



Refinish

DuPont™ Variprime® 615S™/625S™ Self-Etching Primer

Description

Variprime® is a fast-drying, two-component, self-etching primer. It provides excellent corrosion resistance and direct-to-metal adhesion for spot, panel and overall repairs.

General Information



Components

- Variprime® 615S™
- Variprime® 625S™ Lead and Chromate Free
- Variprime® 616S™ - Converter
- Variprime® 620S™ - Fast Converter
- Variprime® 614S™ - Slow Converter

Tips for Success

Keep cans closed when not in use to prevent moisture absorption, which may lead to blistering, loss of adhesion or other product failure.

Mix Ratio/Viscosity

Combine the components either by volume or weight and then mix thoroughly.

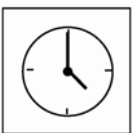
	Volume	Weight (cumulative qt)
Variprime® 615S™/625S™ Primer	1	553 grams
Variprime® 616S™/620S™/614S™ Converter	1	941 grams (sprayable qt)

Viscosity

17 - 19 seconds in a Zahn #2 (DuPont M-222) cup.

Pot Life

72 hours.



Additives

- Accelerator: Not recommended.
- Fish Eye Eliminator: Not recommended.
- Flex Additive: Not recommended.
- Retarder: DuPont™ 3979S™ or 8100S™ Acrylic Enamel Retarder; use 5% and maintain a viscosity of 17 - 19 seconds.

Tinting

Not recommended.



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Primer/Sealers

- Fill 'N Sand® 131S™ Acrylic Primer-Surfacer
- Velvaseal® 1986S™ Acrylic Sealer
- DuPont™ 4004S™ 2K UltraProductive Primer-Filler
- DuPont™ 4904S™ 2K UltraProductive Primer-Filler
- DuPont™ 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer
- DuPont™ ChromaSurfacer® 7704S™ Primer-Filler
- DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane ValueShade® Sealer
- ChromaPremier® 42400S™/42410S™/42440S™/42470S™ Sealer

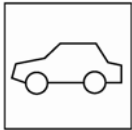
Tips for Success

For optimum holdout and performance, VariPrime® 615S™/625S™ must always be primed or sealed prior to topcoat application.

Application

Substrates

Properly prepared/cleaned steel, aluminum and galvanized



Surface Preparation

- Wipe surface with DuPont™ First Klean™ 3900S™ or Prep-Sol® 3919S™.
- Sand and featheredge with P180 DA grit paper followed by P240 DA grit.
- Remove sanding residue with DuPont™ 3939S™ Lacquer and Enamel Cleaner, DuPont™ Final Klean™ 3901S™ or DuPont™ Kwik Clean™ 3949S™.



Gun Setups*

Conventional

- Siphon Feed: 1.5 mm - 1.8 mm (.059" - .070")
- Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

HVLP

- Siphon Feed: 1.5 mm - 1.8 mm (.059" - .070")
- Gravity Feed: 1.3 mm - 1.6 mm (.051" - .063")



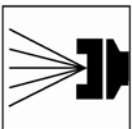
Air Pressure*

Conventional

- Siphon Feed: 30 - 45 psi @ the gun.
- Gravity Feed: 25 - 35 psi @ the gun.

HVLP

- Siphon Feed: 6 - 8 psi @ the gun cap.
- Gravity Feed: 6 - 8 psi @ the gun cap.



*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



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Application

Apply 2 medium coats.



Flash/Dry Times

Air Dry

Flash between Coats:	Flash until dull (normally 5 minutes).
Nib Sanding:	5 - 10 minutes after flash (wet sanding not recommended).
Priming:	30 - 45 minutes.
Max Allowable Dry Time:	24 hours; then sanding is required.

Force Dry

Not recommended.

Note: Variprime® 615S™/625S™ should be primed or sealed within 16 hours for best performance.

Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.



Physical Properties

VOC:	5.9 lbs/gal ready-to-spray.
Theoretical Coverage:	200.5 sq. feet per ready-to-spray gallon at 1 mil.
Weight Solids:	27.5% ready-to-spray.
Volume Solids:	12.5% ready-to-spray.
Recommended Dry Film Thickness:	0.8 - 1.0 mils in 2 coats.
Flash Point:	See MSDS.



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VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Please visit: www.performancecoatings.DuPont™.com to view or print an addition copy of this "Technical Product Data" sheet.



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