



V-2910S™ / V-2940S™ / V-2970S™ DTM EPOXY PRIMER



GENERAL

DESCRIPTION

A two-component, non-isocyanate, non-sanding primer with superior corrosion resistance and excellent adhesion for direct-to-metal applications. Intended for use as a metal treatment under, or a sealer over, primer surfacers. It can be applied over cleaned aluminum, galvanized steel and stainless steel or over appropriately sanded or blasted carbon steel, sanded fiberglass and sanded OEM e-coat primers.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

- V-2910S™ DTM Epoxy Primer White - ValueShade® 1
- V-2940S™ DTM Epoxy Primer Gray - ValueShade® 4
- V-2970S™ DTM Epoxy Primer Dark Gray - ValueShade® 7
- V-2905S™ DTM Epoxy Mid Temperature Activator
- V-2907S™ DTM Epoxy High Temperature Activator

MIX RATIO

Use VS1, VS4, VS7 as packaged or mix to create VS2, VS3, VS5, VS6 per below.

ValueShade®	Part	Ratio
VS1 (White)	V-2910S™	--
VS2	V-2910S™ : V-2940S™	2:1
VS3	V-2910S™ : V-2940S™	1:2
VS4 (Medium Gray)	V-2940S™	--
VS5	V-2940S™ : V-2970S™	2:1
VS6	V-2940S™ : V-2970S™	1:2
VS7 (Dark Gray)	V-2970S™	--

After creating the desired ValueShade®, combine the components either by volume (2:1) or weight (cumulative grams). Mix thoroughly prior to activation.

Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
V-2910S™	2	517	335	172				
V-2940S™	2		517	510	506	337	169	
V-2970S™	2					506	506	506
V-2905S™	1	686	686	679	675	675	675	675

VISCOSITY

20-22 seconds in a Zahn #2 cup.

POT LIFE

12 hours at 70°F (21°C) in a sealed container.

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Retarder:	Not recommended
Reducer:	Up to 5% ChromaSystem® LE 1075S™ Reducer (In areas where 2.1 VOC is required)



TOPCOATS

Cromax® Pro Basecoat
 Cromax® Mosaic™ Basecoat

APPLICATION

SUBSTRATES

Properly sanded OEM replacement parts.
 Sanded or blasted steel.
 Properly cleaned or sanded aluminum, galvanized, and stainless steel
 SMC, fiberglass, body fillers, polyester putties
 Over properly sanded primers
 Under all primers

SURFACE PREPARATION

- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than plastic or fiberglass, clean surfaces with Surface Cleaner.
- For unprimed plastic or fiberglass, refer to the Plastics Refinishing System

To Use Epoxy DTM Primer/Sealer as a precoat:

- Finish sanding with P320 grit paper or finer.
- Final cleaning should be done with Surface Cleaner.

To Use Epoxy DTM Primer/Sealer as a non-sanding primer:

- For application to OEM replacement parts, sand with P320 grit or finer.
- For application direct to steel, sand with P80 grit followed by P180 grit or finer.
- For application to aluminum, galvanized or stainless, clean with Surface Cleaner or sand with P320 grit.
- For OEM and painted surfaces, featheredge with P320 grit or finer.
- Remove sanding sludge with Surface Cleaner.

Tips For Success

- Wipe cleaned surface with clean white rag on fingertip. If white rag turns gray, surface is not clean.
- For difficult to clean substrates, use appropriate surface preparation agent. (Ex: for aluminum, use 225S™ Aluminum Cleaner and for ferrous metals use 5717S™ Metal Conditioner.)

GUN SETUPS*

Conventional

Siphon Feed:	1.6 mm-1.8 mm
Gravity Feed:	1.4 mm-1.6 mm
Pressure Feed:	1.0 mm-1.2 mm

HVLP

Siphon Feed:	1.9 mm-2.1 mm
Gravity Feed:	1.4 mm-1.5 mm
Pressure Feed:	0.8 mm-1.0 mm

(Set fluid flow 10-12 oz. per minute)

*Fluid tip size refers to the actual diameter of the fluid tip in millimeters. Some gun manufacturers represent tip sizes differently.

AIR PRESSURE*

Conventional

Siphon Feed:	35-45 psi at the gun
Gravity Feed:	30-40 psi at the gun
Pressure Feed:	35-40 psi at the gun

(Set fluid flow 12-14 oz. per minute)

HVLP

Siphon Feed:	8-10 psi at the gun
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Gravity Feed: 8-10 psi at the gun
 Pressure Feed: 8-10 psi at the gun
 *The listed setups cover the range for standard application equipment.

APPLICATION

- Apply 1 medium wet coat. Film build dry should be 0.8-1.0 mils as a non-sanding primer-sealer over aluminum, galvanized steel, carbon steel and stainless steel. Time to topcoat is 45-60 minutes.
- 2 coats of primer will build film build quickly and slow down the dry time to topcoat to 90 minutes minimum.
- Can apply up to 2 coats (2.0-2.2 mils) as a non-sanding primer/sealer.



DRY TIMES

AIR DRY

Nib Sanding: 30-60 minutes
 Topcoating: 45-60 minutes (1 coat DTM)
 60-90 minutes (2 coats DTM)

FORCE DRY

Flash before Force Dry: 5 minutes
 Cycle Time: 20 minutes at 140°F (60°C)
 Cool Down: 15 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations

Note: For use under body filler, allow to dry overnight (minimum of 16 hours) or bake 20 minutes at 140°F (60°C).

Tips for Success

Ambient air temperature (greater than 70°F / 21°C) and air flow will maximize product performance.

RECOATABILITY/RE-REPAIR

V-2910S™ / V-2940S™ / V-2970S™ LF DTM Epoxy Primer may be recoated at any stage of cure. It can be topcoated within 2 days air dry without sanding. If V-2910S™ / V-2940S™ / V-2970S™ LF DTM Epoxy Primer is baked or air dried longer than 2 days, it must be sanded with P400-P600 before topcoating.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE): 186 g/L (1.5 lbs./gal)
 Max. VOC (AP): 84 g/L (.7 lbs./gal)
 Avg. Gal. Wt.: 1441 g/L (12.02 lbs./gal)
 Avg. Wt.% Volatiles: 52.9%
 Avg. Wt.% Exempt Solvent: 47.2%
 Avg. Wt.% Water: 0.0%
 Avg. Vol.% Exempt Solvent: 57.1%
 Avg. Vol.% Water: 0.0%
 Theoretical Coverage: 555 sq. ft. per RTS gallon at 1 mil
 Recommended Dry Film Thickness: 0.8-1.2 mils
 Flash Point: See MSDS/SDS



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 usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

