



Refinish

ChromaPremier® Pro 33430S™ Productive Primer Filler

Description

ChromaPremier® Pro 33430S™ Productive Primer Filler 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 Productive Activators and Reducers to provide excellent fill and holdout in a wide range of application conditions.

General Information

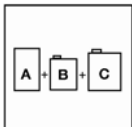


Components

- 33430S™ Productive Primer Filler
- 14301S™ Productive Primer Activator
- 14304S™ Productive Activator Fast
- 14375S™ Productive Reducer, Faster
- 14385S™ Productive Reducer, Normal

Tips for Success

Fastest cure rate and handling is achieved using the Productive Primer Activator 14301S™.



Mix Ratio/Viscosity

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

Mix Formula, Cumulative Weights in grams

Mix by Volume	Mix Formula, Cumulative Weights in grams								
	Mix Size in Ounces	2	4	6	8	12	16	24	30
4	33430S™	59	118	177	236	353	471	707	883
1	14301S™	68	137	205	273	410	546	820	1025
1	14375S™	77	153	230	307	460	613	920	1150

Viscosity

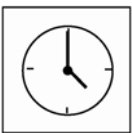
9.5 - 12 seconds in a Zahn #3 cup.

Tips for Success

Use the activator and reducer combinations listed in the Components section.

Pot Life

1 hour at 70° F (21° C).





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Additives

Accelerator: Not recommended.
 Fish Eye Eliminator: Not recommended.
 Retarder: Not recommended.
 Flex Additive: Use Plas-Stick® 2350S™ as described below:

Productive Primer Filler with Plas-stick® Flexible Additive

Mix by Volume	Mix Size in Ounces	Mix Formula, Cummulative Weights in grams							
		2	4	6	8	12	16	24	30
4	33430S™	54	109	163	217	326	435	652	815
1	14301S™	63	126	189	252	378	504	757	946
1	14375S™	71	141	212	283	424	566	849	1061
0.5	2350S™	75	150	225	300	451	601	901	1127

Tips for Success

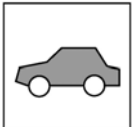
Keep film builds to a minimum on flexible parts.

Sealer

42410S™ (VS1), 42440S™ (VS4) and 42470S™ (VS7) ChromaPremier® Sealers

Topcoats

ChromaPremier® Basecoat
 ChromaPremier® Single Stage
 ChromaBase® Basecoat
 ChromaOne® Single Stage
 Cromax® Pro Basecoat

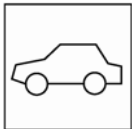


Application

Substrates

Primer-Filler

Properly treated steel, aluminum and galvanized steel.
 Properly sanded OEM finishes and OEM replacement parts
 Direct to 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™.
- 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.
- For substrates other than plastic, 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 ChromaPremier® 22860S™ Premier Etch Primer. Alternately, aluminum may be pretreated with DuPont 225S™/226S™.

Refer to the ChromaSystem Technical Manual for procedures to prepare plastic or fiberglass parts.

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*



Compliant

Siphon Feed:	1.6 mm - 1.8 mm
Gravity Feed:	1.6 mm - 1.8 mm

HVLP

Siphon Feed:	1.6 mm - 1.9 mm
Gravity Feed:	1.6 mm - 1.9 mm

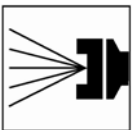
Air Pressure*

Compliant

Siphon Feed:	20-30 psi @ the gun.
Gravity Feed:	20-30 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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Application

Apply 3 medium wet coats.



Tips for Success

Allow adequate flash between coats.

Flash/Dry Times



	<i>Force Dry</i>	<i>Air Dry</i>
Flash between Coats:	7 to 10 minutes	7 to 10 minutes
Dry Sanding (machine or hand):	On cool down	90 minutes
Wet Sanding:	On cool down	90 minutes
Flash before Force Dry:	0 minutes	N/A
Cycle Time:	30 minutes @ 140° F.	N/A
Cool Down:	30 minutes.	N/A

Infrared Dry

Refer to the Infrared Guide for specific setup recommendations.

12 minute IR exposure at 32 inches with a 2000 watt lamp produces good results.

Recoatability/Re-repair

When recoating 33430S™ Productive Primer Filler with itself, sanding is required if the primer has been force dried or has been allowed to air dry for more than 6 hours.

Cleanup

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



Physical Properties

VOC LE:	3.6 lbs/gal
VOC AP:	3.6 lbs/gal
VOC:	4.8 lbs/gal ready-to-spray, maximum
Theoretical Coverage:	680 sq. ft. per ready-to-spray gallon at 1 mil.
Weight Solids:	58.3 % ready-to-spray.
Volume Solids:	42.3 % ready-to-spray.
Recommended Dry Film Thickness:	4.5 – 6.0 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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