

GENERAL INFORMATION

P544A Ultra System Prime DTM Speed Elite - Gray is a high-solid polyurethane surfacer that cures at room temperature, providing strong adhesion and effective corrosion protection. Ideal for both small and large repair jobs, this surfacer can be used on multiple automotive substrates and is applied directly to degreased and well-sanded steel and aluminium.

MIXING RATIO



5 : 1 Surfacers : AC44 Ultra System Activator Speed Elite + 25% Uni Thinner

COMPONENTS



AC44 Ultra System Activator Speed Elite
R24 Ultra System Reduce Short
R25 Ultra System Reduce Medium
R26 Ultra System Reduce Long
R27 Ultra System Reduce Extra Long
R28 Ultra System Reduce Extremely Long

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4 - 1,6	1,8 - 2,2 / 26 - 32
HE	1,4 - 1,6	1,8 - 2,0 / 26 - 29

ADDITIVES



APPLICATION



2 - 3 coats, 80 - 150 µm

No flash off or 1 minute flash off between coats.

POT LIFE AT 20°C (68°F)



15 - 20 minutes

FLASH-OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	LOW BAKE 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	0 - 1 minute	0 - 1 minute	0 - 1 minute
Flash off before bake	-	5 minutes	5 minutes
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	30 - 60 minutes	25 - 30 minutes	10 minutes
Dry to polish	-	-	-

Drying times based on 2 coat application, times may increase depending on layer thickness and conditions. Please refer to the next page for additional drying times and thinner selection guidance.

SUBSTRATES



P544A Ultra System Prime DTM Speed Elite - Gray could be applied directly on degreased and well sanded/scuffed metal/steel, aluminium, old OEM system and body filler. Degreased e-coat - light-sanding is recommended.

SUBSTRATES PLASTIC



Substrate	P544A
ABS	Spray the P580 Ultra System Prime Plastic Adhesion
PP/EPDM	Spray the P580 Ultra System Prime Plastic Adhesion

SURFACE PREPARATION



Preclean the surface with CL790 Ultra System Clean Surface Solvent. Wipe on and wipe dry. Sand surface with P180 - P240 grit abrasive. Remove all sanding debris with compressed air. Sanding vacuum and clean with CL790 Ultra System Clean Surface Solvent. Wipe on and wipe dry. Final sanding with P400 and P500 before application of Basecoat.



Mask entire vehicle to eliminate unwanted overspray.

INFRARED DRYING



	Maximum 3 coats	Half-bake	Full-bake
Flash time	5 minutes	3 minutes	4 minutes

Follow the IR equipment recommendations for optimal distance between object and IR-lamps.

NEXT LAYER



U9001 - U9999 Ultra 9K
Ultra TC1

PHYSICAL DATA

EU REGULATIONS P544A Ultra System Prime DTM Speed Elite - Gray		
VOC Code	2004/42/11B(c)(540)510	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	11B/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l (2007). This product contains a maximum of 510 g/l VOC.	
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS) (sec)	19 - 21 Dincup 4 / 20°C
	Density (kg/l)	1,41
	Flash Point Closed Cup	10°C / 50°F
	Volume % Solids	42
	Economy	7 m ²
	Gloss	Egg Gloss
	Colour	Grey

PROTECTION



Use suitable respiratory protection (*we recommend the use of a fresh air supply respirator*).

For more detailed information please visit the following link for the Safety Data Sheet:

SDS Ultra System

CLEANUP



CL780 Ultra System Clean Gun Solvent

STORAGE / SHELF LIFE



Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES



All reported product properties on the TDS are determined at a temperature of 20°C / 68°F unless specified otherwise.



Additional drying information

Repair size	Air Dry	Air Dry	Air Dry	Air Dry	Air Dry	Air Dry	Low bake	Force dry	IR Dry
Application temperature	< 20°C	20 - 23°C	23 - 26°C	27 - 29°C	30 - 34°C	> 35°C	40°C	60°C	60°C
Spot repair	R24	R24	R24	R25	R26	R26	R26	R27	R27
1 panel	R24	R24	R25	R25	R26	R27	R27	R27	R27
Multi panels	R24	R25	R25	R26	R27	R28	R27	R27	R27