



TECHNICAL DATA SHEET

B14 DTM (DIRECT TO METAL) FLAT LOW VOC POLYURETHANE

07202021



As a high performance topcoat over multiple substrates when pre primed with a suitable Hystar primer including: Hot and Cold roll steel, Galvanized Steel, Aluminum, fiberglass, plastics and wood where outstanding gloss and color retention are desired and outstanding adhesion and flexibility is required.



COMPONENTS

- B14
- R60/70/85
- H10

Topcoat
Fast/Medium/Slow National Rule Reducers
Hardener National Rule



MIXING RATIO

Mix three (3) parts base color to one (1) part hardener. Reduce up to 15%-33% with selected suitable reducer.



POT LIFE

2 hours at 68°F



CLEAN UP

Use Lacquer Thinner or zero VOC solvents. (Check local regulations)



PHYSICAL DATA

Solids wt. 48 % (+ or - 2%)
Volume wt. 44 % (+ or - 2%)

VOC

Coating: 3.5 lbs/gal - 420.0 g/l
Material: 3.5 lbs/gal - 420.0 g/l



DRY / FLASH TIMES

Dust Free: 60 minutes @ 68°F/20°C
Dry to Touch 2-4 hours @ 68°F/20°C
Total Hardness 24 hours @ 68°F/20°C
Force Dry 45 minutes @ 140°F/60°C



GUN SETUPS

HLVP Gravity Feed 1.3 mm – 1.5 mm
Pressure Pot HLVP 1.0 mm – 1.1 mm
Air Assist Airless 1.0 mm - 1.1 mm
Conventional 1.4 mm - 1.7mm
Airless Not Recommended



SURFACE PREPARATION

Use HyMax Clean Wipe (S01) to clean substrate free of grease, dirt, and foreign contaminants.

Best:

SA2 sandblast Blow all dust and contaminates off and apply B14 DTM Topcoat as directed.

Better:

Hot Phosphate wash system, blow dry and apply B14 DTM Topcoat as directed.

Good:

Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal solvent, making sure all residue is removed. Apply B14 DTM Topcoat as directed.

Aluminum: Clean surface with clean drying wax and grease remover. Apply Hystar Epoxy Primer followed by topcoat for max performance.

Galvanized Steel: Clean all dust, oil residue, and contaminates from surface using a Clean drying wax and grease remover. Light Sanding (320P grit) Clean again with clean drying wax and grease remover ensuring that all residue is removed. Apply P10 Primer followed by B14 Topcoat for Max performance.



APPLICATION AT 77° F/25°C

• Two medium wet coats, allow 10-20 minutes flash between coats. Or apply one medium coat follow by a medium cross coat.



SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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