

4001S / 4004S / 4007S

ULTRA PRODUCTIVE PRIMER

Description

2-component primer surfacer with very fast drying for spot and panel repair.
Colour: white, grey, black.
Composition based on functional acrylic copolymer. Non-isocyanate primer.

Products

4001S	Ultra Productive Primer - white
4004S	Ultra Productive Primer - grey
4007S	Ultra Productive Primer - black
4075S	Activator
XB387	High Temperature Thinner

Properties

- High productive primer: easy wet and dry sandability after 1 h air dry, very short flash time between coats.
- Requires no wash primer on sand throughs to steel or zinc.
- Excellent filling properties and perfect sagging resistance.
- High solids technology: same build with fewer coats, resulting in less consumption.
- Superior topcoat hold-out.
- Can be coated with all DuPont topcoats.











Substrates

- bare steel and zinc on sand throughs
- OEM or cured repaired finishes
- sanded polyester putty
- DuPont wash primers: 820R, 830R

4001S / 4004S / 4007S

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PRODUCT PREPARATION

	Mixing ratio	4001S/4004S/4007S	Volume	Weight
		4075S	4	100
	Mixing ratio at temp. > 30°C	4001S/4004S/4007S	4	100
		4075S	1	15
		XB387	0.25	4
	VOC RFU	538 g/li		
	Pot life at 20°C	45 min.		
	Spray viscosity at 20°C	DIN 4	19-23 s	
		FORD 4	19-23 s	
		AFNOR 4	22-26 s	
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip	Spray distance
			1.4-1.8 mm	20-25 cm
			1.4-1.8 mm	20-25 cm
			1.2-1.4 mm	15 cm
			1.2-1.4 mm	20-25 cm
	Spray pressure	Gravity feed	3-3.5 bar	
		Suction feed	3-3.5 bar	
		HVLP	0.7 bar at nozzle	
		Pressure feed	4-6 bar	
	Number of coats	2		
	Flash time	Between coats till flat. 10 min. before bake.		
	DFT	50-100 μ		
	Dry to sand	at 15°C		
		at 20°C		
		at 40°C		
		at 60°C		
	IR drying*	Distance	80 cm	* guideline for short/medium wave IR equipment
		Half power	2 min.	
		Full power	4 min.	
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.				

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RECOMMENDED USE

Surface preparation

OEM and cured repaired finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with 3919S. Wipe dry.
3. Sand:
 - dry: start with P220, finish with P280;
 - wet: start with P360, finish with P500.
- Clean surface with 3920S.
- No wash primer required on steel or zinc.

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with 3608S.
2. Sand and eliminate all rust or corrosion.
3. Clean with 3920S.
4. Wipe dry before priming.
5. Apply 1 coat 820R or 830R (see specific TDS) and proceed with 4001S/4004S/4007S application.

Primer application

Apply 2 coats and flash till flat between coats.

Equipment cleaning

Use 3608S.

4001S / 4004S / 4007S

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RECOMMENDED USE (con'd)

Remarks

- Do not use activated 4001S/4004S/4007S beyond the pot life nor reduce it further to get viscosity down again.
- If 4001S/4004S/4007S is applied over thermoplastic acrylic finishes, complete panel or overall car has to be primed. Spot priming or sand throughs of the primer can result in spot marking or lifting when applying basecoat.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of 4075S tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-20°C) before use.

Product data

Package viscosity: 1475 cp
 Theoretical coverage: 4-8 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
4001S	4	2
4004S	4	2
4007S	4	2
4075S	1	2
XB387	5	2

Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

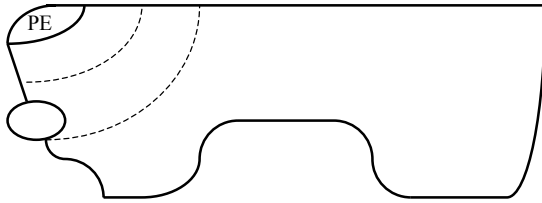
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REPAIR SYSTEMS

Preparation method for spot repair

P280 P320 P360



1. Sand through, end with P280.
2. Fill the spot with polyester putty and sand with P280.
3. Sand the surrounding area with P320 and finish on the OEM finish with P360.
4. Apply 1 coat of 820R or 830R over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1st coat of primer surfacer over the entire prepared area. Flash till completely flat. Apply 2nd coat of primer surfacer, staying inside the 1st-coat area. Flash till flat.