North America

Programmed System Technique (PST)
Topcoat
02/26/2025

DTM Topcoat

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

Mix	By Volume
5	DTM Topcoat ready mix color
1	DTM Topcoat Hardener

✓ Mix well to combine components.

Spray-Gun Set-Up

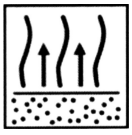
- HVLP – 1.9mm
- Compliant – 1.8mm
- Pressure Feed – 1.4mm

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

Read complete TDS for detailed product information.

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

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

Products and Additives

Product	• U-TECH Toners	– Mixed to prescribed color formula
	• DTM Topcoat Low Gloss Binder	– Item # 584569
	• DTM Topcoat Medium Gloss Binder	– Item # 584571
	• DTM Topcoat High Gloss Binder	– Item # 585022
Hardeners	• DTM Topcoat Hardener	– Item # 604923
Additives	• DTM Topcoat Air Dry Additive	– Item # 579621

Basic Raw Materials

• U-TECH Toners	– Acrylic/polyester resins and pigments
• DTM Topcoat Binders	– Acrylic/polyester resins
• DTM Topcoat Hardener	– Polyisocyanate resin
• DTM Topcoat Airdry Additive	– Acrylic resin/reactive solvent and catalyst

DTM Topcoat

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.

DTM Topcoat

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

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.

Mix	Air Dry Mixture
100	Part DTM Topcoat ready mix color
2.5-5	Parts DTM Topcoat Air Dry Additive

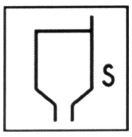
✓ Mix well to combine components.

Then harden the mixture as follows –

5	Parts DTM Topcoat ready mix color + DTM Topcoat Air Dry Additive
1	Parts DTM Topcoat Hardener

✓ Mix well to combine components.

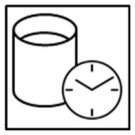
Viscosity – Ready to Spray



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	59ºF (15ºC) (w/ Air Dry Additive)	70ºF (21ºC)	104ºF (40ºC)	140ºF (60ºC)
• 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

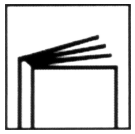
- 1-2 Coats will achieve a thickness of 3.0 – 5.5mils (70 - 140µm).
- The minimum total thickness required is 3.0mils (70µm) for adequate protection and appearance.

DTM Topcoat

Theoretical Coverage

- Ready for use mixture at 1mil dry film thickness with the recommended application the theoretical material usage is ±802 feet^2/gallon (19.7m^2/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

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