

## IC-981-411

## 2K Multi-Use DTM Primer Surfacer

### Description

IC-981-411 is a DTM primer surfacer that features outstanding filling ability with in short period of time. It has a high build capacity, providing a thick and uniform coating. Moreover, it has excellent color holdout with no shrinkage, maintaining the color integrity and surface quality. It can be used on various substrates and is super easy to sand.

### Features

- Multifunctional, can be used as high build filler, primer surfacer, or primer sealer.
- High build capacity
- Excellent adhesion on various substrates and easy to sand
- Can be applied directly to metal

### Required Products

- IC-981-411 Primer
- IC-9788 Hardener Series
- IC-950 Reducer Series
- IC-2K200 Binder

### Compatible Surfaces

- Properly prepared gel coated fiberglass
- Properly prepared OEM finishes
- Properly prepared E-coat
- Properly prepared Steel & aluminum
- Body Fillers
- Plastic Primers
- Plastic Adhesion Promoters
- Epoxy Primers
- Self-etch Primers

### Preparation of Substrate

- Wash the area to be painted with soap and water, then clean with IC-800 degreaser.
- Sand the old finishes with 240-360 grit dry by hand or machine or 600-800 grit wet.
- Reclean with IC-800 degreaser. The use of a tack rag is recommended.



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### Mixing Ratio

	High Build		Primer Surfacer		Primer Sealer	
Product	Vol	Weight	Vol	Weight	Vol	Weight
IC-981-411	100	100	100	100	100	100
IC-9688/9788/9888	25	16	25	16	25	16
IC-940/950/960/970	10	6	25	15	50	30
IC-2K200	-	-	-	-	10	9

Note:

IC-9688/IC-940 is for temperatures between 5-15°C

IC-9788/IC-950 is for temperatures between 15-25°C

IC-9888/IC-960 is for temperatures above 25°C

IC-970 is for temperatures above 35°C or when refinishing large surfaces.

Please shake for 30 s before mixing, and mix well and strain before application.



### Pot Life

At 25°C

High Build	Primer Surfacer	Sealer
20-30 min	30-40 min	40-50 min



### Spray Viscosity

With DIN 4 cup at 25°C/77°F

High Build	Primer Surfacer	Sealer
28-32 s	18-22 s	16-20 s



### Spray Guns

	Type	Nozzle Size	Pressure	Spray Distance
High Build	HVLP Gravity-feed Spray Gun	2.0-2.5 mm	1.8-2.0 bar	15-20 cm
	Compliant Gravity-feed Spray Gun	1.7-2.0 mm	3.0-4.0 bar	20-25 cm
Primer Surfacer	HVLP Gravity-feed Spray Gun	1.6-1.8 mm	1.8-2.0 bar	15-20 cm
	Compliant Gravity-feed Spray Gun	1.5-1.7 mm	3.0-4.0 bar	20-25 cm
Primer Sealer	HVLP Gravity-feed Spray Gun	1.5-1.6 mm	1.8-2.0 bar	15-20 cm
	Compliant Gravity-feed Spray Gun	1.3-1.4 mm	3.0-4.0 bar	20-25 cm

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### Number Of Coats

High Build	Primer Surfacer	Sealer
2-3	2-3	1-2



### Film Thickness

High Build	Primer Surfacer	Sealer
60-70 µm per coat	40-50 µm per coat	20-30 µm per coat



### Drying Times

	High Build		Primer Surfacer		Primer Sealer	
	20°C	60°C	20°C	60°C	20°C	60°C
Flash off	5-10 min	-	5-10 min	-	5-10 min	-
Dry to topcoat	-	-	-	-	20 min	-
Dry to sand	2-2.5 hrs	30 min	1.5-2 hrs	30 min	-	-



### Product Specifications

Color: Grey

Shelf Life: 24 months at 25°C

Theoretical Coverage: 250-300 m<sup>2</sup>/L at 1µm thickness

	High Build	Primer Surfacer	Primer Sealer
Ready to use density	1223 g/l	1191 g/l	1301 g/l
Weight of ready to use solids	62 %	57.8 %	49.4 %



### Sanding

After fully cured, it will be necessary to sand the primer with 400-800 grit abrasives.

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### HEALTH AND SAFETY



**Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.**

- Hardeners contain isocyanate and therefore particular safety precautions must be taken.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.
- Do not smoke whilst using this material.

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