



Refinish

DuPont™ ChromaPremier® 22860S™ Etch Primer

Description

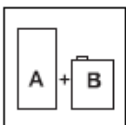
ChromaPremier® 228860S™ Etch Primer is a two-component, self-etching primer that provides exceptional corrosion resistance and adhesion to bare metal. It delivers premium-quality results over bare steel, galvanized and aluminum. Olive-green ChromaPremier® 228860S™ is a non-sanding, OEM approved acid etch primer that makes top-quality direct-to-metal repair work more productive.

General Information



Components

ChromaPremier® 228860S™ Etch Primer (Olive Green)
ChromaPremier® 22805S™ Activator



Mix Ratio/Viscosity

Mix Ratio 1:1

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

	Volume	Weight (cumulative pt.)
ChromaPremier® 228860S™ Etch Primer	1	213.1 grams
ChromaPremier® 22805S™ Activator	1	403.6 grams

Viscosity

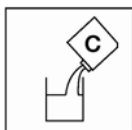
17 seconds in a Zahn #2 (DuPont M-222) cup.

Tips for Success

- *Hand stir components or agitate on a mechanical shaker prior to mixing.*
- *Stir thoroughly while adding Activator, until uniform.*
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Pot Life

8 hours at 70° F (21° C)



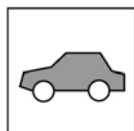
Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not required.
Flex Additive:	Not recommended.
Reducer:	Not recommended.
Retarder:	Not recommended.



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Primer

ChromaSurfacer™ 7704S™ Primer-Filler

ChromaPremier® 32430S™ 2K Premier Primer

ChromaPremier® 424X0S™ 2K Premier Sealer

DuPont™ 4904S™ 2K UltraProductive Primer-Filler

DuPont™ 49X4S™ 2K UltraProductive Primer-Sealer

ChromaPremier® 22860S™ must always be followed with a DuPont Primer-Surfacer or Sealer!

Applications

Substrates

Properly prepared/cleaned steel, aluminum, and galvanized.

Surface Preparation



- Wipe surface with DuPont™ First Klean™ 3900S™ or Prep-Sol® 3919S™.
- Sand and featheredge with P180 DA grit paper followed by P240 DA grit.
- Remove sanding sludge with DuPont™ Final Klean™ 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner, or DuPont™ Low VOC Final Klean™ 3909S™.

Gun Setups*

Conventional

Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")

Gravity Feed: 1.3 mm - 1.6 mm (.051" - .063")

HVLP

Siphon Feed: 1.6 mm - 1.8 mm (.063" - .071")

Gravity Feed: 1.3 mm - 1.6 mm (.051" - .063")

Air Pressure*

Conventional

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

HVLP

6 - 8 psi @ the gun

6 - 8 psi @ the gun cap

*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 2 medium-wet coats. Apply the second coat to hiding. Dry film thickness (DFT) at hiding is approx. 0.5 mils.



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Flash/Dry Times

Flash between Coats:	Flash until dull (normally 10 minutes).
Nib Sanding:	10 minutes after flash (wet sanding not recommended).
Priming:	20 minutes after second coat
Max Allowable Dry Time:	24 hours; then sanding is required.
Force Dry	Not recommended.

Tips for Success

For optimum holdout, air dry overnight, bake or use IR light.



Recoatability/Re-repair

ChromaPremier® 228860S™ is allowed to air dry for more than 8 hours, re-coat with ChromaPremier® 228860S™.

Sanding

No sanding is necessary. May be nib sanded after 20 minutes. Do not wet sand.

Tips For Success

- *If sanding is required to remove imperfections, dry sand with P600 - 1000 grit paper using light hand pressure to avoid any cut-throughs.*



Cleanup

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

Physical Properties

VOC:	6.2 lbs/gal ready-to-spray.
Theoretical Coverage:	176 sq. ft. per ready-to-spray gallon at 0.5 mil.
Percent Solids by Weight:	11.7% ready-to-spray.
Percent Solids by Volume:	55.5% ready-to-spray.
Recommended Dry Film Thickness:	0.5 mils in 2 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 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 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.

Please visit: www.performancecoatings.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.

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