



Refinish

DuPont™ ChromaPremier® 32430S™ 2K Premier Primer

Description

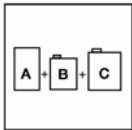
ChromaPremier® 32430S™ 2K Premier Primer is a three-component, high-build, easy to sand primer for premium quality spot, panel and overall repairs. This easy-to-handle primer integrates with ChromaPremier® Activators and Reducers to provide excellent fill and holdout in a wide range of application conditions. For panel and multi-panel repairs, use ChromaPremier® 12305S™ Activator. For increased productivity with spot repairs, use ChromaPremier® 12303S™ Production Activator or ChromaPremier® 12301S™ Ultra Productive Activator. Use ChromaPremier® 42400S™/42410S™/42440S™/42470S™ Sealer with DuPont™ ValueShade® to complete premium repairs more productively, with shorter in-booth process time.

General Information



Components

- ChromaPremier® 32430S™ 2K Premier Primer
- ChromaPremier® 12301S™ Ultra Productive Spot Primer Activator
- ChromaPremier® 12303S™ Production Activator
- ChromaPremier® 12305S™ Activator
- ChromaPremier® 12365S™ Fast Reducer
- ChromaPremier® 12375S™ Medium Reducer
- ChromaPremier® 12385S™ Slow Reducer



Mix Ratio/Viscosity

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

	Vol	Gram Weight (cum qt)		
		12305S™	12303S™	12301S™
ChromaPremier® 32430S™	5	1060	1060	1060
ChromaPremier® 1230XS™ (x= 1,3,or 5)	1	1203	1203	1190
ChromaPremier® 12375S™	1	1319	1318	1302

Viscosity

9.5 - 12 seconds in a Zahn #3 cup.

Tips for Success

Use the following activator/reducer combinations for various temperatures

	65° - 75° F	75° - 85° F	85° F and higher
Spot:	12301S™/12365S™	12303S™/12375S™	12303S™/12385S™
Panel:	12301S™/12375S™	12303S™/21385S™	12305S™/12385S™

Note: Do not use ChromaPremier® 12385S™ and 12395S™ with ChromaPremier® 12301S™ Ultra Productive Primer-Activator.

Note: Do not use ChromaPremier® 12301S™ in ChromaPremier® 2K Premier Sealer, ChromaPremier® Basecoat, ChromaPremier® 72500S™ Premium Appearance Clear or ChromaPremier® 72200S™ Premium Productive Clear.



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Pot Life

1 hour at 70° F (21° C).

Additives

- Accelerator: Not recommended. Do not use MasterTint® 389S to speed up cure. Use the correct activator for adjusting dry times
- Fish Eye Eliminator: Not recommended.
- Retarder: Not recommended.
- Flex Additive: Add 5 oz Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of activated primer or use Plas-Stick® 2350S™ as described below:

	Volume	Gram Weight (cum qt.)		
		12305S™	12303S™	12301S™
ChromaPremier® 32430S™	5	463 g	463 g	463 g
ChromaPremier® 1230XS™ (x=1,3,or 5)	1	526 g	522 g	520 g
ChromaPremier® 12375S™	1	576 g	570 g	569 g
Plas-Stick® 2350S™	1	633 g	625 g	624 g

Tips for Success

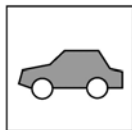
Keep film builds to a minimum on flexible parts.

Sealer

- ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer
- DuPont 2510S™/2540S™/2570S™ DTM Epoxy Primer-Sealer
- DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer

Topcoats

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

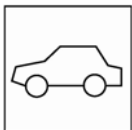


Application

Substrates

Primer-Filler

- Properly treated steel, aluminum and galvanized steel.
- Properly sanded OEM finishes and OEM replacement parts
- Direct to Variprime® 615S™, ChromaPremier® 22860S™ Etch Primer
- Fiberglass, SMC





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Surface Preparation

- Clean surface thoroughly with mild detergent and water. For substrates other than plastic or fiberglass, wipe surface with DuPont™ First Klean™ 3900S™, Prep-Sol® 3919S™ or DuPont™ Kwik Clean™ 3949S™. For flexible and rigid plastic and fiberglass, wipe with Plas-Stick® 2320S™ Plastics Cleaner.
- Sand and featheredge according to the following minimum grit recommendations:
 - Steel: P180 grit.
 - Aluminum: P320 grit, then pretreat.
 - Galvanized: P320 grit, then pretreat.
 - E-coat: P320 grit.
 - Cured paint: P320 grit.
 - OEM featheredge: P180 grit followed by P240 grit.
 - Body filler: P180 grit.
 - 2K putty: P180-P240 grit.
 - SMC/fiberglass: P180-P240 grit.

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

Notes: Aluminum, galvanized, and steel must be pretreated with Variprime® 615S™, lead and chromate-free Variprime® 625S™, or ChromaPremier® 22860S™ Premier Etch Primer. Alternately, aluminum may be pretreated with DuPont 225S™/226S™.

Tips for Success:

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sandscratch swelling in OEM finishes. Finish sensitive substrates in P320 grit.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.



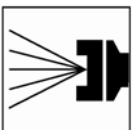
Gun Setups*

Conventional

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

HVLP

Siphon Feed:	1.6 mm - 1.9 mm (.063" - .073")
Gravity Feed:	1.6 mm - 1.9 mm (.063" - .073")



Air Pressure*

Conventional

Siphon Feed:	30-40 psi @ the gun.
Gravity Feed:	30-40 psi @ the gun.

HVLP

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

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Equipment Information section of the ChromaSystem™ Technical Manual.



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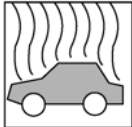
Apply 3 medium wet coats.



Tips for Success

Allow adequate flash between coats.

Flash/Dry Times



Air

Dry

	12305S™	12303S™	12301S™
Flash between Coats:	10 minutes	10 minutes	10 minutes
Dry Sanding (machine or hand):	4 hours	3 hours	2 hours
Wet Sanding:	4 hours.	3 hours	2 hours

Force Dry

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

Note: 12303S™ and 12301S™ activators are designed for air dry only.

Infrared Dry

Refer to the Infrared Guide for specific setup recommendations.

Recoatability/Re-repair

When recoating ChromaPremier® 32430S™ 2K Premier Primer with itself, sanding is required if the primer has been force dried or has been allowed to air dry for more than 16 hours.

Cleanup

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



Physical Properties

VOC:	4.1-4.3 lbs/gal ready-to-spray.
Theoretical Coverage:	663.6 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	63-65% ready-to-spray.
Volume Solids:	41.-42% ready-to-spray.
Recommended Dry Film Thickness:	4.2 - 5.5 mils in 3 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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