



High Performance Paint Product Data Sheet



TUFF COTE DTM PRIMER

05-600 JUN 09



DESCRIPTION: A waterborne direct-to-metal anticorrosive primer with excellent adhesion (typically to iron, steel, aluminium, zinc, copper and brass). Designed as a general industrial primer and interior topcoat for light to medium wear industrial applications. With excellent adhesion and fast set-up time, this product is an excellent replacement for solvent-borne metal primers. Adopting European WB resin technologies, TUFF COTE DTM is formulated to have fast block-resistance and low VOC level (< 50 g/L).

TYPICAL USES: With excellent adhesion and protection to various metals, TUFF COTE DTM is especially designed to protect metallic surfaces. It is used as a primer and may be used as a top coat where uv-exposure and yellowing are not critical. As a primer, it is ideal for machine components (under the bonnet parts & underbodies), concrete reinforcements, and difficult metals (brass and copper). For top coats, COTEC offers a range of products that are compatible with TUFF COTE DTM. E.g. EVO 100% ACRYLIC GLOSS, AQUATEC LP, EPOTEC HIGH BUILD EPOXY, TUFF FLOOR WB EPOXY and TUFF COTE FINISH. Please contact our representatives for further details.

PERFORMANCE: This is a premium, single-pack, self-cross linking, waterborne system. TUFF COTE DTM has two self-cross linking stages – a fast initial cure (for block-resistance) and an oxidative cure (for improving adhesion and corrosion resistance). The fast initial-cure allows TUFF COTE DTM to be handled and recoated much faster than conventional solvent-borne coatings, while making no compromises on adhesion and corrosion resistance.

LIMITATIONS: This is a waterborne product, which is expected to be applied over well-degreased surfaces. Depending on the conditions, the cure time may be extended, e.g. High humidity and low temperatures. Always mix well before use as heavy anti-corrosive pigments can settle.

TECHNICAL DATA:

Resin:	Polybutadiene dispersion
Solvent:	Water
Finish:	Flat
Colour:	Light grey/Limited Colours
Touch Dry (minimum):	60 min @ 25°C, 15 min @ 60°C
Recoat Time (minimum):	90 min @ 25°C, 20 min @ 60°C
Primer:	See over
Number of Coats:	2 usually required
Dry Film Thickness:	45 microns
Wet Film Thickness:	150 microns
Durability:	Very good
Thinning and Clean Up:	Water
VOC:	
Pot Life:	Not Applicable
Pack Size:	1, 4, 10 Litre

SPREAD RATE:

Theoretical Coverage:	Primer/Base 6-7 m ² /litre/coat.
Under the bonnet parts:	Two coats at 6-7 m ² /litre/coat.

COMPUTER CODES:

Tuff Cote DTM Primer	05-600
Tuff Cote DTM Primer Accent	05-6005

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SURFACE PREPARATION:

(Refer to "Surface Preparation and Paint Systems" for full details). To ensure a successful application all surfaces to be coated must be clean, dry and stable.

Note: Commencement of work on a surface means in general you accept that surface. If any doubt about condition etc seek advice.

TUFF COTE DTM is an excellent metal primer which offers superior adhesion and corrosion resistance to various metal surfaces. In most cases, the adhesion and block resistance develops rapidly allowing much faster handling than solvent-borne coatings. Depending on the conditions, TUFF COTE DTM reaches 70% of its final strength in 48 hours and about 7 days to reach full strength.

TUFF COTE DTM is designed to be top coated with various COTEC exterior finishes to provide excellent weather, chemical and mechanical resistance. The following is a guide for coating some general surfaces.

STEEL/IRON:

Remove all rust, grease and oil. Apply 1 coat TUFF COTE DTM. Allow at least 90 minutes drying at 25°C. For general finish, apply 2 coats of EVO 100% ACRYLIC GLOSS or AQUATEC LP. For increased mechanical and chemical protection, apply 2 coats of TUFF COTE FINISH, EPOTEC HIGH BUILD EPOXY or TUFF FLOOR WB EPOXY.

ALUMINIUM / BRONZE:

Lightly sand the surface. Apply 1 coat TUFF COTE DTM. Allow at least 90 minutes drying at 25°C. For general finish, apply 2 coats of EVO 100% ACRYLIC GLOSS or AQUATEC LP. For increased mechanical and chemical protection, apply 2 coats of TUFF COTE FINISH, EPOTEC HIGH BUILD EPOXY or TUFF FLOOR WB EPOXY.

GALVANISED IRON:

Galvanised iron sheets that are lapped must be coated in the lap areas to stop corrosion.

NEW: All new galvanised iron has an oil/grease coating from roll forming and it must be removed before coating. This can be done by leaving the roof exposed to the elements for 3 months before painting, or by using a suitable roof wash solution.

Apply 1 coat TUFF COTE DTM. After 90 minutes drying at 25°C; apply 2 coats of ACRYLIC ROOF PAINT or AQUATEC LP.

OLD: Wash all area with a suitable roof wash solution. Areas of rust must be wire-brushed, to remove loose rust etc. Apply RUST KILL to convert any remaining rust. Wash area thoroughly and allow to dry.

Apply 1 coat TUFF COTE DTM. After 90 minutes drying at 25°C; apply 2 coats of ACRYLIC ROOF PAINT or AQUATEC LP..

If roofs are being used for collection of drinking water, it is strongly recommended that roof down pipes are disconnected until after the first major rainfall event (≥10mm).

PLASTIC SURFACES:

Plastic surfaces are generally very difficult substrates. TUFF COTE DTM has better adhesion to plastic surfaces than most solvent-borne primers, acrylics and epoxies. However, it is very important that test patches are carried out ensuring the coating is fit for purpose. Different surfaces and materials should be tested on a case-by-case basis. Generally, all plastic surfaces should be lightly sanded to ensure physical adhesion.

OTHER NON-METALLIC SURFACES:

For surfaces such as concrete, wood or plastic, please use alternative water based epoxy products, such as TUFF FLOOR WB EPOXY or EPOTEC HIGH BUILD EPOXY.

APPLICATION:

Stir well before application.

Brush/Roller: Use product as supplied.

Roller: Use an 8-12mm nap dacron roller.

Spray: Airless spraying is recommended. Pressure 2,500psi max and a 209 tip for detailed work and 413 tip for general application. Add up to 2% potable water if necessary. Best performance is achieved by an initial low-build pass (tack coat), followed by a full spray of finish coat.

Force Drying: The drying conditions should be strictly controlled under 65°C for 20 minutes to prevent blisters from forming.

THINNING & CLEAN UP:

Maximum thinning is 2%. Clean up with water and detergent.

ENVIRONMENTAL:

This formulation uses the latest technology with low toxicity, ensuring environmental issues are not compromised. DO NOT POUR paint or wash down storm water or water courses. ALWAYS dispose of in accordance with local Government regulations. Soak up spills with absorbent material and dispose of properly. If spraying use suitable respiratory protection. Refer to the MATERIAL SAFETY DATA SHEET.