



DuPont™ URO® 1101S™/1104S™/1107S™ Primer-Filler with Nanoparticle Urethane Technology

Description

DuPont™ URO® 1101S™/1104S™/1107S™ is a value shaded high build 2K Urethane Primer-Filler reducible to a sealer. The Value Shade® primer has excellent hold out and shares activator with Chromaclear® 7900S™ Multiuse Clearcoat.



General Information

Components

DuPont™ URO® 1101S™ Primer (White)	VS1
DuPont™ URO® 1104S™ Primer (Gray)	VS4
DuPont™ URO® 1107S™ Primer (Dark Gray)	VS7
ChromaClear® 7975S™ Lo Temp Activator	
ChromaClear® 7985S™ Mid Temp Activator	
ChromaClear® 7995S™ High Temp Activator	
ChromaPremier® 12365S™ Low Temp Reducer	
ChromaPremier® 12375S™ Mid Temp Reducer	
ChromaPremier® 12385S™ High Temp Reducer	

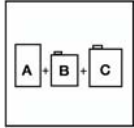
ValueShade® Instructions for Use

Use VS1, VS4, and VS7 as packaged. To create VS2, VS3, VS5, or VS6, mix as shown below. Agitate thoroughly prior to activation.

ValueShade®	Mix	Undercoat	Ratio
VS1 (White)	—	DuPont 1101S™	—
VS2	VS1:VS4	DuPont 1101S™:1104S™	2:1
VS3	VS1:VS4	DuPont 1101S™:1104S™	1:2
VS4 (Medium Gray)	—	DuPont 1104S™	—
VS5	VS4:VS7	DuPont 1104S™:1107S™	2:1
VS6	VS4:VS7	DuPont 1104S™:1107S™	1:2
VS7 (Dark Gray)	—	DuPont 1107S™	—

After creating the desired ValueShade®, activate and reduce the undercoat as shown in Mix Ratio/Viscosity section.

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Mix Ratio 4:1:1 as a filler, 3:1:2 as a sealer

Combine the components either by volume or weight and then mix thoroughly. (cumulative pint)

	Filler		Sealer	
	Volume	Weight	Volume	Weight
DuPont™ URO® 1101S™	4	504.7 grams	3	378.5 grams
ChromaClear® 7975S™	1	585.7 grams	1	458.0 grams
ChromaPremier® 12375S™	1	652.6 grams	2	591.8 grams
DuPont™ URO® 1104S™	4	491.5 grams	3	368.6 grams
ChromaClear® 7975S™	1	572.5 grams	1	448.1 grams
ChromaPremier® 12375S™	1	639.4 grams	2	581.9 grams
DuPont™ URO® 1107S™	4	488.5 grams	3	366.4 grams
ChromaClear® 7975S™	1	569.5 grams	1	445.8 grams
ChromaPremier® 12375S™	1	636.4 grams	2	579.6 grams

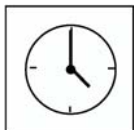
Viscosity

Sealer: 17 - 21 seconds in a Zahn #2 cup.

Filler: 10 - 14 seconds in a Zahn #3 cup.

Tips for Success

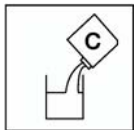
Use mixing stick and a cup with straight sides for accurate measurements.



Pot Life

Filler	Sealer
60 minutes	60 minutes

Additives



Accelerator:	Not required.
Fish Eye Eliminator:	Not required.
Reducer:	Not required.
Retarder:	Not required.
Flex Additive:	Primer-Filler: Add 2.5oz DuPont™ Plas-Stick® 2350S™ flexible additive per RTS pint Primer-Filler: Add 2.0oz DuPont™ Plas-Stick® 2350S™ flexible additive per RTS pint

	Filler Weight (cum. pt.)	Sealer Weight (cum. pt.)
Undercoats		
DuPont 1104S™	425.8 grams	327.6 grams
ChromaClear® 7975S™	494.6 grams	398.2 grams
ChromaPremier® 12375S™	552.6 grams	517.2 grams
Plas-Stick® 2350S™	614.1 grams	567.7 grams

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

Application



Substrates

Primer-Filler

Sanded OEM Substrates
Direct to Variprime 615S™
DTM for cut through only

Sealer

Sanded OEM Substrates
Sanded URO 110XS™ Primer-Filler
Direct to Variprime 615S™
Sanded e-coat
Properly cleaned and scuffed e-coat (red or gray scuff pad)

Tips for Success

- Apply filler using outside-in technique. Allow each coat to flash to a dull even finish before applying next coat.
- For best holdout, IR, force dry, or allow primer to dry overnight.



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™, or DuPont Surface Klean A-3970S™/A-3990S™ Aerosol Surface Cleaners.
- For unprimed plastic and fiberglass, wipe with DuPont™ Plas-Stick® 2320S™ Plastics Cleaner.
- Dry sand: As a primer, sand and featheredge with P180 / P240 / P320, stepping your way up using the stated grit paper.
- Wet sand: Use P400 or P500 grit sand paper.
- Remove sanding sludge with DuPontFinal Klean 3901S™ DuPont 3939S™ Lacquer and Enamel Cleaner, DuPont Low VOC Final Klean 3909S™ or DuPont Surface Klean A-3970S™/A-3990S™ Aerosol Surface Cleaners.
- Apply 2 medium coats of Variprime® 615S™ Self-Etching Primer.
- Clean surface with Sontara® PS-39X5S™ static control wipes before applying sealer to ensure a dirt free clean finish.

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 sand scratch swelling in OEM finishes.

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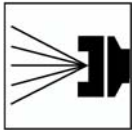
Gun Setups*

Conventional

	Filler	Sealer
Siphon Feed:	1.6 mm - 2.0 mm (.063" - .070")	1.4 mm - 1.6 mm (.055" - .063")
Gravity Feed:	1.6 mm - 2.0 mm (.063" - .070")	1.4 mm - 1.6 mm (.055" - .063")

HVLP

Siphon Feed:	1.6 mm - 2.0 mm (.047" - .070")	1.2 mm - 1.5 mm (.047" - .067")
Gravity Feed:	1.6 mm - 2.0 mm (.047" - .070")	1.2 mm - 1.5 mm (.047" - .067")



Air Pressure*

Conventional

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

HVLP

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

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

**Overall recommendations for sealer use only.



Application

	Filler	Sealer
Coats	3 medium-wet	1 medium-wet
DFT	4.5 - 5.5 mils	0.8 - 1.2 mils



Flash/Dry Times

Air Dry

	Filler	Sealer
Flash between Coats:	10-12 minutes	
Wet Sanding:	2 hours	15 - 30 minutes
Dry Sanding:	3 hours	20 - 30 minutes

Force Dry

Flash before Force Dry:	0-5 minutes	0-5 minutes
Cycle Time:	30 minutes @ 140°F	10 minutes @ 140°F
Cool Down:	30 minutes	10 minutes

Infrared Dry

Refer to the Infrared Guide for setup recommendations.

Tips for Success

For optimum holdout, air dry overnight or force dry.

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Recoatability/Re-repair

When recoating DuPont 110XS™ Primer with more DuPont 110XS™ Primer, sanding is required if the primer has been force dried or has been allowed to air dry more than 3 hours (filler) or 8 hours (sealer).

Sanding

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

	Filler	Sealer
VOC (lbs/gal RTS):	3.9	4.5
Theoretical Coverage (sq ft / RTS gal at 1 mil):	729	581
Weight Solids (RTS):	65.6%	56.0%
Volume Solids (RTS):	45.4%	36.2%
Dry Film Thickness:	4.8 mils in 3 coats	0.8 - 1.2 mils in 1 coat
Flash Point:	See MSDS	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.

