



Effective 28 October, 2005

DP4101 / DP4104 / DP4107

HS PRIMER

Description

2-component High Solids primer with 2 methods of application:

- a. primer surfacer;
- b. non-sanding primer.

Colour: white, medium grey and black.

Composition based on a special hydroxy functional acrylic.

Products

DP4101	DuPont™ Marine Finishes HS Primer - white
DP4104	DuPont™ Marine Finishes HS Primer - medium grey
DP4107	DuPont™ Marine Finishes HS Primer - black
DP2100	DuPont™ Marine Finishes HS Activator Standard
DP2110	DuPont™ Marine Finishes HS Activator Slow
TH40	DuPont™ Marine Finishes Thinner Standard
TH41	DuPont™ Marine Finishes Thinner Large Surfaces

Auxiliary products

3910WB	DuPont™ Waterborne Degreaser
3911WB	DuPont™ Final Clean
3919S	DuPont™ Prepsol
3920S	DuPont™ Degreaser
5717S	DuPont™ Metal Conditioner

Properties

- Very high solids - low VOC technology: better filling, same build with fewer coats, resulting in less consumption.
- Less solvent than conventional 2K high solids primers.
- Excellent in dry and wet sanding.
- Superior topcoat hold-out.
- Can be coated with all DuPont™ Marine Finishes topcoats.

Substrates

Following specifications listed in the DuPont™ Marine Finishes Manual and in particular:

- cured repaired finishes;
- cured DuPont™ Marine Finishes epoxy primers.











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PRODUCT PREPARATION

	Mixing ratio	Primer surfacer				Non-sanding	
		Standard		Large surface		TH40/TH41	
		Volume	Weight	Volume	Weight	Volume	Weight
	DP4101/DP4104/DP4107 DP2100 DP2110 TH40/TH41	4 1 - 1	100 18 - 15	4 - 1 1	100 - 18 15	4 - 1 3	100 - 18 45
	VOC	450 to 492 g/l				530 g/l	
	Pot life at 20°C	DP2110/DP2100		3 to 4 hr		2 to 3 hr	
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4		19-23 s 19-23 s 21-25 s		14 s 14 s 16 s	
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed		Fluid tip		Distance	
				1.6-1.8 mm 1.6-1.8 mm 1.4-1.6 mm 1.2 mm		20-25 cm 20-25 cm 15 cm 20-25 cm	
	Spray pressure	Gravity feed Suction feed HVLP Pressure feed		3-3.5 bar 3-3.5 bar 0.7 bar at nozzle 4-6 bar			
	Number of coats	1 to 3				1 to 2	
	Flash time	Between coats till flat. 5 min before bake.				15 min (till 8 hr maximum) before topcoating.	
	DFT	60 to 80 µ/coat				30 to 40 µ/coat	
	Dry to sand at 15°C at 20°C	DP2100/DP2110				Not applicable.	
		16 hr 8 hr					
<p>This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.</p>							



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RECOMMENDED USE

Surface preparation

Following specifications listed in the DuPont™ Marine Finishes Manual and in particular:

Cured repaired finishes

1. Clean surface with water and soap. Rinse and dry.
 2. Degrease with 3919S or 3910WB. Wipe dry.
 3. Sand:
 - a) primer surfacer: mechanical with P220 - P280, wet with P360 - P500;
 - b) non-sanding: mechanical with P220 - P320, wet with P600.
- ! Treat bare metal spots in sand through areas as described below:
- Apply 5717S, rinse with plenty of water and dry.
 - Clean surface with 3920S or 3911WB.
 - Apply 1 coat DuPont™ Marine Finishes epoxy primer (see specific TDS).

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a suitable nitrocellulose thinner.
2. Sand and eliminate all rust or corrosion.
3. Clean with 3920S or 3911WB.
4. Wipe dry before priming.
5. Apply 1 coat DuPont™ Marine Finishes epoxy primer (see specific TDS) and proceed with DP4101/DP4104/DP4107 application.

Remarks

- Do not use activated DP4101/DP4104/DP4107 beyond the pot life nor reduce it further to get viscosity down again.
- Do not exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of DP2100 and DP2110 tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- Material has to be at room temperature (18-25°C) before use.

Application selection

Primer surfacer

Normal priming; spot, panel and overall repair.

Non-sanding

To reduce sanding work and increase output.



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RECOMMENDED USE (con'd)

Equipment cleaning

Use a suitable nitrocellulose thinner.

Product data

Package viscosity: 2.500-3.500 cp
 Volume solids: 47 % ± 5 %
 Theoretical coverage: 5.0-7.0 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Storability at 20°C (year)	Density (kg/l)
DP4101	4	2	1.571
DP4104	4	2	1.529
DP4107	4	2	1.504
DP2100	1 - 5	2	1.064
DP2110	1 - 5	2	1.078
TH40	5	2	0.908
TH41	5	2	0.900
3910WB	5	2	0.975
3911WB	5	2	0.945
3919S	5 - 20	2	0.811
3920S	5 - 20	2	0.776
5717S	1 - 4	2	1.157

Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.



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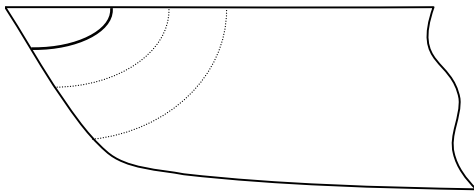
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REPAIR SYSTEMS

Preparation method for spot repair

P280 P320 P360



1. Sand through, end with P280.
2. Fill the spot with putty and sand with P280.
3. Sand the surrounding area with P320 and finish with P360.
4. Apply 1 coat of DuPont™ Marine Finishes epoxy primer over the putty to isolate the substrate and flash till flat.
5. Apply 1st coat of primer surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of primer surfacer, staying inside the 1st-coat area. Flash till flat.