



Refinish

DuPont™ 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer

Description

DuPont™ 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer is a high performance undercoat designed to provide excellent flow and leveling for spot, panel and overall applications. It exhibits exceptional topcoat holdout and minimum overspray during application. It is also available in ValueShade® and provides the option to "finesse" finish sand, if desired. These features combine to deliver quality and productivity during the entire repair process. When mixed with Plas-Stick® 4950S™ Flex-Additive, DuPont™ 4910S™/4940S™/4970S™/4990S 2K UltraProductive Primer-Sealer provides an excellent foundation for repairs on flexible parts. This product is an iso-free alternative to ChromaPremier® Sealer.

General Information



Components

- DuPont™ 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer
- DuPont™ 4965S™ Low-Temp Activator
- DuPont™ 4975S™ Mid-Temp Activator
- DuPont™ 4995S™ High-Temp Activator

Mix Ratio/Viscosity

Mix Ratio (3:1)

Mix 3 parts DuPont™ 4910S™/4940S™/4970S™/4990S 2K UltraProductive Primer-Sealer to 1 part Activator

	Weight (grams/cumulative qt)	
	DuPont™ 4965S™/4975S™	DuPont™ 4995S™
DuPont™ 4910S™	1068.7 grams	1068.7 grams
DuPont™ 49X5S™	1278.7 grams	1292.0 grams
DuPont™ 4940S™	1031.0 grams	1031.0 grams
DuPont™ 49X5S™	1241.0 grams	1254.2 grams
DuPont™ 4970S™	997.5 grams	997.5 grams
DuPont™ 49X5S™	1207.5 grams	1220.7 grams

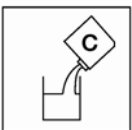
Viscosity

8 - 9 seconds in a Zahn #3 cup.



Pot Life

45 minutes.



Additives

- Accelerator: Not required.
- Fish Eye Eliminator: Not required.
- Reducer: Not required.
- Retarder: Not required.
- Flex Additive: Add 3 oz. Plas-Stick® 4950S™ 2K Flex-Additive per ready-to-spray quart.
Cumulative weight per RTS quart of flexed sealer:

	DuPont™ 4910S™	DuPont™ 4940S™	DuPont™ 4970S™
DuPont™ 49X0S™	946.1 grams	914.6 grams	883.1 grams
DuPont™ 49X5S™	1137.4 grams	1105.9 grams	1074.4 grams
DuPont™ 4950S™	1223.9 grams	1192.5 grams	1160.9 grams



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Topcoats

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

Application

Substrates

- Properly sanded OEM finishes and OEM replacement parts
- Properly sanded DuPont™ 4904S™, 4004S™ Primer-Fillers, or DuPont™ urethane primers
- Direct to Variprime® 615S™ or ChromaPremier® 22860S™ Etch Primer
- Fiberglass, SMC

Tips For Success

DuPont™ 49X0S™ 2K UltraProductive Primer-Sealer is not intended for use direct to metal. Minor cut-throughts at styling lines may be sealed. For larger areas at bare metal use Variprime® 615S™ or ChromaPremier® 22860S™ Wash Primer.

Surface Preparation

- Clean painted surfaces thoroughly with mild detergent and water.
- Wipe surface using DuPont™ Sontara® E-4142™ Surface Preparation System Solvent Wipes, DuPont™ First Klean™ 3900S™, Prep-Sol® 3919S™ or DuPont™ Kwik Klean™ 3949S™.
- Repair and prime areas as required.
- Finish sanding substrate with a minimum of P400 DA grit dry, P500 grit hand or P600 grit wet.
- Clean using DuPont™ Final Klean™ 3901S™ and a DuPont™ Sontara® E-4142™ Surface Preparation System Solvent Wipe.
- After cleaning is complete and immediately before sealing, wipe surfaces with the temperature appropriate DuPont™ Sontara® PS-39XS™ Pre-Saturated Static Control Wipe.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead and Chromate-Free to large areas of bare steel. For aluminum, treat with DuPont™ 225S™ followed by DuPont™ 226S™ and apply 1 coat of Variprime®.

Gun Setups*

Conventional

- Siphon Feed: 1.5 mm – 1.8 mm
- Gravity Feed: 1.4 mm -1.6 mm

HVLP

- Siphon Feed: 1.7 mm – 1.8 mm
- Gravity Feed: 1.4 mm – 1.6 mm



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Air Pressure*

Conventional	Panel	Overall
Siphon Feed:	30 - 45 psi @ the gun.	40 - 45 psi @ the gun.
Gravity Feed:	25 - 30 psi @ the gun.	35 - 40 psi @ the gun.
HVLP		
Siphon Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.
Gravity Feed:	6 - 8 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 1 medium wet coat.



Tips For Success

Normally, only 1 coat of sealer will be needed. However, for sensitive substrates (e.g., LDL or OEM delaminations), 2 coats can provide better holdout.

Flash/Dry Times



	1 Coat	2 Coats
Flash Between Coats	N/A	15 minutes
Air Dry @ 70°F		
Nib Sanding:	15 - 20 minutes	30 - 40 minutes
Topcoating:	20 - 30 minutes	30 - 40 minutes
Force Dry		
Flash before Force Dry:	10 minutes	10 minutes
Cycle Time:	10 minutes @ 140°F	15 minutes @ 140°F
Cool Down:	20 minutes	20 minutes

Infrared Dry Refer to the Infrared Guide for setup recommendations.

Tips for Success

Cooler temperature or more coats will require longer flash times.

Recoatibility/Re-repair

When recoating the sealer with itself or topcoating, sanding (P400 grit dry DA, P500 grit hand or P600 grit wet) is required if the sealer has been allowed to dry more than 8 hours.

Cleanup

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





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Physical Properties

VOC:	4.2 lbs/gal ready-to-spray.
Theoretical Coverage:	624.9 sq. feet per ready-to-spray gallon at 1 mil.
Weight Solids:	60.3% ready-to-spray.
Volume Solids:	38.9% ready-to-spray.
Recommended Dry Film Thickness:	0.8 - 1.2 mils.
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 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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