

North America

Programmed System Technique (PST)

DTM Topcoat

Topcoat
02/26/2025

U-TECH DTM Topcoat is a direct-to-metal topcoat developed for commercial vehicle manufacturers and fleet refinish markets. It is a versatile product that uses the existing U-TECH intermix tints in conjunction with one hardener and three binders to achieve various colors and gloss levels.



Safety Considerations

- Use suitable personal protection.
- AkzoNobel recommends the use of a fresh air supply respirator.
- Refer to the product Safety Data Sheet (SDS) for more complete safety information.



Suitable Surfaces

- Steel
 - Blasted to white metal
 - P80 to P120 grit dry
- Steel, Cold or Hot Rolled
 - P180 grit dry or red scuff pad
- Steel, Hot Dip Galvanized
 - P180 grit dry
- Stainless Steel
 - P220 grit dry
- Aluminum 2024 T3
 - P220 grit dry
- Aluminum 5052 H32
 - P220 grit dry
- Aluminum 7075 T6
 - P220 grit dry



Mix

5
1

By Volume

DTM Topcoat ready mix color
DTM Topcoat Hardener

- ✓ Mix well to combine components.

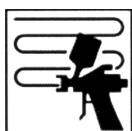


Spray-Gun Set-Up

- HVLP – 1.9mm
- Compliant – 1.8mm
- Pressure Feed – 1.4mm

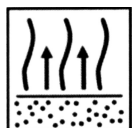
Application Settings

- HVLP – 10 psi (<0.7 bar) at cap maximum.
- Consult manufacturer specifications.
- 12oz. per minute.



Application

- Apply one (1) to two (2) single flowing coats with no flash between coats.



Flash Between Coats at 70°F (21°C)

- None required.

Flash at 70°F (21°C) Before Force Drying

- 15 minutes.



Air Drying at 70°F (21°C)

- Dry to Handle in 4-½ hours

Dependent on film weight.

Force Drying at 140°F (60°C)

- Dry to Handle in 45 minutes

DTM Topcoat

Description

U-TECH DTM Topcoat is a direct-to-metal topcoat developed for commercial vehicle manufacturers and fleet refinish markets. It is a versatile product that uses the existing U-TECH intermix tints in conjunction with one hardener and three binders to achieve various colors and gloss levels.

Suitable Substrates



- Existing finishes
- Steel
- Steel, Cold or Hot Rolled
- Steel, Hot Dip Galvanized
- Stainless Steel
- Aluminum 2024 T3
- Aluminum 5052 H32
- Aluminum 7075 T6
- Autoprep Pretreatment Wipes
- Henkel Bonderite 1000 Pretreatment
- Henkel 457 followed by 5700
- With AkzoNobel approval*
- Blasted to white metal
- P80 to P120 grit dry
- P180 grit dry or red scuff pad
- P180 grit dry
- P220 grit dry
- P220 grit dry
- P220 grit dry

NOTE: *Any other chemical cleaners, pretreatments, and/or existing finishes must be pre-approved by AkzoNobel.

Products and Additives

- | | | |
|----------------|---|--|
| Product | <ul style="list-style-type: none"> • U-TECH Toners • DTM Topcoat Low Gloss Binder • DTM Topcoat Medium Gloss Binder • DTM Topcoat High Gloss Binder | <ul style="list-style-type: none"> – Mixed to prescribed color formula – Item # 584569 – Item # 584571 – Item # 585022 |
|----------------|---|--|

- | | | |
|------------------|--|---|
| Hardeners | <ul style="list-style-type: none"> • DTM Topcoat Hardener | <ul style="list-style-type: none"> – Item # 604923 |
|------------------|--|---|

- | | | |
|------------------|--|---|
| Additives | <ul style="list-style-type: none"> • DTM Topcoat Air Dry Additive | <ul style="list-style-type: none"> – Item # 579621 |
|------------------|--|---|

Basic Raw Materials



- | | |
|---|--|
| <ul style="list-style-type: none"> • U-TECH Toners • DTM Topcoat Binders • DTM Topcoat Hardener • DTM Topcoat Airdry Additive | <ul style="list-style-type: none"> – Acrylic/polyester resins and pigments – Acrylic/polyester resins – Polyisocyanate resin – Acrylic resin/reactive solvent and catalyst |
|---|--|

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Substrate Preparation



Pre-Cleaning

- Clean with R859 Wax & Grease Remover, Autoprep UltraPrep (VOC compliant) surface cleaner or equivalent.



Sanding & Surface Preparation

Substrate	Preparation	Additional Notes
Existing Finishes	Consult AkzoNobel.*	AkzoNobel approval required.*
Steel	Blasted to clean white appearance.	
Cold Rolled Steel	#P80 – P120 Dry	
Hot Rolled Steel	#P80 – P120 Dry	Mil scale removed.
Hot Dip-Galvanized Steel	#P180 Dry or a red scuff pad	
Aluminum	#P220 Dry	
AutoPrep Pre-Treatment	Per AutoPrep Pre-Treatment TDS.	
Henkel Bonderite 1000 Pre-Treatment	Per Henkel Process.	Per Henkel Process.
Henkel Deoxidine 457 followed by Henkel Alodine 5700	Per Henkel Process.	Per Henkel Process.

NOTE: *Any other chemical cleaners, pretreatments, and/or existing finishes must be pre-approved by AkzoNobel.



Final Cleaning, Sanded Surfaces – Prior to Paint Application

- Clean with R859 Wax & Grease Remover, Autoprep UltraPrep (VOC compliant) surface cleaner or equivalent.

Product Preparation



Agitation

- Because DTM Topcoat is high solids paint it needs to be agitated before use.
- Stir or shake vigorously before each use.

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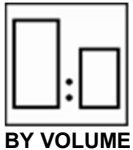
Mixing – Formulas



- DTM Topcoat is available in 90, 70, 50 and 30 gloss unit formulas.
- These can be accessed in MIXIT or the Color Manager mixing program.

Note: Due to color, application and environmental factors, gloss levels may vary by 10 gloss units.

Mixing – By Volume



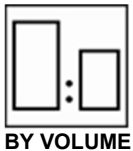
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|------------|-----------------------------------|
| Mix | Normal Temperatures |
| 5 | Parts DTM Topcoat ready mix color |
| 1 | Parts DTM Topcoat Hardener |
| | ✓ Mix well to combine components. |

- There is an air-dry additive available for DTM Topcoat. It is designed for use in cooler temperatures to promote curing.



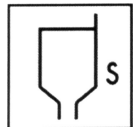
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|--------------|------------------------------------|
| Mix | Air Dry Mixture |
| 100 | Part DTM Topcoat ready mix color |
| 2.5-5 | Parts DTM Topcoat Air Dry Additive |
| | ✓ Mix well to combine components. |

Then harden the mixture as follows –



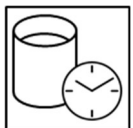
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|----------|--|
| 5 | Parts DTM Topcoat ready mix color + DTM Topcoat Air Dry Additive |
| 1 | Parts DTM Topcoat Hardener |
| | ✓ Mix well to combine components. |

Viscosity – Ready to Spray



- | | |
|------------|---|
| N/A | • DTM Topcoat has a thixotropic nature and cannot be measured by viscosity cup. |
|------------|---|

Pot-Life When Mixed



- | | |
|---|--------------------|
| Product Mix | 70°F (21°C) |
| • DTM Topcoat mixed and ready to spray | – 1 to 1.25 hours |
| • DTM Topcoat including Air Dry Additive and ready to spray | – 30 to 45 minutes |

DTM Topcoat

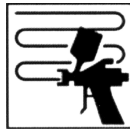
Spray Gun Set-Up

Consult spray gun instructions for specific spray gun pressure specifications.



Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Feed	1.9mm	<10 psi (<0.7 bar) at cap.
Compliant Gravity Feed	1.8mm	psi per spray gun manufacturer.
Pressure Feed	1.4mm	12oz. per minute - psi per spray gun manufacturer.
Graco Air Assisted Airless	4.11 – 4.15 5.11 – 5.15	Material pressure 1160-1958 psi (80-135 bar). Atomizing pressure 22-51 psi (1.5-3.5 bar).

Application



- Apply one (1) to two (2) single flowing coats.

Flash Drying at 70°F (21°C)



Between Coats:

- No flash between coats required.

Before Force Drying:

- 15 minutes.

Drying / Curing Time



Temperature	59°F (15°C) (w/ Air Dry Additive)	70°F (21°C)	104°F (40°C)	140°F (60°C)
• Dust Free	1-½ hours	2-½ hours	1-¼ hours	30 minutes
• Dry to Handle	1-¾ hours	4-½ hours	1-½ hours	45 minutes

- ✓ Drying times are stated at recommended application method, film thickness and object temperature.

Film Thickness – Using Suitable Application



- 1-2 Coats will achieve a thickness of 3.0 – 5.5mils (70 - 140μm).
- The minimum total thickness required is 3.0mils (70μm) for adequate protection and appearance.

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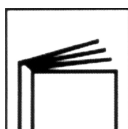
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Theoretical Coverage



- Ready for use mixture at 1mil dry film thickness with the recommended application the theoretical material usage is ±802 feet²/gallon (19.7m²/liter).
- Actual coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique and other application variables.

Recoating



- DTM Topcoat may be recoated with itself after a 30-minute flash (at 70°F (21°C)) and up to 24 hours. After 24 hours it must be sanded before reapplication.
- At the time of publication other paint materials suitable over DTM Topcoat have not been determined.

Cleaning of Equipment



- Clean equipment following local and federal regulations. In compliant localities, use a VOC compliant high-quality solvent borne gun cleaner. For national rule regions, use a high-quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

VOC / Regulatory Information



Product	VOC Pounds per Gallon	VOC Grams per Liter
• DTM Topcoat (ready to spray)	<3.50	<420

Product Storage



- Store product unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. The optimum storage temperature is approximately 70°F (21°C).
- Refer to the Product Shelf-Life Overview TDS or the current price list for the most up-to-date shelf-life information.

DTM Topcoat

AkzoNobel Inc, North America

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Telephone: 800.618.1010

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Safety Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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