



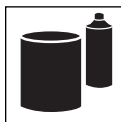
DuPont Automotive Finishes

DuPont™ ChromaFil® 4140S™ Multi-Use Primer

Description

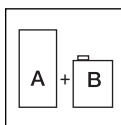
ChromaFil® 4140S™ is a two-component primer that combines excellent holdout, good fill and productivity. ChromaFil® may be used direct to metal, or for maximum corrosion protection, use it over Variprime®.

General Information



Components

ChromaFil® 4140S™ Multi-Use Primer
ChromaFil® 4175S™ Multi-Use Undercoat Activator



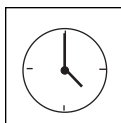
Mix Ratio/Viscosity

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

	Volume	Weight (cumulative qt)
ChromaFil® 4140S™ Primer	4	1018 grams
ChromaFil® 4175S™ Activator	1	1182 grams

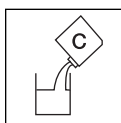
Viscosity

16 - 20 seconds in a Zahn #2 cup.



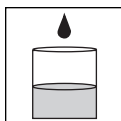
Pot Life

1½ hours.



Additives

Accelerator: Not required.
Fish Eye Eliminator: Not required.
Flex Additive: Not required.
Reducer: Not required.
Retarder: Not required.



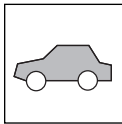
Tinting

May use up to 10% MasterTint® mixing colors that are 4.8 VOC or below.

Sealer

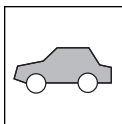
ChromaPremier® 42410S™ Sealer
Low VOC Prime 'N Seal® 2710S™/2740S™/2770S™

DuPont™ ChromaFil® 4140S™ Multi-Use Primer



Topcoats

ChromaPremier® Basecoat
 ChromaPremier® Single Stage
 ChromaBase®
 ChromaOne®



Application

Substrates

Properly treated steel, aluminum and galvanized
 Properly sanded OEM finishes and OEM replacement parts
 Direct to Variprime®
 Rigid plastic or fiberglass



Surface Preparation

- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont First Klean 3900S™, Prep-Sol® 3919S™ or DuPont Kwik Clean 3949S™. For unprimed rigid plastic or fiberglass, wipe with Plas-Stick® 2320S™ Plastics Cleaner.

- Sand and featheredge according to the following minimum grit recommendations:

Steel:	P80 - P120 DA grit.
Aluminum:	P240 DA grit, then pretreat.
Galvanized:	P320 DA grit or red scuff pad, then pretreat.
E-coat:	P320 DA grit or red scuff pad.
Cured paint:	P240 - P320 DA grit.
OEM featheredge:	P180 DA grit followed by P240 DA grit.
Body filler:	P240 DA grit.
2K putty:	P240 DA grit.
SMC/fiberglass:	P180 - P240 DA grit.

- Remove sanding sludge with DuPont Final Klean 3901S™, DuPont 3939S™ Lacquer and Enamel Cleaner or DuPont Low VOC Final Klean 3909S™.

Notes:

Aluminum and galvanized substrates must be pretreated with Variprime® 615S™ or Variprime® 625S™ Lead and Chromate Free.

Alternately, aluminum may be pretreated with DuPont 225S™/226S™ and galvanized may be pretreated with DuPont 5717S™/5718S™.

For steel, as an optional pretreatment step, apply 2 medium coats of Variprime® 615S™ or 625S™ for maximum corrosion protection.

Tips for Success

- *When using coarse grit paper, step your way up through P80/P180/P240 DA grit prior to priming to remove coarse scratches and avoid sandscratch swelling in OEM finishes.*
- *Sand beyond the area to be primed with P320 DA grit or finer to ensure good adhesion at the thin edge of the primer.*
- *ChromaFil® is not recommended for use on flexible plastic substrates.*

DuPont™ ChromaFil® 4140S™ Multi-Use Primer



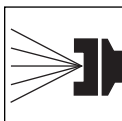
Gun Setups*

Conventional

Siphon Feed: 1.6 mm - 1.8 mm (.063" - .070")
 Gravity Feed: 1.6 mm - 1.8 mm (.063" - .070")

HVLP

Siphon Feed: 1.4 mm - 1.8 mm (.055" - .070")
 Gravity Feed: 1.4 mm - 1.8 mm (.055" - .070")



Air Pressure*

Conventional

	Panel	Overall
Siphon Feed:	35 - 40 psi @ the gun.	40 - 45 psi @ the gun.
Gravity Feed:	30 - 35 psi @ the gun.	35 - 40 psi @ the gun.

HVLP

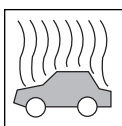
Siphon Feed:	8 - 10 psi @ the gun cap.	8 - 10 psi @ the gun cap.
Gravity Feed:	8 - 10 psi @ the gun cap.	8 - 10 psi @ the gun cap.

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



Application

Apply 3 medium-wet coats.



Flash/Dry Times

Air Dry

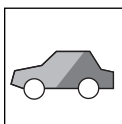
Flash between Coats: 5 - 10 minutes.
 Wet Sanding: 2 hours minimum.
 Dry Sanding (machine): 90 minutes (at 3.5 mils at 70°F).
 Dry Sanding (hand): 2 - 3 hours.

Force Dry

Flash before Force Dry: 5 - 10 minutes.
 Cycle Time: 30 minutes @ 140°F.
 Cool Down: 30 minutes.

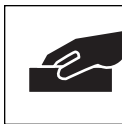
Infrared Dry

For a 1500 - 2000 Watt unit, cure for 30 minutes at a distance of 36 inches. **Allow to flash 10 minutes before applying IR.** Refer to the Infrared Guide for setup recommendations.



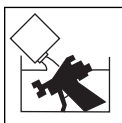
Recoatability/Re-repair

When recoating ChromaFil® 4140S™ with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 16 hours.



Sanding

Prior to sealing or topcoating, sand with P400 DA grit or P500 dry or wet.



Cleanup

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

DuPont™ ChromaFil® 4140S™ Multi-Use Primer

Physical Properties

VOC: 4.6 lbs/gal ready-to-spray.

Theoretical Coverage: 561 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 56.2% ready-to-spray.

Volume Solids: 35.0% ready-to-spray.

Dry Film Thickness: 3.5 - 5.0 mils in 3 coats.

Flash Point: See MSDS.

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 and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

Before using any DuPont Refinish product, be sure to read all safety directions and warnings. WEAR A PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.

