

2.1 VOC DTM Primer
A-536 (Grey) & A-537 (Dark Grey)

Technical Support: 1-800-776-0933

Product Description Pro-Spray® A-536™ Grey and A-537™ Dark Grey 2.1 VOC DTM Primer are high build, fast drying, direct-to-metal primers ideal for use on properly prepared bare substrates, sanded OE finishes and body filler. A-536 and A-537 provide excellent adhesion to bare metal and have outstanding filling, leveling and sanding properties.

Components



- Primers** **A-536 (Grey)**
 A-537 (Dark Grey)
- Activators** **A-538**
- Thinners** OPTIONAL: **PCR-1770** or **PCR-1772**

Typical Substrates

- Cleaned and Sanded: ▪ **Steel** ▪ **Fiberglass** ▪ **Galvanized** ▪ **Aluminum** ▪ **Body Filler**
 ▪ **OE Finishes**

Surface Preparation



Clean and dry the surface. Sand surface with P180–P320 grit abrasive. Remove all sanding debris with or ICR-0014™.

Mix Ratio

- Primer** **4 Parts**
- Activator** **1 Part**
- Thinner** **OPTIONAL: Up to 1 Part**

Pot Life @ 72°F / 22.2°C



2 hours

Viscosity @ 72°F / 22.2°C

22–24 secs Zahn #2

Grey Shade Mixing Ratio

Final Grey Shade color must be activated and thinned according to the Mix Ratio above.

Code	Description	Grey Shade					
		GS-1	GS-2	GS-3	GS-4	GS-5	GS-6
		Ratio	Ratio	Ratio	Ratio	Ratio	Ratio
A-536	Grey DTM	1 Part	4 Parts	3 Parts	2 Parts	1 Part	0 Parts
A-537	Dk Grey DTM	0 Part	1 Part	1 Part	1 Part	1 Part	1 Part

Gun Set Up



- High Efficiency** **HVLP**
- 1.4 mm–1.6 mm 1.4 mm–1.6 mm

Air Pressure



- High Efficiency** **HVLP**
- 15–29 psi 6–10 psi
- @ the gun @ the cap

NOTE: Refer to individual gun manufacturer for proper spray gun setting.

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Application



2–3 medium wet coats
5–10 minutes flash between coats

NOTE: DO NOT apply A-536 or A-537 over A-614 Low VOC Etch Primer.

Dry Times to Sand @ 72°F / 22.2°C



Flash 5–10 minutes between coats
Air Dry 1 hour
Baking 15 minutes @ metal temperature of 140°F/60°C
Short Wave Refer to the infrared manufacturer's guide for set-up regulations
10 minutes. Allow to cool completely.

Sanding



Dry & D.A.: P400–P600
Water Sanding: P500–P600

Recoat

Topcoat within 24 hours after sanding. If time exceeds 24 hours, the primed surface must be sanded and cleaned again prior to application of primer or topcoat.

Topcoats

When dry and sanded, topcoat with:

- Pro-Spray 2K Sealers
- Pro-Spray Solvent Basecoat/Clearcoat
- Pro-Spray Single Stage
- Pro-Spray H2O Basecoat/Clearcoat

Special Notes / Clean Up



Clean Up Clean equipment after use with a cleaning solvent. Dispose of solvent according to state, local and federal regulations.

Physical Data

VOC (RTS) per U.S. Gal 2.1 lbs
Recommended Dry Film Thickness 2–3 mils
Total Solids by Weight (RTS) 58.1%
Coverage - Sq. Ft. /100 ml (RTS) 4.4

Health and Safety



For professional use only. KEEP OUT OF REACH OF CHILDREN. WARNING! CONTENTS ARE FLAMMABLE. VAPOR AND SPRAY MIST IS HARMFUL. SKIN AND EYE IRRITANT.

Do not handle the Pro-Spray products until the Material Safety Data Sheets have been read and understood in their entirety. Ensure that all employees are trained on Material Safety Data Sheets and all chemicals with which they come into contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist. Wear protective clothing, gloves and eye safety with a side shield.

This data sheet information is given in good faith but without warranty. The information contained herein represents the current state of our knowledge and is intended as a guide to our products and their uses; it is not intended for insurance of certain product properties or of their specific applications.

Follow all warnings on product labels.