

**DTM Primer-Sealer**

**AP-7541**

**(Includes Variants: Ap-7541b, AP-7541g , & AP-7541w)**

**GENERAL INFORMATION**

Alpha Automotive Paint's DTM Primer/Sealer AP-7541 is a multi-purpose direct-to-metal primer that functions as both a high-build primer and a wet-on-wet sealer. Its exceptional build, fast drying time, and smooth self-leveling properties create the perfect foundation for any topcoat.

**SUBSTRATES**

It can be applied over properly prepared and cleaned surfaces, including bare steel, galvanized steel, aluminum, OEM finishes, E-coat, body fillers, plastic adhesion promoters, and epoxy primers.



**MIXING RATIO**

**4:1:1 PRIMER**

100% by vol. AP-7541  
25% by vol. AH-7100  
25% by vol. Urethane Reducer

**4:1:2 SEALER**

100% by vol. AP-7541  
25% by vol. AH-7100  
50% by vol. Urethane Reducer

**PART #**

**AP-7541**

AH- 7603(fast),  
7605(media), 7607(slow)

AR-3060 (fast), 3070  
(medium), 3080 (slow),  
3090 (extra slow)



**AIR PRESSURE AND  
SPRAY GUN SETUP**

	AIR PRESSURE	PRIMER FILLER	SEALER
HVLP	21-29 psi (1.4-2.0 bar)	1.7 - 2.0mm	1.3-1.4mm
CONVENTIONAL	45-60 psi (3-4 bar)	1.7 - 2.0mm	1.3-1.4mm

**NOTE** Refer to the spray gun manufacturer's recommendations for the best overall result.



**APPLICATION**

**High Build: 2-3 Full Coats**  
**Sealer: 1-2 Medium Wet Coats**

**Coat Thickness: 4.7 - 5.5 mil (120 - 140 μm)**  
**Coat Thickness: 2.5 - 4 mil (60- 100 μm)**



**DRYING TIMES**

**Between Coats: 5 - 15 minutes**  
**at 70°F (21°C) or until matte.**

At 68°F (20°C)	Primer Filler	Sealer
To Sand:	2-3 hours	30 min (nib-sand)
To Topcoat:	3 hours	15-20 min (wet-on-wet)*

*\*after 3 hours, please sand and re-apply sealer or basecoat.*

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**SELECTION GUIDE CHARTS**

**HARDENERS**

PART NUMBER	DESCRIPTION	55°F-70°F (12°C-21°C)	70°F-85°F (21°C-30°C)	+ 85°F (+30°C)
AH-7107	Slow	-----	-----	█
AH-7105	Medium	-----	█	
AH-7103	Fast	-----	█	

**REDUCERS**

PART NUMBER	DESCRIPTION	55°F-70°F (12°C-21°C)	70°F-85°F (21°C-30°C)	+ 85°F (+30°C)
AR-3080	Slow	-----	-----	█
AR-3070	Medium	-----	█	█



**SURFACE PREPARATION**

- Prepare the surface by cleaning it with a wax and grease remover. For aluminum or galvanized steel, we highly recommend applying AP-5511 Epoxy Primer before spraying AP-7541 Primer-Sealer.
- If using AP-7541 as a primer-filler, sand the surface with P180-P280 grit.
- If applying AP-7541 as a wet-on-wet sealer, sand with P320-P400 grit.
- After sanding, clean the surface again with a wax and grease remover or an anti-static cleaner before applying the topcoat.



**PACKAGING & SHELF LIFE**

**Sizes:** 3.5L  
**Shelf Life:** 4 years under normal storage conditions.



**SANDING**

**P400-800** Wet  
**P320-800** Dry by hand or D.A sander

**NOTES**

- Seal the hardener container immediately after each use.
- Avoid spraying at temperatures below **55°F** ; if necessary, apply in a controlled spray booth environment with heat.

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**TECHNICAL DATA**

VOLUME RATIO	4:1:1	4:1:2
SPECIFIC GRAVITY	1.67 KG/L	
FLASH POINT	71°F (22°C)	
SOLIDS VOL. %	75%	
SOLIDS WT. %	NA	
COVERAGE: Viscosity DINCUP	8 m <sup>2</sup> /L (per layer 60 µm)	
VISCOSITY (RTS)	20-22 sec. Cup DIN 4	
GLOSS	MATTE	
COLOR	BLACK, WHITE, GREY	
AS PACKED - V.O.C. REGULATORY (less water, less exempts)	335 g/l, (2.8 lbs/gal)	
AS PACKED - V.O.C. ACTUAL	280 g/l, (2.3 lbs/gal)	
V.O.C. REGULATORY RTS (less water, less exempts)	385 g/l, (3.2 lbs/gal) 261 g/l	413 g/l, (3.4 lbs/gal) 256 g/l
V.O.C. ACTUAL RTS	2.2 lbs/gal	2.1 lbs/gal
APPLICABLE USE CATEGORY	Primer Surfacer	Primer Sealer