



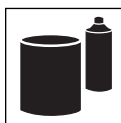
DuPont Automotive Finishes

DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer

Description

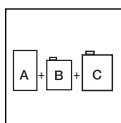
DuPont 4910S™/4940S™/4970S™/4990S™ 2K UltraProductive Primer-Sealer is a high performance undercoat designed to provide excellent flow and leveling for spot, panel and overall applications. It exhibits exceptional topcoat holdout and minimum overspray during application. It is also available in ValueShade® and provides the option to “finesse” finish sand, if desired. These features combine to deliver quality and productivity during the entire repair process. When mixed with Plas-Stick® 4950S™ Flex-Additive, DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer provides an excellent foundation for repairs on flexible parts. This product is an iso-free alternative to ChromaPremier® Sealer.

General Information



Components

DuPont 4910S™/4940S™/4970S™/4990S™ 2K UltraProductive Primer-Sealer
 DuPont 4965S™ Low-Temp Activator
 DuPont 4975S™ Mid-Temp Activator
 DuPont 4995S™ High-Temp Activator



Mix Ratio/Viscosity

Mix Ratio (3:1)

Mix 3 parts DuPont 4910S™/4940S™/4970S™/4990S™ 2K UltraProductive Primer-Sealer to 1 part Activator

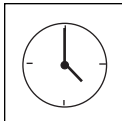
Weight (grams/cumulative qt)

	DuPont 4965S™/4975S™	DuPont 4995S™
DuPont 4910S™	1068.7 grams	1068.7 grams
DuPont 49X5S™	1278.7 grams	1292.0 grams
DuPont 4940S™	1031.0 grams	1031.0 grams
DuPont 49X5S™	1241.0 grams	1254.2 grams
DuPont 4970S™	997.5 grams	997.5 grams
DuPont 49X5S™	1207.5 grams	1220.7 grams

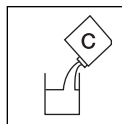
Viscosity

8 - 9 seconds in a Zahn #3 cup.

DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer



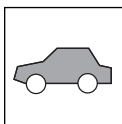
Pot Life
45 minutes.



Additives

Accelerator: Not required.
 Fish Eye Eliminator: Not required.
 Reducer: Not required.
 Retarder: Not required.
 Flex Additive: Add 3 oz. Plas-Stick® 4950S™ 2K Flex-Additive per ready-to-spray quart.
 Cumulative weight per RTS quart of flexed sealer:

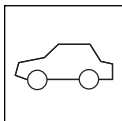
	DuPont 4910S™	DuPont 4940S™	DuPont 4970S™
DuPont 49X0S™	946.1 grams	914.6 grams	883.1 grams
DuPont 49X5S™	1137.4 grams	1105.9 grams	1074.4 grams
DuPont 4950S™	1223.9 grams	1192.5 grams	1160.9 grams



Topcoats

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

Application



Substrates

Properly sanded OEM finishes and OEM replacement parts
 Properly sanded DuPont 4904S™, 4001S™/4004S™/4007S™ Primer-Fillers, or DuPont urethane primers
 Direct to Variprime® 615S™ or ChromaPremier® 22860S™ Etch Primer
 Fiberglass, SMC

Tips For Success

DuPont 49X0S™ 2K UltraProductive Primer-Sealer is not intended for use direct to metal. Minor cut-throughts at styling lines may be sealed. For larger areas at bare metal use Variprime® 615S™ or ChromaPremier® 22860S™ Wash Primer.



Surface Preparation

- Clean painted surfaces thoroughly with mild detergent and water.
- Wipe surface using DuPont™ Sontara® E-4142™ Surface Preparation System Solvent Wipes, DuPont First Klean 3900S™, Prep-Sol® 3919S™ or DuPont Kwik Klean 3949S™.
- Repair and prime areas as required.
- Finish sanding substrate with a minimum of P400 DA grit dry P500 grit hand or P600 grit wet.
- Clean using DuPont Final Klean 3901S™ and a DuPont™ Sontara® E-4142™ Surface Preparation System Solvent Wipe.
- After cleaning is complete and immediately before sealing, wipe surfaces with the temperature appropriate DuPont™ Sontara® PS-39XS™ Pre-Saturated Static Control Wipe.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead- and Chromate-Free to large areas of bare steel. For aluminum, treat with DuPont 225S™ followed by DuPont 226S™ and apply 1 coat of Variprime®.

DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer



Gun Setups*

Conventional

Siphon Feed: 1.5 mm - 1.8 mm
 Gravity Feed: 1.4 mm - 1.6 mm

HVLP

Siphon Feed: 1.7 mm - 1.8 mm
 Gravity Feed: 1.4 mm - 1.6 mm



Air Pressure*

Conventional

Siphon Feed:	30 - 45 psi @ the gun.	40 - 45 psi @ the gun.
Gravity Feed:	25 - 30 psi @ the gun.	35 - 40 psi @ the gun.

HVLP

Siphon Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.
Gravity Feed:	6 - 8 psi @ the gun cap.	8 - 10 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."

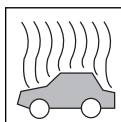


Application

Apply 1 medium wet coat.

Tips For Success

Normally, only 1 coat of sealer will be needed. However, for sensitive substrates (e.g., LDL or OEM delaminations), 2 coats can provide better holdout.



Flash/Dry Times

	1 Coat	2 Coats
Flash Between Coats	N/A	15 minutes
Air Dry @ 70°F		
Nib Sanding:	15 - 20 minutes	30 - 40 minutes
Topcoating:	20 - 30 minutes	30 - 40 minutes

Force Dry

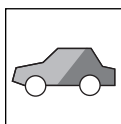
Flash before Force Dry:	10 minutes	10 minutes
Cycle Time:	10 minutes @ 140°F	15 minutes @ 140°F
Cool Down:	20 minutes	20 minutes

Infrared Dry

Refer to the Infrared Guide for setup recommendations.

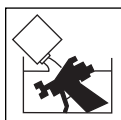
Tips for Success

Cooler temperature or more coats will require longer flash times.



Recoatability/Re-repair

When recoating the sealer with itself or topcoating, sanding (P400 grit dry DA, P500 grit hand or P600 grit wet) is required if the sealer has been allowed to dry more than 8 hours.



Cleanup

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

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Physical Properties

VOC: 4.2 lbs/gal ready-to-spray.

Theoretical Coverage: 624.9 sq. feet per ready-to-spray gallon at 1 mil.

Weight Solids: 60.3% ready-to-spray.

Volume Solids: 38.9% 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.