

SpecAqua 1K DTM HB Satin × 2 coats

IPC-DTM-CC-2L-02-SS · OEM — Waterborne 1K Direct-to-Metal High-Corrosivity System

 2 COATS SYSTEM BUILD · NUMBER OF COATS	 C5 ISO 12944-2:2017 ENVIRONMENT	 160 µm TOTAL SYSTEM DFT	 HIGH TDS-RATED · C5 'LONG'	 DTM SURFACE PREPARATION GRADE
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DESCRIPTION

A single-component waterborne direct-to-metal system applied in two coats. Latest-generation compact polymer matrix binder with metal-free organic corrosion inhibition creates a flexible, super-hydrophobic film delivering C5-level corrosion resistance at a fraction of the film build of conventional epoxy/polyurethane systems.

SpecAqua 1K DTM HB Satin — One component, high build, satin finish, water based hydrophobic DTM primer/finish. TDS-rated corrosion class C5 — very high protection; extremely UV stable and weather resistant. Eco-friendly, metal-free, low VOC.

SYSTEM BREAKDOWN

SYSTEM BUILD — LAYER · VOLUME SOLIDS · DFT · THEORETICAL YIELD					
Layer	Product	Vol. Solids	DFT	Theoretical Yield ¹	Comments
1st coat	SpecAqua 1K DTM HB Satin	50%	80 µm	6.25 m ² /L @ 80 µm	Single coat alone rates C4 – Long (TDS)
2nd coat	SpecAqua 1K DTM HB Satin	50%	80 µm	6.25 m ² /L @ 80 µm	Recoat with waterborne after 4 h @ 25 °C
TOTAL	Total system dry film thickness		160 µm		

¹ Theoretical yield = Volume Solids × 10 ÷ DFT (µm), per product TDS — allow for application loss factors.

SURFACE PREPARATION

Mild steel: degrease with Hydrosolve, rinse; remove loose rust by coarse sanding / mechanical grinding or Rust Remover Gel; prime the same day. Galvanized steel: clean with Galvanized Iron Cleaner to a water-break-free surface, rinse, prime same day. Old paint: wire brush, degrease, abrade rust spots to clean metal and patch prime.

OVERCOATING INTERVALS

DRYING & OVERCOATING — SUBSTRATE TEMPERATURE AS STATED			
Product	Minimum	Maximum	If window exceeded / notes
SpecAqua 1K DTM HB Satin (each coat)	4 h @ 25 °C (waterborne over waterborne)	—	Recoat with solvent-borne systems only after 24 h @ 60 µm

Overcoating information is a guide only and is subject to climate and site conditions — the product TDS governs.

INTENDED USES & BENEFITS

- Mild steel, stainless, galvanized, zinc-plated and zinc-phosphated steel
- One-coat-system economics — fewer working hours, lower film weight
- Excellent coverage of nuts, bolts and welds; crack and peel resistant
- Topcoatable with SpecAqua 2K PUD where enhanced mechanical/chemical resistance is needed

ISO 12944 CLASSIFICATION & EXPECTED DURABILITY

Environment classification	C5 (very high) at 2 × 80 µm; C4 at 1 × 80 µm (ISO 12944-2:2017)
Expected durability	High — TDS-rated 'Long' durability (legacy C5-I notation, SANS/ISO 1998 ed.)

Corrosion class and durability are TDS-rated for this product (C4 Long @ 80 µm; C5-I Long @ 160 µm — legacy 1998 notation, unified to C5 in ISO 12944-2:2017).

NOTE: All products shall be applied according to the instructions and within the application parameters given on the Speccoats™ Technical Data Sheet (TDS) for each product — the TDS governs in any conflict. Expected durability = time to first major maintenance (ISO 12944-1:2017), not a guarantee.