



TECHNICAL SERVICE BULLETIN

Applying DP31 to Unsanded E-Coat Finishes

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To help meet the growing needs of today's highly competitive production facilities, R-M DP31 Power Fill 2K Sealer Gray may be applied as a wet-on-wet sealer over unsanded e-coat. Observing the following steps will result in the quality finish from R-M. As always, please check local regulations to ensure the products referenced are VOC-compliant.

APPLICATION PROCEDURE:

1. By means of a solvent test (a rag soaked with R-M UR50 Reducer works well), ensure the pre-primed part is not solvent sensitive. If the factory-applied primer is softened, you must remove the factory applied primer. If primer is not softened, continue to step 2.
2. Thoroughly clean part with R-M 900 Pre-Kleano to remove any oil or grease contamination that may be present.
3. Apply 1 medium wet coat of R-M DP31 mixed as recommended. Refer to the DP31 technical data sheet for details.
4. Flash off for 15 to 20 minutes.
5. Apply R-M Diamont basecoat, according to recommended procedures.
6. Apply your preferred R-M clearcoat, according to its technical recommendations.

Refer to the R-M Technical Manual for more detailed information on DP31, Diamont or the choices of R-M clearcoats.

At BASF, The Chemical Company, our goal is to help you make *your* business better. If you have questions on this or any other R-M product or procedure, you may contact the BASF Technical Service Department at (800) 758-BASF (2273), or visit our website at www.basfrefinish.com.