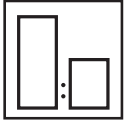


80-222/ 80-223 DTM HB PRIMER/ SURFACER/SEALER - WHITE/BLACK

APPLICATION DATA



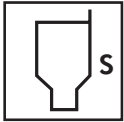
Mixing Ratio (Volume):
* Check local regulations for VOC compliance guidelines

High Build Primer

4 Parts 80-222 / 80-223 DTM HB Primer/Surfacer/Sealer - White / Black
1 Part 80-220 DTM HB Hardener
1 Part 1-1000 Thinner Zero VOC (2.1 VOC)
OR 1-141 / 1-151 / 1-161 / 1-171 (National Rule compliance)

Sealer

4 Parts 80-222 / 80-223 DTM HB Primer/Surfacer/Sealer - White / Black
1 Part 80-220 DTM HB Hardener
2 Parts 1-1000 Thinner Zero VOC (2.1 VOC)
OR 1-141 / 1-151 / 1-161 / 1-171 (National Rule compliance)



Application - Viscosity
RTS (Ready To Spray)
Viscosity @ 20°C/70°F
DIN Cup 4 mm

HB Primer

23 - 28 seconds

Sealer

13 - 18 seconds



Spray Gun HVL
Nozzle:
Air Cap:
Inlet Air Pressure

HB Primer

1.5 - 1.9 mm
1.5 - 1.9 mm
20 - 30 psi (1.4 - 2.0 bar)

Sealer

1.3 - 1.5 mm
1.3 - 1.5 mm
25 - 35 psi (1.7 - 2.4 bar)



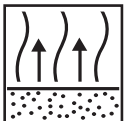
Conventional Gun
Nozzle:
Air Cap:
Inlet Air Pressure

HB Primer

1.5 - 1.9 mm
1.5 - 1.9 mm
20 - 30 psi (1.4 - 2.0 bar)

Sealer

1.3 - 1.5 mm
1.3 - 1.5 mm
25 - 35 psi (1.7 - 2.4 bar)



Flash/Bake/Air Dry Times:
Flash Time
To Sand Air Dry
To Sand Bake 155°F (68°C)
To Topcoat Air Dry
To Topcoat Without Sanding

HB Primer

10 - 15 minutes
60 - 90 minutes
10 - 15 minutes
30 minutes
24 Hrs Maximum

Sealer

10 - 20 minutes
Nib Sand 10 minutes
10 - 20 minutes
4 Hrs Maximum



Spray Coats
Film Thickness

HB Primer

1 - 3 Coats
2.2 - 3.2 mils (55-80 µm)

Sealer

1 Coat
0.8 - 1.3 mils (20-35 µm)



Potlife @ 25°C/77°F

HB Primer

20 - 30 minutes

Sealer

45 - 60 minutes

Field of application : 80-222 and 80-223 are Direct to Metal High Build Primer/Sealers for use on a number of different substrates (see below). No etching required.

Chemical basis : Epoxy-acrylic resins.

General qualities : DTM HB (4:1:1 / 4:1:2) Primer/Surfacer/Sealer 80-222 and 80-223 is a premium non-Iso 2-pack Direct to Metal primer with multiple mix ratios for filling and sealing applications.

Auxiliary materials : 80-220 DTM HB Hardener
1-1000 Thinner Zero VOC (for 2.1 VOC compliance)
1-41 / 1-151 / 1-161 / 1-171 Uni Thinners (for National Rule compliance)

Gloss : Matte

Substrates : Properly cleaned and sanded Aluminum, Steel, Galvanized Steel or sand blasted Steel. Properly cleaned and sanded fiberglass, SMC, E-Coat, OEM finish. Properly cleaned OEM E-Coat.

Physical properties

FOR USA/Canada (3.5/2.1 LBS./GAL Compliance)

| RTS REGULATORY DATA | 4:1:1 | | 4:1:1 | |
|---|----------------------|-------------|---------------------------|-------------|
| | (Uni Thinner Series) | | (1-1000 Thinner Zero VOC) | |
| | LBS./GAL. | g/L | LBS./GAL. | g/L |
| Actual VOC | 2.6 Max. | 315 Max. | 1.25 Max. | 150 Max. |
| Regulatory VOC (less water and exempt solvents) | 3.5 Max. | 420 Max. | 2.1 Max. | 250 Max. |
| Density | 10 - 12 | 1200 - 1440 | 10 - 12 | 1200 - 1440 |
| | WT. % | VOL. % | WT. % | VOL. % |
| Total Solids Content | 50 - 60 | 35 - 45 | 50 - 60 | 35 - 45 |
| Total Volatile Content | 40 - 50 | 55 - 65 | 40 - 50 | 55 - 65 |
| Water | 0 | 0 | 0 | 0 |
| Exempt Compound Content | 20 - 30 | 25 - 35 | 30 - 40 | 45 - 45 |
| Coating Category | Primer Surfacer | | | |

NOTE: US/Canadian Regulations allow for the use of exempt compounds for VOC calculations.

FOR USA/Canada (4.6/2.1 LBS./GAL Compliance)

| RTS REGULATORY DATA | 4:1:2 | | 4:1:2 | |
|---|----------------------|-------------|---------------------------|-------------|
| | (Uni Thinner Series) | | (1-1000 Thinner Zero VOC) | |
| | LBS./GAL. | g/L | LBS./GAL. | g/L |
| Actual VOC | 3.45 Max. | 415 Max. | 1.0 Max. | 125 Max. |
| Regulatory VOC (less water and exempt solvents) | 4.6 Max. | 550 Max. | 2.1 Max. | 250 Max. |
| Density | 10 - 12 | 1200 - 1440 | 10 - 12 | 1200 - 1440 |
| | WT. % | VOL. % | WT. % | VOL. % |
| Total Solids Content | 45 - 55 | 30 - 40 | 45 - 55 | 30 - 40 |
| Total Volatile Content | 45 - 55 | 60 - 70 | 45 - 55 | 60 - 70 |
| Water | 0 | 0 | 0 | 0 |
| Exempt Compound Content | 20 - 25 | 25 - 30 | 35 - 45 | 50 - 55 |
| Coating Category | Primer Sealer | | | |

NOTE: US/Canadian Regulations allow for the use of exempt compounds for VOC calculations.

FOR REST-OF-WORLD (outside US and Canada):

| RTS REGULATORY DATA | 4:1:1 | | 4:1:2 | |
|------------------------|----------------------|-------------|----------------------|-------------|
| | (Uni Thinner Series) | | (Uni Thinner Series) | |
| | LBS./GAL. | g/L | LBS./GAL. | g/L |
| VOC | 6.0 Max. | 720 Max. | 6.6 Max. | 800 Max. |
| Density | 10 - 12 | 1200 - 1440 | 10 - 12 | 1200 - 1440 |
| | WT. % | VOL. % | WT. % | VOL. % |
| Total Solids Content | 50 - 60 | 35 - 45 | 45 - 55 | 30 - 40 |
| Total Volatile Content | 40 - 50 | 55 - 65 | 45 - 55 | 60 - 70 |
| Water | 0 | 0 | 0 | 0 |
| Coating Category | Primer Surfacer | | Primer Sealer | |

Finishing Materials : All DeBeer Finishes

Cleaning the Equipment : 1-1000 (Check local regulations)

Colour : White / Black

Storage life : Under normal storage conditions 41 - 90°F (5 - 32°C) up to two years (unopened container)

The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. **UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.