



2510S™ / 2540S™ / 2570S™ / 2580CR™ / 2590S™ LF EPOXY DTM PRIMER



GENERAL

DESCRIPTION

A two-component, non-sanding primer that delivers excellent corrosion resistance and adhesion. ValueShade® technology improves topcoat coverage, boosts productivity and reduces paint consumption.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

- 2510S™ LF Epoxy DTM Primer White - ValueShade® 1
- 2540S™ LF Epoxy DTM Primer Gray - ValueShade® 4
- 2570S™ LF Epoxy DTM Primer Dark Gray - ValueShade® 7
- 2580CR™ Chromate Epoxy DTM Primer
- 2590S™ LF Epoxy DTM Primer Black
- 2503S™ Epoxy DTM Activator Low Temperature
- 2505S™ Epoxy DTM Activator Mid Temperature
- 2507S™ Epoxy DTM Activator High Temperature
- 2509S™ Epoxy DTM Activator Very High Temperature

VALUESHADE® INSTRUCTIONS FOR USE

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

ValueShade®	Mix	Undercoat Ratio
VS1 (White)	—	2510S™ —
VS2	VS1:VS4	2510S™:2540S™ 2:1
VS3	VS1:VS4	2510S™:2540S™ 1:2
VS4 (Medium Gray)	—	2540S™ —
VS5	VS4:VS7	2540S™:2570S™ 2:1
VS6	VS4:VS7	2540S™:2570S™ 1:2
VS7 (Dark Gray)	—	2570S™ —

After creating the desired ValueShade®, activate per the mix ratio section.

MIX RATIO

Combine the components by volume or weight (cumulative qt.). Mix thoroughly.

Component	Volume	Weight
2510S™ LF Epoxy DTM Primer White	2	922 grams
2503S™ / 2505S™ / 2507S™ / 2509S™ Activator	1	1188 grams
2540S™ LF Epoxy DTM Primer Gray	2	894 grams
2503S™ / 2505S™ / 2507S™ / 2509S™ Activator	1	1159 grams
2570S™ LF Epoxy DTM Primer Dark Gray	2	906 grams
2503S™ / 2505S™ / 2507S™ / 2509S™ Activator	1	1171 grams
2580CR™ Chromate Epoxy DTM Primer	2	915 grams
2503S™ / 2505S™ / 2507S™ / 2509S™ Activator	1	1180 grams



2590S™ LF Epoxy DTM Primer Black	2	902 grams	
2503S™ / 2505S™ / 2507S™ / 2509S™ Activator		1	1168 grams

VISCOSITY

18-20 seconds in a Zahn #2 cup.

POT LIFE

12 hours at 70°F (21°C) in a sealed container.

Tips For Success

Apply one medium wet coat. Film build dry should be 0.8-1.0 mils as a non-sanding primer/sealer over aluminum, galvanized, stainless steel. Two coats of primer will build film build quickly and slow down the dry time to topcoat to 40-60 minutes. Up to 2 coats can be applied (2.0-2.2 mils) as non-sanding primer/sealer over steel.

ADDITIVES

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

TOPCOATS

- ChromaPremier® Basecoat
- ChromaPremier® Single Stage Topcoat
- ChromaBase® Basecoat
- Imron® Single Stage Topcoat
- Imron® Elite™ Single Stage Topcoat and Basecoat
- Excel™ Pro Single Stage Topcoat and Basecoat



APPLICATION

SUBSTRATES

- OEM replacement parts
- Properly sanded or blasted steel.
- Properly cleaned or sanded aluminum, galvanized steel or stainless steel
- Properly sanded SMC/fiberglass/body fillers/polyester putties
- Under all primers

SURFACE PREPARATION

- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than plastic or fiberglass, clean surfaces with Prep-Sol® 3919S™ Cleaning Solvent.
- For rigid plastic or fiberglass, wipe with Plas-Stick® 2319S™ Surface Cleaner or Plas-Stick® 2320S™ Flexible Parts Cleaner.
- For flexible fascia, refer to the Plastics Refinishing System.

To use 25X0S as a Precoat:

- Finish sanding with P320 grit paper or finer.
- Final cleaning should be done with Final Klean™ 3901S™ Surface Cleaner or 3909S™ Low VOC Surface Cleaner.

To use 25X0S as a non-sanding primer:

- For application to OEM replacement parts, sand with P320 grit or finer.
- For application direct to steel, sand with P80 grit followed by P180 grit or finer.
- For application to aluminum, galvanized or stainless, clean with Final Klean™ 3901S™ Surface Cleaner or 3909S™ Low VOC Surface Cleaner or sand with P320 grit.
- For OEM and painted surfaces, featheredge with P320 grit or finer.
- Remove sanding sludge with Final Klean™ 3901S™ Surface Cleaner or 3909S™ Low VOC Surface Cleaner.



Tips For Success

- Wipe cleaned surface with clean white rag on finger tip. If white rag turns gray, surface is not clean.
- For difficult to clean substrates, use appropriate surface preparation agent. For aluminum surfaces, use 225S™ Aluminum Metal Cleaner. For ferrous metals, use 5717S™ Metal Conditioner.

GUN SETUPS*

Compliant

Siphon Feed: 1.6 mm-1.8 mm
Gravity Feed: 1.4 mm-1.6 mm

HVLP

Siphon Feed: 1.5 mm-1.8 mm
Gravity Feed: 1.4 mm-1.6 mm

AIR PRESSURE*

Compliant

Siphon Feed: 30-45 psi at the gun
Gravity Feed: 30-40 psi at the gun

Pressure Feed 1.2 mm fluid tip, 35-40 psi at the gun (fluid flow-14-16 oz/minute)

HVLP

Siphon Feed: 8-10 psi at the gun cap
Gravity Feed: 8-10 psi at the gun cap

*The listed setups cover the usual range for standard application equipment.

APPLICATION

Apply 1 medium wet coat.

FOR OPTIMUM CORROSION PERFORMANCE:

Option 1: Apply two medium coats of 2510S™, 2540S™, 2570S™ or 2590S™ to bare metal areas larger than 18" x 18". Allow a 2 hour dry at time 85°F (29°C) and higher temperatures or a 4 hour dry time at 65°F (18°C) to 85°F (29°C) before applying subsequent layers.

Option 2: Apply one medium coat of 2580CR™ to bare metal areas larger than 18" x 18". Allow a 1 hour dry at time 75°F (24°C) and higher temperatures before applying subsequent layers.



DRY TIMES

AIR DRY

Nib Sanding: 30-60 minutes
Topcoating: 1 coat: 20-30 minutes
2 coats: 40-60 minutes

FORCE DRY

Flash before Force Dry: 5 minutes
Cycle Time: 30 minutes at 140°F (60°C)
Cool Down: 30 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Note: For use under body filler, allow to dry overnight (minimum of 16 hours) or bake 20 min at 140°F (60°C).

Tips For Success



Ambient air temperature (greater than 70°F / 21°C) and air flow will maximize product performance.

RECOATABILITY/RE-REPAIR

DTM may be recoated at any stage of cure. DTM can be topcoated within 24 hours air dry without sanding the DTM. If the DTM is baked it must be sanded with P400-P600 before topcoating.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	539 g/L (4.5 lbs./gal)
Max. VOC (AP):	507 g/L (4.2 lbs./gal)
Avg. Gal. Wt.:	1239 g/L (10.34 lbs./gal)
Avg. Wt.% Volatiles:	44.8%
Avg. Wt.% Exempt Solvent:	6.9%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	10.8%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	621 sq. feet per RTS gallon at 1 mil
Recommended Dry Film Thickness:	0.8-1.2 mils
Flash Point:	See MSDS / SDS

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.

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In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
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