



4004S™ 2K ULTRA PRODUCTIVE PRIMER FILLER



GENERAL

DESCRIPTION

A two-component, 2K ultra productive primer-filler designed for spot and panel repairs. It delivers excellent topcoat holdout, fast dry, minimum overspray and ease of sanding.

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



MIXING

COMPONENTS

- 4004S™ Ultra Productive 2K Primer Filler
- 4075S™ Ultra Productive Mid Temperature Activator
- 4095S™ Ultra Productive High Temperature Activator

MIX RATIO

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

Component	Volume	Weight
4004S™ 2K Ultra Productive Primer Filler	4	1071 grams
4075S™ / 4095S™ Activator	1	1232 grams

VISCOSITY

12-16 seconds in a Zahn #3 cup.

POT LIFE

45 minutes

Tips For Success

- Add 10% reducer by volume to RTS mixture to improve flow and leveling.
- Use 4095S™ and 10% reducer if the temperature is higher than 80°F.

ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Retarder:	Not required
Reducer:	Add 10% reducer by volume to RTS mixture to improved flow and leveling
Flex Additive:	4950S can be added with a mix ratio of 4:1:1

SEALERS

- ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
- ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
- 2580CR™ / 2510S™ / 2540S™ / 2570S™ LF Epoxy DTM Primer Low VOC Epoxy DTM V-
- 2910S™ / V-2940S™ / V-2970S™ LF DTM Epoxy Primer
- Cromax® Mosaic LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer
- Cromax® Pro LE LE3410S™ / LE3440S™ / LE3470S™ Urethane Primer Sealer

TOPCOATS

- ChromaPremier® Basecoat
- ChromaPremier® Single Stage
- ChromaBase® Basecoat
- Do not use with Imron® Single Stage Topcoats or Basecoats



APPLICATION

SUBSTRATES

Properly cleaned and sanded steel and galvanized
 Properly treated aluminum
 Properly sanded OEM finishes and OEM replacement parts
 Direct to Variprime® 615S™ Self-Etching Primer

SURFACE PREPARATION

- Clean surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with First Klean™ 3900S™ Surface Cleaner, Prep-Sol® 3919S™ Cleaning Solvent or 3949S™ Low VOC Cleaner. For unprimed plastic or fiberglass, wipe with Plas-Stick® 2320S™ Flexible Parts Cleaner.
- Finish sanding substrate using chart below as a guide.
- Remove sanding sludge with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer and Enamel Cleaner or 3909S™ Low VOC Surface Cleaner.

Sand and Featheredge according to the following minimum grit recommendations:

Steel:	P180 grit
Aluminum:	P240 grit, then pretreat
Galvanized:	P320 grit
E-coat:	P320 grit
Cured paint:	P320 grit
OEM featheredge:	P180 grit followed by P240 grit
Body filler:	P180 grit
2K putty:	P180-P240 grit
SMC/fiberglass:	P180-P240 grit

Note: Aluminum must be pretreated with Variprime® 615S™ Self-Etching Primer. Alternately, aluminum may be pretreated with 225S™ Aluminum Metal Cleaner and 226S™ Aluminum Conversion Coating. For steel, as an optional pretreatment step on small area repairs, apply 2 medium coats of Variprime® 615S™ Self-Etching Primer for maximum corrosion protection.

Large areas of bare steel must be pretreated with Variprime® 615S™ Self-Etching Primer for maximum corrosion protection.

Tips for Success

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.
- Allow etch primer to flash adequately before applying 4004S™ 2K Ultra Productive Primer Filler.

GUN SETUPS

Compliant	
Siphon Feed:	1.8mm-2.0mm
Gravity Feed:	1.8mm-2.0mm

HVLP	
Siphon Feed:	1.8mm-2.0mm
Gravity Feed:	1.8mm-2.0mm

AIR PRESSURE

Compliant	20-35 psi at the gun
HVLP	6-8 psi at the gun cap

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



APPLICATION

Apply 3 medium wet coats. Flash 5-10 minutes between coats.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

AIR DRY

Nib Sanding:	1 hour
Top Coating:	1 hour

FORCE DRY

Flash before Force Dry:	10 minutes.
Cycle Time:	30 minutes at 140°F (60°C)
Cool Down:	30 minutes.

INFRARED DRY

For a 1500-2000 Watt unit, cure 15 minutes at a distance of 36 inches. Allow to flash 10 minutes before applying IR. Refer to the Infrared Guide for specific setup recommendations.

Tips for Success

For optimum holdout on sensitive substrates, dry primer using infrared equipment.

RECOATABILITY/RE-REPAIR

When recoating 4004S™ 2K Ultra Productive Primer Filler with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 2 hours.

SANDING

Prior to sealing or topcoating: P400 grit DA, P500 grit dry or P600 grit wet.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	530 g/L (4.4 lbs./gal)
Max. VOC (AP):	530 g/L (4.4 lbs./gal)
Avg. Gal. Wt.:	1312 g/L (4.4 lbs./gal)
Avg. Wt.% Volatiles:	40.4%
Avg. Wt.% Exempt Solvent:	0.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	0.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	588 sq. feet per RTS gallon at 1 mil.
Recommended Dry Film Thickness:	4.5-6.0 mils in 3 coats
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/SDS 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 Canada:
1.800.668.6945
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