



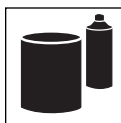
DuPont Automotive Finishes

## DuPont™ URO® 1120S™/1140S™ Primer-Filler

### Description

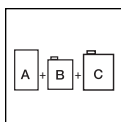
DuPont™ URO® 1120S™/1140S™ Primer-Filler is a high build, 2K urethane primer-filler that provides good topcoat holdout. It is designed for spot, panel and overall applications.

### General Information



#### Components

DuPont™ URO® 1120S™ Primer-Filler (Beige)  
 DuPont™ URO® 1140S™ Primer-Filler (Gray)  
 DuPont 1125S™ Activator  
 DuPont™ URO® 1130S™ Converter  
 DuPont™ URO® 1135S™ Fast Converter



#### Mix Ratio/Viscosity

*Mix Ratio 4:1:1*

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

| DuPont™ URO® 1120S™           | Volume | Weight (cumulative qt) |
|-------------------------------|--------|------------------------|
| DuPont™ URO® 1120S™ Primer    | 4      | 968.4 grams            |
| DuPont 1125S™ Activator       | 1      | 1121.7 grams           |
| DuPont™ URO® 1130S™ Converter | 1      | 1259.3 grams           |
| DuPont™ URO® 1140S™           | Volume | Weight (cumulative qt) |
| DuPont™ URO® 1140S™ Primer    | 4      | 969.9 grams            |
| DuPont 1125S™ Activator       | 1      | 1123.2 grams           |
| DuPont™ URO® 1130S™ Converter | 1      | 1260.8 grams           |

#### Viscosity

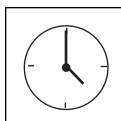
20 - 24 seconds in a Zahn #2 (DuPont M-222) cup.

#### Tips for Success

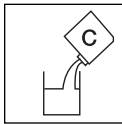
- Use mixing stick for accurate measurements.
- DuPont™ URO® 1130S™ provides better holdout and should be used whenever speed to sand is not the primary attribute desired.

#### Pot Life

2 - 3 hours (DuPont™ URO® 1130S™).  
 1 - 1½ hours (DuPont™ URO® 1135S™).



## DuPont™ URO® 1120S™/1140S™ Primer-Filler



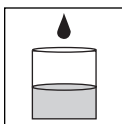
### Additives

Accelerator: Not required.  
 Fish Eye Eliminator: Not required.  
 Reducer: Not required.  
 Retarder: Not required.  
 Flex Additive: DuPont™ Plas-Stick® 2350S™ Flexible Additive

| Undercoats                 | Volume | Weight (cum. pt.) |
|----------------------------|--------|-------------------|
| <b>DuPont™ URO® 1120S™</b> | 4      | 336.3             |
| DuPont 1125S™              | 1      | 391.5             |
| DuPont™ URO® 1130S™/1135S™ | 2      | 490.4             |
| Plas-Stick® 2350S™         | 1.5    | 572.7             |
| <b>DuPont™ URO® 1140S™</b> | 4      | 343.3             |
| DuPont 1125S™              | 1      | 397.4             |
| DuPont™ URO® 1130S™/1135S™ | 2      | 494.7             |
| Plas-Stick® 2350S™         | 1.5    | 575.5             |

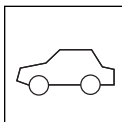
### Tips for Success

Keep film builds to a minimum on flexible parts.



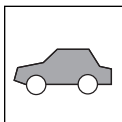
### Tinting

May use up to 10% MasterTint® mixing color.



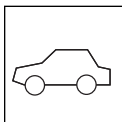
### Sealer

ChromaPremier® Sealer  
 DuPont 2K UltraProductive Primer-Sealer  
 Low VOC Prime'N Seal®  
 Plas-Stick® Flexible Adhesion Sealer



### Topcoats

ChromaPremier® Basecoat  
 ChromaPremier® Single Stage  
 ChromaBase®  
 ChromaOne®



### Application

#### Substrates

Properly treated steel, aluminum and galvanized  
 Properly sanded OEM finishes and OEM replacement parts  
 Direct to Variprime® 615S™/625S™ Self-Etching Primer

#### Tips for Success

- The use of DuPont™ URO® Primer-Filler over sensitive lacquer substrates often results in sporadic lifting when topcoated with lacquer or other strong solvent-containing topcoats. For repairs over sensitive lacquer substrates, limit use of DuPont™ URO® Primer-Filler to panel repairs.
- For best holdout, IR, force dry, or allow primer to dry overnight.

## DuPont™ URO® 1120S™/1140S™ Primer-Filler



### Surface Preparation

- Clean painted surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont First Klean 3900S™, Prep-Sol® 3919S™ or DuPont Kwik Clean 3949S™.
- For unprimed plastic and fiberglass, wipe with DuPont™ Plas-Stick® 2320S™ Plastics Cleaner.
- As a primer, sand and featheredge with P180 DA grit paper followed by P240 DA grit paper.
- Remove sanding sludge with DuPontFinal Klean 3901S™ or DuPont 3939S™ Lacquer and Enamel Cleaner or DuPont Low VOC Final Klean 3909S™.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead and Chromate Free, or treat with DuPont 5717S™/5718S™ on bare steel. Aluminum must be treated with DuPont 225S™/226S™.

### Tips for Success

*Avoid the use of excessively coarse grit paper. When working with 36/40 grit scratches, step your way up through P80/P180/P240 DA grit prior to priming to remove coarse scratches and avoid sandscratch swelling in OEM finishes.*



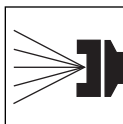
### Gun Setups\*

#### Conventional

Siphon Feed: 1.6 mm - 1.8 mm (.063" - .070")  
 Gravity Feed: 1.6 mm - 1.8 mm (.063" - .070")

#### HVLP

Siphon Feed: 1.2 mm - 1.8 mm (.047" - .070")  
 Gravity Feed: 1.2 mm - 1.8 mm (.047" - .070")



### Air Pressure\*

#### Conventional

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

#### HVLP

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

#### Overall

45 - 50 psi @ the gun.  
 35 - 40 psi @ the gun.

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

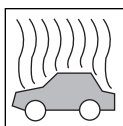


### Application

Apply 3 medium-wet coats.

### Tips for Success

*Apply medium-wet coats; heavy-wet coats have a tendency to "skin dry" and trap solvents. If higher film builds are desired, use DuPont™ Uro® 1130S™ and allow the first coat to dry thoroughly before applying consecutive coats.*



### Flash/Dry Times

#### Primer

##### Air Dry

Flash between Coats: 10 minutes.  
 Wet Sanding: 3 hours with DuPont™ Uro® 1130S™  
 2 hours with DuPont™ Uro® 1135S™  
 Dry Sanding: 4 hours with DuPont™ Uro® 1130S™  
 3 hours with DuPont™ Uro® 1135S™

##### Force Dry

Flash before Force Dry: 10 minutes.  
 Cycle Time: 30 minutes @ 140°F.  
 Cool Down: 30 minutes.

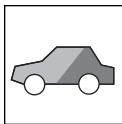
##### Infrared Dry

Refer to the Infrared Guide for setup recommendations.

### Tips for Success

*For optimum holdout, air dry overnight or force dry.*

## DuPont™ URO® 1120S™/1140S™ Primer-Filler



### Recoatability/Re-repair

When recoating DuPont™ URO® Primer-Filler with more DuPont™ URO® Primer-Filler, sanding is required if the primer-filler has been force dried or has been allowed to air dry more than 16 hours.

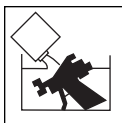


### Sanding

Prior to sealing or topcoating, sand with P400 DA or P500 - P600 dry or wet.

### Tips for Success

*For best holdout, 2 - 3 mils of dry film build should remain on featheredges after sanding.*



### Cleanup

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

### Physical Properties

|                       |                               |
|-----------------------|-------------------------------|
| VOC:                  | 4.6 lbs/gal RTS.              |
| Theoretical Coverage: | 586 sq ft / RTS gal at 1 mil. |
| Weight Solids:        | 58.2% RTS.                    |
| Volume Solids:        | 36.5% RTS.                    |
| Dry Film Thickness:   | 4.5 - 5.5 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

WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST ARE EXHAUSTED. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.