

DuPont™ ChromaPremier® 32430S™ 2K Premier Primer

Description

ChromaPremier® 32430S™ 2K premier Primer 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 ChromaPremier® Activators and Reducers to provide excellent fill and holdout in a wide range of application conditions. For panel and multi-panel repairs, use ChromaPremier® 12305S™ Activator. For increased productivity with spot repairs, use ChromaPremier® 12303S™ Production activator or ChromaPremier® 12301S™ Ultra Productive Activator. Use ChromaPremier® 42410S™/42440S™/42470S™ Sealer with DuPont™ ValueShade® to complete premium repairs more productively, with shorter in-booth process time.

General Information



Components

ChromaPremier® 32430S™ 2K Premier Primer
 ChromaPremier® 12301S™ Ultra Productive Activator
 ChromaPremier® 12303S™ Production Activator
 ChromaPremier® 12305S™ Activator
 ChromaPremier® 12365S™ Fast Reducer
 ChromaPremier® 12375S™ Medium Reducer
 ChromaPremier® 12385S™ Slow Reducer
 ChromaPremier® 12395S™ Very Slow Reducer

Mix Ratio/Viscosity

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

| | | Gram Weight (cum. qt) | | |
|------------------------|--------|-----------------------|---------|---------|
| | | 12305S™ | 12303S™ | 12301S™ |
| | | x = 5 | x=3 | x=1 |
| | Volume | | | |
| ChromaPremier® 32430S™ | 5 | 1060 g | 1060 g | 1060 g |
| ChromaPremier® 1230XS™ | 1 | 1203 g | 1203 g | 1190 g |
| ChromaPremier® 12375S™ | 1 | 1319 g | 1318 g | 1302 g |

Viscosity:

9.5-12 seconds in a Zahn #3 cup

Note: Do not use ChromaPremier® 12385S™ and 12395S™ with ChromaPremier™ 12301S™ UltraProductive Primer Activator.

Note: Do not use ChromaPremier® 12301S™ in ChromaPremier® 2K Premier Sealer, ChromaPremier® Basecoat, ChromaPremier® 72500S™ Premium Appearance Clear or ChromaPremier® 72200S™ Premium Productive Clear.

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Pot Life

1 hour at 70°F (21C)



Additives

Accelerator: Not recommended. Do not use Mastertint® 389S™ to speed up cure. Use the correct activator for adjusting dry times.

Fish Eye Eliminator: Not recommended

Retarder: Not recommended

Flex Additive: Add 5oz Plas-Stick® 2350S™ Flexible Additive per ready to spray quart of activated primer or use Plas-Stick® 2350S™ as described below.

| | | Gram Weight (cum.qt) | | |
|-------------------------------|--------|----------------------|---------|---------|
| | | 12305S™ | 12303S™ | 12301S™ |
| | Volume | x = 5 | x=3 | x=1 |
| ChromaPremier® 32430S™ | 5 | 463 g | 463 g | 463 g |
| ChromaPremier® 1230XS™ | 1 | 526 g | 522 g | 520 g |
| ChromaPremier® 12375S™ | 1 | 576 g | 570 g | 569 g |
| Plas-Stick™2350S™ | 1 | 633 g | 625 g | 624 g |

Tips for Success

Keep film builds to a minimum on flexible parts.

Sealer

ChromaPremier® 42400S™/ 42410S™/42440S™/42470S™ 2K Premier Sealer
 DuPont 2510S™/2540S™/2570S™ DTM Epoxy Primer-Sealer
 DuPont 4910S™/4940S™/4970S™ 2K UltraProductive Primer-Sealer

Topcoats

ChromaPremier® Basecoat
 ChromaBase® Basecoat
 ChromaOne® Single Stage
 ChromaPremier® Single Stage



Application

Substrates:

Properly treated steel, galvanized and aluminum
 Properly sanded OEM finishes and OEM replacement parts
 Direct to Variprime® 615S, 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™. For flexible and rigid plastic and fiberglass, wipe with Plas-stick® 2320S™ Plastics cleaner.

Sand and featheredge according to the following minimum grit recommendations:

| | |
|------------------|---------------------------------|
| Steel: | P180grit. |
| Aluminum: | P320grit, 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 |
| 2Kputty: | P180-P240 grit |
| SMC/fiberglass: | P180-P240 grit |

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 Variprime® 615S™ or ChromaPremier® 22860S™ Premier Etch Primer. Alternately, aluminum may be pretreated with DuPont 225S™/ 226S™.

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*

Siphon Feed: 1.6 mm – 1.8 mm (.063" - .070")
Gravity Feed: 1.6 mm – 1.8 mm (.059" - .070")

Siphon Feed: 1.6 mm – 1.9 mm (.047" - .073")
Gravity Feed: 1.6 mm – 1.9 mm (.047" - .073")



Air Pressure*

Conventional

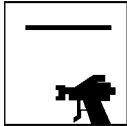
Siphon Feed: 30 - 40 psi @ the gun.
Gravity Feed: 30 - 40 psi @ the gun.

HVLP

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

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*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.



Application

Apply 3 medium wet coats.

Tips for Success

Allow adequate flash between coats.



Flash/Dry Times

| | <i>Air Dry</i> | 12305S™ | 12303S™ | 12301S™ |
|----------------------|----------------|--------------|--------------|--------------|
| Flash between Coats: | | 10 minutes | 10 minutes | 10 minutes |
| Wet Sanding: | | 4 hours | 3 hours | 2 Hours |
| Dry Sanding | | 4 hours | 3 hours | 2 hours |
| <i>Force Dry</i> | | | | |
| Flash before | | 5-10 minutes | 5-10 minutes | 5-10 minutes |
| Force Dry: | | | | |
| Cycle Time: | | 30 minutes | 30 minutes | 30 minutes |
| | | @140°F | @140°F | @140°F |
| Cool Down: | | 30 minutes | 30 minutes | 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.

Recoatability/Rerepair

When recoating ChromaPremier® 32430S™ 2K Premier Primer with itself, sanding is required if the primer has been force dried or has been allowed to air dry.

Cleanup

Clean spray equipment immediately after use with DuPont Lacquer Thinner.

Physical Properties

VOC: 4.1-4.3 lbs./gal ready to spray
 Theoretical Coverage: 663.6-sq. ft/gal at 1mil
 Weight Solids: 63-65% ready to spray
 Volume Solids: 41-42% ready to spray
 Dry Film Thickness: 4.2-5.5 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 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 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.

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