

DuPont™ 18530S™ Urethane Primer

Type

DuPont™18530S™ is a two component urethane primer

Description

DuPont™18530S™ is a high performance urethane primer that provides a level, texture free surface for topcoats. It has excellent topcoat holdout and has a ready-to-spray VOC of less than 2.8 lbs/gal.

Recommended Uses

DuPont™18530S™ Urethane Primer is recommended for above the water line spot repairs or priming small parts where smooth appearance and fast dry times are required. It may also be used as a sanding surfacer over properly primed or treated substrates for maximum topcoat appearance. It may be used over most aged and hard cured coatings in good condition and can be topcoated with MS600 topcoats. **DuPont™18530S™ should not be topcoated with epoxies.**

General Information for Use

Components

DuPont™ 18530S™ Urethane Primer
DuPont™ 18100S™ Urethane Activator



Mix Ratio

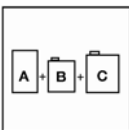
Thoroughly mix DuPont™18530™ prior to activation.

Two Component System

DuPont™18530S™ Urethane Primer
DuPont™18100S™ Urethane Activator

Parts by Volume

4
1

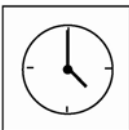


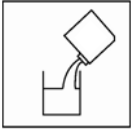
Pot Life and Induction Time

Pot life is 1 hours at 77°F (25 °C)

Pot life is 2 hrs with 2 oz DuPont™ 18820S™ Urethane Acelerator

No induction time is required prior to application.





Additives

Accelerator

DuPont™ 18820S™ for improved dry time (up to 2 oz per ready-to-spray gallon)

Guidelines for Use



Substrates and Surface Preparation

For best results, all surfaces must be clean, dry and free of oil, grease, sanding residue oxidation and other contamination. Gelcoat and previously painted and cured coating in good condition must be scuffed sanded prior to application of DuPont™ 18530S™. Aluminum substrate should be sanded with 80 grit until a uniform silver appearance is obtained.



Gun Setup

DuPont™ 18530S™ can be applied with conventional, HVLP, and electrostatic spray equipment using pressure, siphon, or gravity fluid delivery.

Conventional

Pressure Pot
Siphon Feed
Gravity Feed

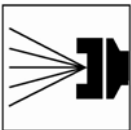
Fluid Tip

1.2 mm – 1.5 mm (.047" - .059")
1.2 mm – 1.5 mm (.047" - .059")
1.3 mm – 1.6 mm (.051" - .063")

HVLP

Pressure Pot
Siphon Feed
Gravity Feed

1.0 mm – 1.4 mm (.039" - .055")
1.0 mm – 1.4 mm (.039" - .055")
1.2 mm – 1.5 mm (.047" - .059")

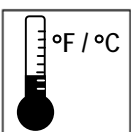


Fluid Delivery

Conventional 8 - 10 ozs/min
HVLP 8 - 10 ozs/min

Air Pressure

Conventional 50 – 60 psi atomizing air
HVLP 25 – 30 psi atomizing air



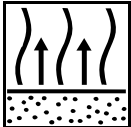
Environmental Conditions

Substrate and ambient temperature must be between 50°F (10°C) and 95°F (35°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated paint above 110°F (43°C) may cause gelation.



Application

Apply DuPont™18530S™ Urethane Primer using a cross coat technique. Spray a wet first coat using a top to bottom motion followed by a medium wet second coat using a side to side motion. No flash time between coats is required. Apply to a maximum dry film thickness of 2.5 mils (approximately 5 mils wet). Imron® MS600™ topcoats may be applied wet-on-wet after a 15 to 20 minute flash.



Dry Times @ 77 deg F

Without DuPont™18820S™ Accelerator

Dry to Touch	2 hours
Thumb print	8-12 hours

With 2 oz DuPont™18820S™ Accelerator

Dry to Touch	30 – 45 minutes
Dry to Tape	2-3 hours



Recoat

If recoating DuPont™18530™ with itself, sanding is required if the primer has air dried longer than 16 hours or force dried. To ensure optimum adhesion, DuPont™18530S™ should be topcoated within 72 hours.



Cleanup Solvents

DuPont™ 3642S™ Thinner or Nason®481-16 Thinner

Physical Properties

VOC	<i>Less Exempts (LE)</i>	<i>As Packaged (AP)</i>
DuPont™ 18530S™	2.3 lbs/gal	2.9 lbs/gal
Ready-to-Spray DuPont™18530S™	2.8 lbs/gal	2.3 lbs/gal

Factory-Packaged Clearcoat

Color	Gray
Closed Cup Flash Point	20°F – 73°F

Ready-to-Spray

Theoretical Coverage(at 1 mil dry film thickness)	818 ft ² /gal
Weight Solids	68%
Volume Solids	51%
Gallon Weight	10.6 lbs/gal

Dry Film

Recommended Film Thickness	1.5 – 2.5 mils for spot repair 3.0-4.0 mils as a sanding surfacer
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Coating Performance

Chemical and Solvent Resistance	Very Good
Weatherability	Excellent
Humidity Resistance	Excellent
Adhesion	Excellent
Flexibility	Excellent.

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 approved ventilation, and gloves.

Do not allow material or overspray to enter drains or waterways

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