

### DTM Express

Endura DTM Express Polyurethane is a two-component, Low VOC, coating that can be used in both a direct to metal application or over a primer coat. It provides excellent gloss, hardness, adhesion and flexibility over a wide range of surfaces.

#### Product Features

- ◆ Excellent gloss and color retention
- ◆ Cures quickly to improve shop productivity
- ◆ Low temperature application - Down to 35°F (2°C)
- ◆ High-film build in one coat

#### Theoretical Solids Content:

Volume: 61.5% ± 3.5%  
Depending on color

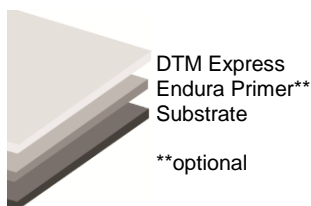
#### Shelf Life\*

Component A: (3) years  
Component B: (1) year

\*For unopened product.

#### Pot Life of Mixed Product:

40-90 Minutes @ 77°F (25°C) and 50% RH



#### Suitability

Endura DTM Express Polyurethane is a high performance coating for direct-to metal applications or for application as a topcoat over primer. It provides maximum protection in all environments.



#### Surface Preparation

DTM Express can be directly applied to all surfaces that have been sand blasted (with minimum SSPC SP-6) or scuff sanded with 240-280 grit sandpaper and prepared with appropriate Endura products.



#### Mixing Ratio

2 parts by volume of part A  
1 part by volume of part B

The recommended temperature when mixed is 20-25°C (68-77°F).

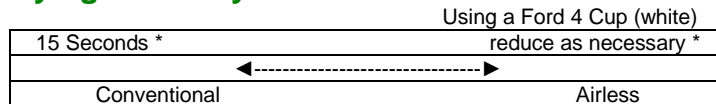
#### Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C\* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) or more above the dew point at all times.

\*for use outside this range please contact your Endura representative.



#### Spraying Viscosity\*



\* Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish.



#### Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures ( heel of gun )	Fluid Delivery
Siphon Feed	1.6-2.0 mm	40-50 psi	
Gravity Feed	1.3-1.4 mm	30-40 psi	
Pressure Feed	1.0-1.4 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-13 Thou	1,700-3000 psi	

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#### Recommended Film Build Thickness and Cover Rate

Endura DTM Express Polyurethane coating has a recommended film build thickness of:

As a direct to metal

Wet (unreduced): 8.0 – 10.0 mils wet (200 – 350 microns)

**Dry: 5.0 – 6.0 mils dry (125-150 microns)**

As a top coat over primer

Wet (unreduced): 3.5 – 5.0 mils wet (87.5 – 125 microns)

**Dry: 2.0 – 3.0 mils dry (50 – 75 microns)**

Theoretical coverage at 1.0 mil (25 microns) DFT: 984 ft² per gallon @ 100% transfer efficiency.



#### Drying Time\*

After 72 hours sand with 400-600 grit sand paper to achieve inter-coat adhesion,

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Dust Free	2 Hours	1 Hours	30 Minutes
Full Cure	7-9 Days	5-6 Days	3-4 Days

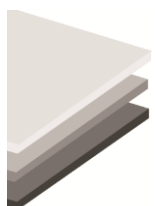
\* Subject to ambient conditions (temperature and humidity) film build and good airflow. For improved scheduling please contact your Endura representative.

#### Specifications

Hardness	ASTM D3363	H-2H
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	50mg loss
QUV-A 1000 hrs	ASTM D4587	90% gloss retention
Impact resistance	ASTM D2794	100 in. lbs/
Flexibility	ASTM D522	1/8" mandrel bend; NO failure
Gloss	ASTM D523	90+

#### Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.



DTM Express  
Endura Primer\*\*  
Substrate

\*\*optional

