DuPont™ DTM EPOXY PRIMER/SEALER V-2910S VS1

Description
DuPont 2.1 VOC DTM EPOXY PRIMER/SEALER a two-component, non-isocyanate non-sanding primer with superior corrosion resistance and excellent adhesion for direct-to-metal applications. 2.1 VOC DTM is currently available in white. It is intended for use as a metal treatment under DuPont primer surfacers, or a sealer over DuPont primer surfacers. DTM can be applied over cleaned aluminum, galvanized steel, and stainless steel, or over appropriately sanded or blasted carbon steel, sanded fiberglass, and sanded OEM e-coat primers.

General Information
Components
V-2905S - 2.1 VOC DTM Epoxy Primer/Sealer LF (White) VS 1
V-2907S - DTM Mid-Temp Activator
V-2907S - DTM High-Temp Activator

Mix Ratio/Viscosity
Mix Ratio (2:1)
Mix 2 parts 2.1 VOC DTM PRIMER to 1 part Activator

<table>
<thead>
<tr>
<th>Weight (Cum. Qt.)</th>
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<tbody>
<tr>
<td>V-2910S</td>
<td>1030 grams</td>
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<tr>
<td>V-2905S</td>
<td>1030 grams</td>
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<tr>
<td>V-2907S</td>
<td>1368 grams</td>
</tr>
<tr>
<td>V-290XS</td>
<td>1369 grams</td>
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<td>(sprayable quart)</td>
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Viscosity
20 - 22 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 steel, carbon steel and stainless steel. Time to topcoat is 30-40 minutes. Two coats of primer will build film build quickly and slow down the dry time to topcoat to 60 minutes. Can apply up to 2 coats (2.0-2.2 mils) as non-sanding primer/sealer.

Pot Life
12 hours at 70°F in a sealed container.
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Additives
Reducer: Up to 5% 12375S/12385S/12395S (In areas where 2.8 VOC is required)
Accelerator: Not recommended.
Fish Eye Eliminator: Not recommended.
Retarder: Not recommended.

Topcoats
ChromaPremier® Basecoat
ChromaPremier® Single-Stage
ChromaBase® Basecoat
ChromaOne® Single-Stage
Centari® Single-Stage
Imron® 5000 Single-Stage
Imron® 6000 Basecoat
Imron® Single-Stage

Application
Substrates
Properly sanded OEM replacement parts
Properly sanded or blasted steel.
Properly cleaned or sanded aluminum, galvanized, and stainless steel
SMC, fiberglass, body fillers, polyester putties
Over properly sanded DuPont primers.
Under all DuPont primers.

Surface Preparation
n Clean painted surfaces thoroughly with mild detergent and water.
 For substrates other than plastic or fiberglass, clean surfaces with Prep-Sol® 3909S.
 For rigid plastic or fiberglass, wipe with Plastic-Prep® 2319S or 2320S.
 For flexible fascia, refer to the DuPont Plastics Refinishing System
1. To Use 2.1 VOC DTM Epoxy Primer/Sealer as a Precoat:
   Finish sanding with 320 grit paper or finer.
   Final cleaning should be done with 3909S.
2. To Use 2.1 VOC DTM Epoxy Primer/Sealer as a non-sanding primer:
   For application to OEM replacement parts, sand with 320 grit or finer.
   For application direct to steel, sand with 80 grit followed by 180 grit or finer.
   For application to aluminum, galvanized or stainless steel, clean with 3909S or sand with 320 grit paper or finer.
   Remove sanding sludge with 3909S.
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**Gun Setups**

**Conventional**
- Siphon Feed: 1.6 mm - 1.8 mm (.063" - .071")
- Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")
- Pressure Feed: 1.0 mm - 1.2 mm

**HVLP**
- Siphon Feed: 1.9 mm - 2.1 mm
- Gravity Feed: 1.4 mm - 1.5 mm
- Pressure Feed: .8 mm - 1.0 mm (Set fluid flow 10-12 oz per minute)

**Air Pressure**

**Conventional**
- Siphon Feed: 35 - 45 psi @ the gun.
- Gravity Feed: 30 - 40 psi @ the gun.
- Pressure Feed: 35 - 40 psi @ the gun (Set fluid flow 12-14 oz per minute)

**HVLP**
- Siphon Feed: 8 - 10 psi at the gun cap.
- Gravity Feed: 8 - 10 psi at the gun cap.
- Pressure Feed: 8 - 10 psi at 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.

**Flash/Dry Times**

**Air Dry**
- Nib Sanding: 30 - 60 minutes
- Topcoating: 30 - 40 minutes (1 coat DTM) 50 - 60 minutes (2 coats DTM)

**Force Dry**
- Flash before Force Dry: 5 minutes
- Cycle Time: 20 minutes @ 140°F
- Cool Down: 15 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.
Recoatability/Re-repair
2.1 VOC DTM may be recoated at any stage of cure. DTM can be topcoated within 2 days air dry without sanding the DTM. If the DTM is baked or air dried longer than 2 days, it must be sanded with P400-P600 before topcoating.

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

Physical Properties
VOC: 2.1 lbs/gal ready-to-spray.
Theoretical Coverage: 555 sq. feet per ready-to-spray gallon at 1 mil.
Volume Solids: 35% 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 and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling
Before using any DuPont Refinish product, be sure to read all safety directions and warnings. WEAR A PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.