



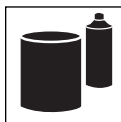
DuPont Automotive Finishes

DuPont 4904S™ 2K UltraProductive Primer-Filler

Description

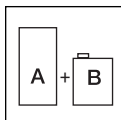
DuPont 4904S™ 2K UltraProductive Primer-Filler is designed for those shops seeking a highly productive 2K primer. Consistent speed to sand of 1 hour air dry provides increased productivity during the entire repair process, from undercoat application to in-booth process time. This spot and panel primer-filler delivers quality topcoat holdout, fast dry, minimum overspray and ease of sanding in a high-build 2K primer-filler. When mixed with Plas-Stick® 4950S™ Flex-Additive, DuPont 4904S™ provides an excellent foundation for repairs on flexible substrates.

General Information



Components

- DuPont 4904S™ 2K UltraProductive Primer-Filler
- DuPont 4965S™ UltraProductive Low-Temp Activator
- DuPont 4975S™ UltraProductive Mid-Temp Activator
- DuPont 4995S™ UltraProductive High-Temp Activator



Mix Ratio/Viscosity

Mix Ratio (3:1)

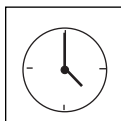
Mix 3 parts DuPont 4904S™ to 1 part DuPont 49X5S™ 2K UltraProductive Primer-Filler Activator (X=6, 7, or 9).

Weight (grams/cumulative qt.)

	DuPont 4965S™/4975S™	DuPont 4995S™
DuPont 4904S™	1142 grams	1142 grams
DuPont 49X5S™	1352 grams	1365 grams

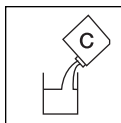
Viscosity

12-16 seconds in a Zahn #3 cup.



Pot Life

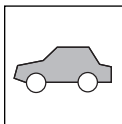
45 minutes.



Additives

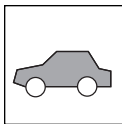
Accelerator:	Not required.
Fish Eye Eliminator:	Not required.
Reducer:	Add up to 10% DuPont ChromaSystem™ or ChromaPremier® Reducer by volume to ready-to-spray mixture for improved flow and leveling.
Retarder:	Not required.
Flex Additive:	Add 3 oz. Plas-Stick® 4950S™ Flex-Additive per ready-to-spray quart Cumulative weight per RTS quart of flexed primer-filler:
	DuPont 4904S™ 1029 grams
	DuPont 4965S™/4975S™/4995S™ 1225 grams
	Plas-Stick® 4950S™ 1311 grams

DuPont 4904S™ 2K UltraProductive Primer-Filler



Sealers

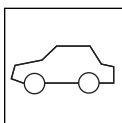
DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer
 DuPont 2510S™/2540S™/2570S™/2580CR™ Epoxy DTM Primer-Sealer
 ChromaPremier® 42410S™/42440S™/42470S™ Sealer
 Low VOC Prime 'N Seal® 2710S™/2740S™/2770S™



Topcoats

ChromaPremier® Basecoat
 ChromaPremier® Single Stage
 ChromaBase® Basecoat
 ChromaOne® Single Stage
 ChromaOne® High Solids

Application



Substrates

Properly cleaned and sanded steel and galvanized
 Properly treated aluminum
 Properly sanded OEM finishes and OEM replacement parts
 Direct to Variprime® or ChromaPremier® 22860S™ Etch Primer



Surface Preparation

- Clean surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface using DuPont™ Sontara® E-4142™ Surface Preparation System Solvent Wipe and DuPont First Klean 3900S™, Prep-Sol® 3919S™ or DuPont Kwik Clean 3949S™. For unprimed plastic or fiberglass, wipe with Plas-Stick® 2320S™ Plastics Cleaner or Plas-Stick® 2319S™ Plastics Cleaner. Then follow Plastics Repair recommendations in the ChromaSystem™ Technical Manual.
- Finish sanding substrate using chart below as a guide.
- Remove sanding sludge with DuPont Final Klean 3901S™, DuPont 3939S™ Lacquer and Enamel Cleaner or DuPont Low VOC Final Klean 3909S™ and a DuPont™ Sontara® E-4142™ Surface Preparation System Solvent Wipe.

Sand and featheredge according to the following minimum grit recommendations:

Steel:	P180 grit.
Aluminum:	P240 grit, then pretreat.
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.

Note: Aluminum must be pretreated with Variprime® 615S™ or Variprime® 625S™ Lead- and Chromate-Free. Alternately, aluminum may be pretreated with DuPont 225S™/226S™. For steel, as an optional pretreatment step on small area repairs, apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™, or ChromaPremier® 22860S™ Etch Primer for maximum corrosion protection. **Large areas of bare steel must be pretreated with Variprime® 615S™, Variprime® 625S™ or ChromaPremier® 22860S™ for maximum corrosion protection.**

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

DuPont 4904S™ 2K UltraProductive Primer-Filler



Gun Setups

Conventional

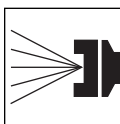
Siphon Feed: 1.8mm - 2.0mm (.070" - .079")

Gravity Feed: 1.8mm - 2.0mm (.070" - .079")

HVLP

Siphon Feed: 1.8mm - 2.0mm (.070" - .079")

Gravity Feed: 1.8mm - 2.0mm (.070" - .079")



Air Pressure

Conventional

25 - 35 psi at the gun.

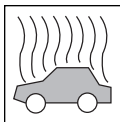
HVLP

6 - 8 psi at the gun cap.



Application:

Apply 3 medium wet coats.



Flash/Dry Times

Air Dry

Flash between Coats: 5-8 minutes.

Sanding: 1 hour.

Top Coating: 1 hour.

Force Dry

Flash before Force Dry: 10 minutes.

Cycle Time: 30 minutes @ 140°F.

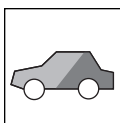
Cool Down: 30 minutes.

Infrared Dry

For a 1500-2000 Watt unit, cure 15 minutes at a distance of 36 inches. Allow to flash 10 minutes before applying IR. Refer to the Infrared Guide for specific setup recommendations.

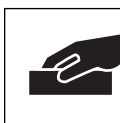
Tips for Success:

For optimum holdout on sensitive substrates, force dry primer.



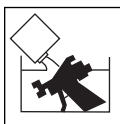
Recoatability/Re-repair

When recoating DuPont 4904S™ 2K UltraProductive Primer-Filler with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 1 hours.



Sanding

Prior to sealing or topcoating: P400 grit DA, P500 grit hand or P600 grit wet.



Cleanup

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

DuPont 4904S™ 2K UltraProductive Primer-Filler

Physical Properties

VOC: 3.2 lbs/gal ready-to-spray.

Theoretical Coverage: 712 sq. feet per ready-to-spray gallon at 1 mil.

Weight Solids: 65.6% ready-to-spray.

Volume Solids: 44.4% ready-to-spray.

Recommended Dry Film Thickness: 5-6 mils in 3 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.

