



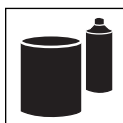
DuPont Automotive Finishes

DuPont™ Variprime® 615S™/625S™ Self-Etching Primer

Description

Variprime® is a fast-drying, two-component, self-etching primer. It provides excellent corrosion resistance and direct-to-metal adhesion for spot, panel and overall repairs.

General Information

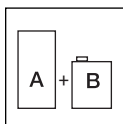


Components

- Variprime® 615S™
- Variprime® 625S™ Lead and Chromate Free
- Variprime® 616S™ - Converter
- Variprime® 620S™ - Fast Converter
- Variprime® 614S™ - Slow Converter

Tips for Success

Keep cans closed when not in use to prevent moisture absorption, which may lead to blistering, loss of adhesion or other product failure.



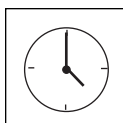
Mix Ratio/Viscosity

Combine the components either by volume or weight and then mix thoroughly.

	Volume	Weight (cumulative qt)
Variprime® 615S™/625S™ Primer	1	553 grams
Variprime® 616S™/620S™/614S™ Converter	1	941 grams (sprayable qt)

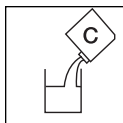
Viscosity

17 - 19 seconds in a Zahn #2 (DuPont M-222) cup.



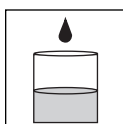
Pot Life

72 hours.



Additives

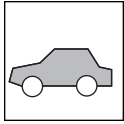
- Accelerator: Not recommended.
- Fish Eye Eliminator: Not recommended.
- Flex Additive: Not recommended.
- Retarder: DuPont 3979S™ or 8100S™ Acrylic Enamel Retarder; use 5% and maintain a viscosity of 17 - 19 seconds.



Tinting

Not recommended.

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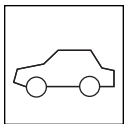
Primer/Sealer

Fill 'N Sand® 131S™ Acrylic Primer-Surfacers
 DuPont™ URO® 1120S™/1140S™ Primer-Filler
 DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler
 Velvaseal® 1986™ Acrylic Sealer
 Low VOC Prime 'N Seal® 2710S™/2740S™/2770S™
 ChromaFil® 4140S™ Multi-Use Primer
 DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler
 DuPont 4904S™ 2K UltraProductive Primer-Filler
 DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer

Tips for Success

For optimum holdout and performance, VariPrime® 615S™/625S™ must always be primed or sealed prior to topcoat application.

Application



Substrates

Properly prepared/cleaned steel, aluminum and galvanized



Surface Preparation

- Wipe surface with DuPont First Klean 3900S™ or Prep-Sol® 3919S™.
- Sand and featheredge with P180 DA grit paper followed by P240 DA grit.
- Remove sanding residue with DuPont 3939S™ Lacquer and Enamel Cleaner, DuPont Final Klean 3901S™ or DuPont Kwik Clean 3949S™.



Gun Setups*

Conventional

Siphon Feed: 1.5 mm - 1.8 mm (.059" - .070")
 Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

HVLP

Siphon Feed: 1.5 mm - 1.8 mm (.059" - .070")
 Gravity Feed: 1.3 mm - 1.6 mm (.051" - .063")



Air Pressure*

Conventional

Siphon Feed: 30 - 45 psi @ the gun.
 Gravity Feed: 25 - 35 psi @ the gun.

HVLP

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

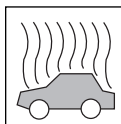
*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application

Apply 2 medium coats.

DuPont™ Variprime® 615S™/625S™ Self-Etching Primer



Flash/Dry Times

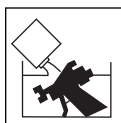
Air Dry

Flash between Coats:	Flash until dull (normally 5 minutes).
Nib Sanding:	5 - 10 minutes after flash (wet sanding not recommended).
Priming:	30 - 45 minutes.
Max Allowable Dry Time:	24 hours; then sanding is required.

Force Dry

Not recommended.

Note: Variprime® 615S/625S should be primed or sealed within 16 hours for best performance.



Cleanup

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

Physical Properties

VOC: 5.9 lbs/gal ready-to-spray.

Theoretical Coverage: 200.5 sq. feet per ready-to-spray gallon at 1 mil.

Weight Solids: 27.5% ready-to-spray.

Volume Solids: 12.5% ready-to-spray.

Recommended Dry Film Thickness: 0.8 - 1.0 mils in 2 coats.

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.

