

Autocoat BT LV 151 DTM

FOR PROFESSIONAL USE ONLY

Description

Two pack VOC compliant Direct To Metal topcoat finish for commercial vehicles and industrial equipment. The product is designed for plural component systems and airless application. The target use for this product is refinishing and refurbish of existing vehicles and the painting of newly build commercial vehicles and trailers.



100 LV 151 DTM
20 LV 151 Hardener



48



Air Assisted Airmix:	Fluid tip:	80 – 135 Bar material pressure
	4.11 – 4.15	1.5 – 3.5 Bar atomization pressure
Pressure feed	5.11 – 5.15	
	1.1 mm	4 – 4.5 Bar atomization pressure
		300 – 350 ml paint flow



1-2 x 1 coat



Drying times:

4.5 hours at 20°C

45 minutes at 60°C



Use suitable respiratory protection

Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Product and Additives:

Autocoat BT toners:	8099-702
LV 151 Convertor LG:	1507-001
LV 151 Convertor MG:	1507-002
LV 151 DTM RM:	1507-003
LV 151 Hardener:	1507-104
LV 151 DTM Air Dry Additive:	1519-503

Basic Raw Materials:

LV 151 DTM	Acrylic/polyester resins
LV 151 Hardener	Poly-isocyanate resin
LV 151 DTM Air Dry Additive	Acrylic resin / reactive diluant and catalyst

Suitable Substrates:

- Steel (Blasted)
 - Steel (Sanded)
 - Galvanized (hot dipped)
 - Aluminum, except grade 6061
 - Stainless steel
 - LV 251 Primer UHS
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Surface Preparation:

- Steel: Blast clean, Sa 2.5 according ISO12944-4 *or*
Clean with BT 800 Degreaser or LV 350 Antistatic Silicon Remover and dry sand with P120 grit
 - Galvanized: Clean with BT 800 Degreaser or LV 350 Antistatic Silicon Remover and dry sand with P120 grit
 - “hard” aluminum: Clean with OTO Quick Degreaser or 800 Degreaser and dry sand with P120 and P240 grit.
 - “soft” aluminum: Clean with OTO Quick Degreaser or 800 Degreaser and dry sand with P240 and P360/P400 grit.
 - Stainless Steel: Clean with BT 800 Degreaser or LV 350 Antistatic Silicon Remover and dry sand with P120 grit
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Mixing Ratio by Volume:

Standard system

100 parts of LV 151 DTM
20 parts of LV 151 Hardener

Mixing stick 48

Low Temperature system

100 parts of LV 151 DTM
5 parts of LV 151 DTM Air Dry Additive
20 parts of LV 151 Hardener

Mixing stick 48

Spraying Viscosity:

Thixotropic.

Potlife:

Standard system: 60 – 75 min at 20°C.
Low Temperature system: 30 – 45 min at 20°C.

Spray gun fluid tip and working pressure:

Spray Equipment:	Air Assisted Airmix	Airless
Fluid tip:	4.11 – 4.15 / 5.11 – 5.15	0.013"
Working pressure:	80 – 135 bar material pressure	120-180 bar
Air assistance:	1.5-3.5 bar atomization pressure	

Spray Equipment:	Pressure pot
Fluid tip:	1.1 mm
Working pressure:	0.8 - 1 bar
Atomization Air:	4 – 4.5 bar (<i>depending on length hose</i>)
Paintflow:	300 – 350 ml/min

Spray Equipment:	Gravity feed
Fluid tip:	1.8-1.9 mm
Working pressure:	0.7 - 2 bar

* For detailed information check spray gun supplier specification

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Application Process:

Apply 1 to 2 single flowing coats with no flash between coats

Film Thickness:

70 µm per coat

Theoretical coverage:

Ready for use mixture at 1 µm dry film thickness

m²/liter

± 500

Note: The practical cover rate depends on many factors e.g. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of Equipment:

Use Sikkens Solvent.

Drying times:

	15°C	20°C	40°C	60°C
Dust free		2.5 hrs	75 min	30 min
Dry to handle		4.5 hrs	90 min	45 min

Recoatable with:

Autocoat BT LV 151 DTM
Autocoat BT LV 853 Clear

Minimum recoat time 30 minutes at 20°C
Maximum recoat time 24 hours at 20°C

When these drying times are exceeded, sanding is required

VOC:

2004/42/IIIB(d)(420)420

The EU VOC limit value for this product (product category: IIB.D) in ready to use form is max 420 g/liter. The VOC content of this product in ready to use form is max 420 g/liter.

Packaging:

Autocoat BT toner:	gallon pail
LV 151 Convertor LG:	gallon pail
LV 151 Convertor MG:	gallon pail
BT LV 151 DTM RM:	10 liter in 10-litre pail
BT LV 151 Hardener:	5 liter in 5-litre pail
BT LV 151 DTM Air Dry Additive:	1 litre

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Product Storage:

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuations.

Minimum storage temperature: 5°C
Maximum storage temperature: 35°C

Shelflife:

Autocoat BT Toners	3 years
LV 151 DTM Convertor	1 year
LV 151 DTM ready mixed	1 year
LV 151 Hardener	1 year
LV 151 Air Dry Additive	1 year

HEALTH & SAFETY DATA regarding Autocoat BT LV 151 DTM 1507-003

For professional use only. (See **Material Safety Data Sheet**).

See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.

Akzo Nobel Coatings LTD

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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 Material 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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