



VIETEK™

TEK-600

DTM Low VOC Urethane Primer Surfacer

Part #:

34-600

GENERAL DESCRIPTION:

A 2.1 lb. /gal (250 g/l) VOC compliant, 2K urethane primer surface.

MIX RATIO:

Combine the components by volume (4:1). Mix thoroughly prior to activation.

COMPONENT:

34-600 DTM Low VOC Primer Surfacer
34-670 DTM Urethane Primer Activator Low VOC

VOLUME:

4
1

POT LIFE:

1 hour at 70°F (21°C) at 50% Relative Humidity

APPLICATION:

SURFACE PREPARATION:

Clean surface thoroughly with mild detergent and water. For substrates other than plastic or fiberglass, wipe surface with wax and grease remover or locally permitted cleaner.

SPRAY PRESSURE:

HVLP: 7-9 PSI

GUN SETUP :

HVLP for primer: 1.7-1.9 mm
HVLP for sealer: 1.3-1.4 mm

APPLICATION:

Apply 2 to 3 medium wet coats to achieve desired film build. Flash 8-10 minutes between coats.

DRY TIMES:

To sand: Primer: 2-3 hours at 70°F

SANDING FOR PRIMER:

P-320 to P-400 grit for single stage topcoats
P-400 to P-600 grit for basecoats

PHYSICAL PROPERTIES:

All Values Ready To Spray

Max. VOC (LE)	244 g/L (2.0 lbs./gal)
Max. VOC (AP)	143 g/L (1.2 lbs./gal)
Avg. Gal. Wt.	1527 g/L (12.74 lbs./gal)
Avg. Wt.% Volatiles	44.7%
Avg. Wt.% Exempt Solvent	35.3%
Avg. Wt.% Water	0.0%
Avg. Vol.% Exempt Solvent	41.3%
Avg. Vol.% Water	0.0%

Recommended Dry Film Thickness: 5 mils in 3 coats

Flash Point:

See SDS/MSDS

Theoretical Coverage:

681 ft² (63.2 m²)
at 1 mil

