IMRON® MARINE
DP4101/DP4104 HS Primer

Description

2-component High Solids primer with 2 methods of application:
a. Primer surfacer.
b. High density primer surfacer.
Colour: white, medium grey.
Composition based on a special hydroxy functional acrylic.

Products

DP4101	HS Primer - white
DP4104	HS Primer - medium grey
DP2100	HS Activator Standard
DP2110	HS Activator Slow
TH40	HS Thinner Standard
TH41	HS Thinner Large Surfaces

Auxiliary products

TH39	Water Based degreaser
3919S	Prepsol
5717S	Metal Conditioner

Properties

- Very high solids - low VOC technology: better filling, same build with fewer coats, resulting in less consumption.
- Less solvent than conventional 2K high solids primers.
- Excellent in dry and wet sanding.
- Superior topcoat hold-out.
- Can be coated with all Imron® Marine topcoats.

Substrates

Following specifications listed in the Imron® Marine Manual and in particular:
- cured repaired finishes;
- cured Imron® Marine epoxy primers.

IMRON® MARINE
DP4101/DP4104 HS Primer

PRODUCT PREPARATION

	Mixing ratio		**Primer surfacer**				**High Density**	
			Standard		**Large surface**		**TH40/TH41**	
			Volume	Weight	Volume	Weight	Volume	Weight
		DP4101/DP4104	4	100	4	100	3.5	100
		DP2100	1	18	-	-	-	-
		DP2110	-	-	1	18	1	20
		TH40/TH41	1	15	1	15	0.5 - 1	7 - 14
	VOC		470 g/l				455 - 480 g/l	
	Pot life at 20°C	DP2110/DP2100	3 to 4 hr.		3 to 4 hr.		3 to 4 hr.	
	Spray viscosity at 20°C	**DIN 4** **FORD 4** **AFNOR 4**	19-23 s 19-23 s 21-25 s		19-23 s 19-23 s 21-25 s		19-23 s 19-23 s 21-25 s	
	Spray equipment		**Fluid tip**		**Distance**			
		Gravity feed **Suction feed** **HVLP** **Pressure feed**	1.6-1.8 mm 1.6-1.8 mm 1.4-1.6 mm 1.2 mm		20-25 cm 20-25 cm 15 cm 20-25 cm			
	Spray pressure	**Gravity feed** **Suction feed** **HVLP** **Pressure feed**	3-3.5 bar 3-3.5 bar 0.7 bar at nozzle 4-6 bar					
	Number of coats		1 to 3				1 to 5	
	Flash time		Between coats till flat.					
	DFT		60 to 80 µ/coat					
	Dry to sand **at 15°C** **at 20°C**		**DP2100/DP2110** 16 hr. 8 hr.					

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.

IMRON® MARINE
DP4101/DP4104 HS Primer

RECOMMENDED USE

Surface preparation

Following specifications listed in the Imron® Marine Manual and in particular:
Cured repaired finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with 3919S or TH39. Wipe dry.
3. Sand:
   a) primer surfacer: mechanical with P220 - P280, wet with P360 - P500;
   b) non-sanding: mechanical with P220 - P320, wet with P600.

! Treat bare metal spots in sand through areas as described below:
- Apply 5717S, rinse with plenty of water and dry.
- Clean surface with 3919S or TH39.
- Apply 1 coat Imron® Marine epoxy primer (see specific TDS).

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

1. Clean surface with a suitable nitrocellulose thinner.
2. Sand and eliminate all rust or corrosion.
3. Clean with 3919S or TH39.
4. Wipe dry before priming.
5. Apply 1 coat Imron® Marine epoxy primer (see specific TDS) and proceed with DP4101/DP4104 application.

Remarks

- Do not use activated DP4101/DP4104 beyond the pot life nor reduce it further to get viscosity down again.
- 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 paper filling.
- Activated material should not be returned to original can of non-activated material.
- Close can of DP2100 and DP2110 tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- Material has to be at room temperature (18-25°C) before use.

IMRON® MARINE
DP4101/DP4104 HS Primer

Application selection

Primer surfacer
Normal priming; spot, panel and overall repair.

High Density
When extra primer build is necessary

Equipment cleaning

Use a suitable nitrocellulose thinner.

Product data

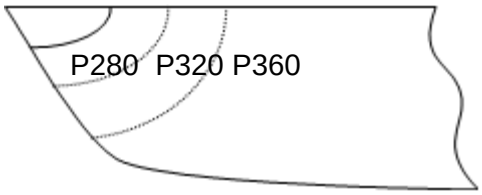
Package viscosity: 2.500-3.500 cp
Volume solids: 47 % ± 5 %
Theoretical coverage: 5.0-7.0 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Storability at 20°C (year)	VOC (g/l) ± 5	Density (kg/l) ± 0.01	Flash Point (°C)
DP4101	4	2	446	1.57	24
DP4104	4	2	458	1.53	24
DP2100	1-5	2	314	1.06	23
DP2110	1-5	2	320	1.08	41
TH40	5	2	717	0.91	10
TH41	5	2	714	0.90	35
TH39	5	2	194	0.98	68
3919S	5 - 20	2	809	0.81	35
5717S	1 - 5	2	324	1.15	68

IMRON® MARINE
DP4101/DP4104 HS Primer

REPAIR SYSTEMS

Preparation method for spot repair



1. Sand through, end with P280.
2. Fill the spot with putty and sand with P280.
3. Sand the surrounding area with P320 and finish with P360.
4. Apply 1 coat of Imron® Marine epoxy primer over the 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.

Safety

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

IMRON® MARINE
DP4101/DP4104 HS Primer

Information

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.
This Technical Data Sheet supersedes all previous issues.

Copyright© 2014, Axalta Coating Systems, LLC and all affiliates. All rights reserved. The Axalta logo, Axalta™ , Axalta Coating Systems™ and all products denoted with ™ or ® are trademarks or registered trademarks of Axalta Coating Systems, LLC and its affiliates. Axalta trademarks may not be used in connection with any product or service that is not an Axalta product or service.