel, Aluminum, Fiberglass, SMC, and various plastics and composites.

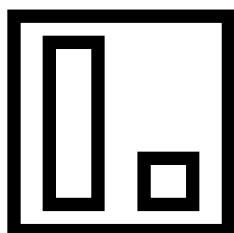
OEM Finishes, E-coated replacements, and OEM primed plastics

## Substrate Preparation

All surfaces shall be cleaned prior to performing sanding, or spraying activity.

Steel:	Sand Dry P80-P120 grit
Aluminum:	Sand with 3M 7447 Pad (or equal) or P120-P220 Dry
Fiberglass:	Sand with P120-P220 Dry
SMC:	Sand with P120-P220 Dry
OEM E-Coat:	Sand with P180-P220 Dry or P220-P320 Wet
OEM plastic:	Sand with P180-P220 Dry or P220-P320 Wet
OEM finishes:	Sand with P180-P220 Dry or P220-P320 Wet

## Mixing Ratios and Options



### **High Build**

4 Parts 2K DTS Primer 1350-100, 150, or 200  
1 Part Universal Primer Hardener 11-00PH

### **Medium Build**

4 Parts 2K DTS Primer 1350-100, 150, or 200  
1 Part Universal Primer Hardener 11-00PH  
1 Part Orion Urethane Reducer 594-UR60, 70, or 80

### **Sealer**

4 Parts 2K DTS Primer 1350-100, 150, or 200  
1 Part Universal Primer Hardener 11-00PH  
2 Parts Orion Urethane Reducer 594-UR60, 70, or 80

**Additives** Please Call for Availability Additive for flexible parts:

26-020 Flex Agent - Up to 10% to mixed amount of Primer

## **Application**

Application can be 1-3 coats depending on requirements. Allowing thorough flash time will improve cure and speed overall dry times.

Spray gun Gun Recommendations:

*Large areas*

Gravity feed Primer grade gun 1.6-1.8 Fluid tip @ 12-16 PSI inlet pressure

*Small repairs*

Topcoat grade gun 1.5-1.6 Fluid tip @ 10-14 PSI inlet pressure

## **Dry Times/Pot Life @**

(Dry/flash times dependent on layer thickness)

Flash time between coats: 5-10 Minutes

Dry to Sand: 30-40 minutes

Pot Life: 45 minutes

## **Recoating**

After dry and sanding Orion 1350 Series 2K DTS Primer can be top coated directly with itself or any Orion Brand Basecoat, or single stage product.

Recoating with 1650 Series 2K DTS Primer:

Sand with P220-P320 Wet or P180-P220 Dry

Recoating with Orion Basecoat:

Sand with P500-P800 Wet or P320-P500 Dry

## Safety and Emissions Data

Color:	Black, White, or Grey
Mixing Ratio:	4:1
Viscosity CF/4 (RTS):	16-18 Seconds
Weight Solids (RTS):	62.5%
V.O.C. (RTS):	*****
V.O.C. (as packaged)	*****
Film Build:	1-2 mil DFT (Dry Film Thickness) yield per layer
Disposal/Safety:	see SDS for this product

### **FOR INDUSTRY USE ONLY**

#### **Read SDS Before Use**

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.

The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

**SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.**

**NOTE: Orion Finishes products are not recommended for use in temperatures below 65°F. Use below these temperatures will effect dry times and performance.**