



# Refinish

## DuPont™ 2510S™/2540S™/2570S™/2580CR™/2590S™ Epoxy DTM

### Description

DuPont™ Epoxy DTM Primer-Sealer a two-component, non-isocyanate non-sanding primer with corrosion resistance and excellent adhesion for direct-to-metal applications. DTM is available in lead/chromate free ValueShade® and chromate for use under body filler, polyester putties, primer-surfacers and topcoats. It is ideal for sandthrough repairs as a DTM with ValueShade®. In addition, ValueShade® is a DuPont technology that improves topcoat coverage, boosts productivity and reduces paint consumption.

DTM can be applied over sanded or blasted steel, well cleaned aluminum, and galvanized or stainless steel without sanding.

It is ideal for commercial/fleet and collision refinishing applications.

### General Information



#### Components

- DuPont™ 2510S™ Epoxy DTM LF (White) ValueShade® 1
- DuPont™ 2540S™ Epoxy DTM LF (Gray) ValueShade® 4
- DuPont™ 2570S™ Epoxy DTM LF (Dark Gray) ValueShade® 7
- DuPont™ 2580CR™ Epoxy DTM CHROMATE CR (Olive Green)
- DuPont™ 2590S™ Epoxy DTM (Black)
- DuPont™ 2503S™ DTM Activator-Low Temperature (55-65°F)
- DuPont™ 2505S™ DTM Activator-Mid Temperature (65-75°F)
- DuPont™ 2507S™ DTM Activator-High Temperature (75-85°F)
- DuPont™ 2509S™ DTM Activator-Overall High Temperature (85-100°F)

### ValueShade® Instructions for Use

Use VS1, VS4 and VS7 as packaged. To create VS2, VS3, VS5 or VS6, mix as shown below. Agitate thoroughly prior to activation.

ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	--	DuPont™ 2510S™	--
VS2	VS1:VS4	DuPont™ 2510S™:2540S™	2:1
VS3	VS1:VS4	DuPont™ 2510S™:2540S™	1:2
VS4 (Medium Gray)	--	DuPont™ 2540S™	--
VS5	VS4:VS7	DuPont™ 2540S™:2570S™	2:1
VS6	VS4:VS7	DuPont™ 2540S™:2570S™	1:2
VS7 (Dark Gray)	--	DuPont™ 2570S™	--

After creating the desired ValueShade®, activate the Epoxy DTM Primer/Sealer as shown in Mix Ratio/Viscosity Section.



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### Mix Ratio/Viscosity

Mix Ratio (2:1)

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

DuPont™ 2510S™	Volume	Weight (cumulative qt)
DuPont™ 2510S™ Primer Sealer	2	937 grams
DuPont™ 2503S™, 2505S™, 2507S™, 2509S™ Activator	1	1203 grams

DuPont™ 2540S™	Volume	Weight (cumulative qt)
DuPont™ 2540S™ Primer Sealer	2	909 grams
DuPont™ 2503S™, 2505S™, 2507S™, 2509S™ Activator	1	1174 grams

DuPont™ 2570S™	Volume	Weight (cumulative qt)
DuPont™ 2570S™ Primer Sealer	2	909 grams
DuPont™ 2503S™, 2505S™, 2507S™, 2509S™ Activator	1	1175 grams

DuPont™ 2580CR™	Volume	Weight (cumulative qt)
DuPont™ 2580CR™ Primer Sealer	2	931
DuPont™ 2503S™, 2505S™, 2507S™, 2509S™ Activator	1	1198

DuPont™ 2590S™	Volume	Weight (cumulative qt)
DuPont™ 2590S™ Primer Sealer	2	904
DuPont™ 2503S™, 2505S™, 2507S™, 2509S™ Activator	1	1171

### Viscosity

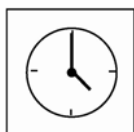
18 - 20 seconds in a Zahn #2 cup at 2:1.

### Tips For Success

Apply one medium wet coat. Film build dry should be 0.8-1.0 mils as a non-sanding primer/sealer over aluminum, galvanized, stainless steel. Two coats of primer will build film build quickly and slow down the dry time to topcoat to 40-60 minutes. Up to 2 coats can be applied (2.0-2.2 mils) as non-sanding primer/sealer over steel.

### Pot Life

12 hours at 70°F in a sealed container.



### Additives

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

### Topcoats

ChromaPremier® Basecoat  
 ChromaPremier® Single Stage  
 ChromaBase® Basecoat  
 ChromaOne® Single Stage  
 ChromaOne® High Solids

### For use over DuPont 2580CR™ only:

Centari® Single Stage  
 Imron® 5000™ Single Stage  
 Imron® 6000™ Basecoat  
 Imron® Single Stage



# Refinish

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### Application

#### Substrates



- OEM replacement parts
- Properly sanded or blasted steel.
- Properly cleaned or sanded aluminum, galvanized steel, or stainless steel
- Properly sanded SMC/fiberglass/body fillers/polyester putties
- Under all DuPont primers

#### Surface Preparation



- Clean painted surfaces thoroughly with mild detergent and water.
  - For substrates other than plastic or fiberglass, clean surfaces with Prep-Sol® 3919S™.
  - For rigid plastic or fiberglass, wipe with Plas-Stick® 2319S™ or 2320S™.
  - For flexible fascia, refer to the DuPont Plastics Refinishing System
1. To Use Epoxy DTM Primer/Sealer as a Precoat:
    - Finish sanding with P320 grit paper or finer.
    - Final cleaning should be done with DuPont™ Final Klean™ 3901S™ or DuPont™ Low VOC Final Klean™ 3909S™.
  2. To Use Epoxy DTM Primer/Sealer as a non-sanding primer:
    - For application to OEM replacement parts, sand with P320 grit or finer.
    - For application direct to steel, sand with P80 grit followed by P180 grit or finer.
    - For application to aluminum, galvanized or stainless, clean with DuPont™ Final Klean™ 3901S™ or DuPont™ Low VOC Final Klean™ 3909S™ or sand with P320 grit.
    - For OEM and painted surfaces, featheredge with P320 grit or finer.
    - Remove sanding sludge with DuPont™ Final Klean™ 3901S™ or DuPont™ Low VOC Final Klean™ 3909S™.

#### Tips For Success

- Wipe cleaned surface with clean white rag on finger tip. If white rag turns gray, surface is not clean.
- For difficult to clean substrates, use appropriate surface preparation agent. (e.g. for aluminum, use DuPont 225S™ and for ferrous metals use DuPont™ 5717S™.)

#### Gun Setups\*

##### Conventional

- Siphon Feed: 1.6 mm - 1.8 mm (.063" - .071")
- Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

##### HVLP

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

#### Air Pressure\*

##### Conventional

- Siphon Feed: 30 - 45 psi @ the gun.
- Gravity Feed: 30 - 40 psi @ the gun.
- Pressure Feed 1.2 mm fluid tip, 35-40 psi @ the gun (fluid flow-14-16 oz/minute)

##### HVLP

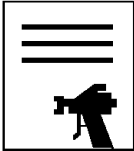
- Siphon Feed: 8-10 psi @ the gun cap
- Gravity Feed: 8-10 psi @ the gun cap

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



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### Application

Apply 1 medium wet coat.

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### Flash/Dry Times

#### Air Dry

Nib Sanding:	30 - 60 minutes	
Topcoating:	20 - 30 minutes (1 coat)	40 - 60 minutes (2 coats)

#### Force Dry

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

*Infrared Dry* Refer to the Infrared Guide for setup recommendations.

**Note:** For use under body filler, allow to dry overnight (minimum of 16 hours) or bake 20 min @ 140°F.

#### *Tips For Success*

*Ambient air temperature (greater than 70°F) and air flow will maximize product performance.*

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### Recoatability/Re-repair

DTM may be recoated at any stage of cure. DTM can be topcoated within 24 hours air dry without sanding the DTM. If the DTM is baked it must be sanded with P400-P600 before topcoating.

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### Physical Properties

VOC:	4.5 lbs/gal ready- to-spray.
Theoretical Coverage:	621 sq. feet per ready- to-spray gallon at 1 mil.
Weight Solids:	53% ready- to-spray.
Volume Solids:	34.97% ready- to-spray.
Recommended Dry Film Thickness:	0.8-1.2 mils.
Flash Point:	See MSDS.



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### VOC Regulated Areas

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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

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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](http://www.performancecoatings.DuPont.com) to view or print an addition copy of this "Technical Product Data" sheet.



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03/07