



Roller Application of 2K Primers

Description

DuPont offers E-4888 roller handles, E-4889 roller trays and E-4890 rollers for roller application of DuPont 4004S™ 2K UltraProductive Primer-Filler and other 2K primers. The rollers are specifically designed to minimize the fat edge incurred during this type of application.

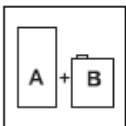
General Information



Components

4004S™ 2K UltraProductive Primer Surfacer
4075S™ Activator

Mix Ratio



Component	Ratio	Cumulative Weight			
		4 oz	8 oz	12 oz	16 oz
4004S™	4	135 g	271 g	406 g	541 g
4075S™	1	156 g	311 g	467 g	622 g

Pot Life

45 minutes.



Tips for Success

Mix small amounts of primer suited to the size of the job. This will help reduce waste.



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Application

Substrate

Properly treated steel, galvanized steel and aluminum. Direct to pre-treated metals. Refer to the ChromaSystem® Manual for the correct metal pre-treatment.

Surface Preparation



- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface using DuPont™ Sontara® PS-3909S™ wipe, Sontara® PS-3970S™ wipe, Sontara® PS-3990S™ wipe, First Klean™ 3900S™, Prep-Sol® 3919S™ or Kwik Clean® 3949S™.
- Refer to the ChromaSystem® Technical Manual for procedures to prepare plastic or fiberglass parts.
- Finish sanding substrate using chart below as a guide.



Sand and featheredge according to the following minimum grit recommendations:

Steel:	P180 grit.
Aluminum:	P240 grit.
Galvanized:	P320 grit.
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™ Sontara® PS-3909S™ wipe, Final Klean™ 3901S™, Final Klean™ 3909S™ or 3939S™ Lacquer and Enamel Cleaner.

Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.

Note: Aluminum must be pre-treated with Variprime® 615S™ or DuPont ChromaPremier® 22860S™ Premier Etch Primer. Over areas of bare steel greater than 8" X 8", pretreat with 615S™ or 22860S™.

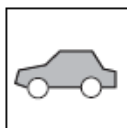
Tips for Success

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 the OEM finish.

Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.



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Sealers

DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer
 DuPont 2510S™/2540S™/2570S™/2580CR™ Epoxy DTM Primer-Sealer
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer

Topcoats

ChromaPremier® Basecoat/ChromaClear®
 ChromaPremier® Single Stage
 ChromaBase® Basecoat/ChromaClear®
 ChromaOne® Single Stage

Application



Thoroughly saturate roller in the paint tray and remove excess. Apply paint in an outside in pattern in progressive coats. Using minimum pressure, apply paint to vehicle in a “V” pattern. The “V” pattern will reduce “track marks” from the roller’s edge. Avoid leaving heavy edge marks. Cover the entire repair area.

Flash 6 to 10 minutes between coats. The primer needs to flash thoroughly before applying another coat.

Apply 3 coats. Use of the sponge roller gives 2.5 to 3.5 mils dft.

Tips for Success

If the first coat is still tacky, the application of the second coat will pull paint off of the first coat leaving large lumps in the film. Allow the primer to flash thoroughly between coats.

Clean the roller as soon as possible to remove the 2K primer before it cures.

Flash/Dry Times



Air Dry

Flash between Coats	6 to 10 minutes.
Sand	60 minutes at 80 °F or 90 minutes at 70 °F
Topcoat	60 minutes at 80 °F or 90 minutes at 70 °F

Infrared Red Cure

Flash before cure	10 minutes
Cure	15 minutes at 36 inches with a 1500 watt to 2000 watt unit

Tips for Success

For optimum holdout on sensitive substrates, dry primer using infrared equipment.



Sanding

Sand with P400 grit DA, P500 grit dry or P600 wet. Finish sanding with P600 on a DA if you do not intend to seal before topcoating.



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Physical Properties

VOC :

VOC AP	4.1 lb/gal ready-to-spray
VOC LE	4.1 lb/gal ready-to-spray

Flash Point: See MSDS.

VOC Regulated Areas

These directions refer to the use of products which may be restricted in VOC regulated areas. Follow usage 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.

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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DuPont Performance Coatings 4