

DuPont™ 18530S™/18532S™ Urethane Primer

Type

DuPont™ 1853XS is a two component urethane primer

Description

DuPont™ 1853XS™ 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

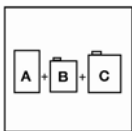
DuPont™ 1853XS™ Urethane Primer is recommended for above the water line spot repairs or priming small parts where smooth appearance and fast dry times are required. It may also be used as a sanding surfacer over properly primed or treated substrates for maximum topcoat appearance. It may be used over most aged and hard cured coatings in good condition and can be topcoated with MS600 topcoats. **DuPont™ 1853XS should not be topcoated with epoxies.** DuPont™ 18530S™ Urethane Primer – Gray can be mixed in any ratio with DuPont™ 18532S™ Urethane Primer - White to achieve various primer shades.

General Information for Use



Components

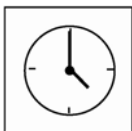
DuPont™ 18530S™ Urethane Primer - Gray
DuPont™ 18532S™ Urethane Primer - White
DuPont™ 18100S™ Urethane Activator



Mix Ratio

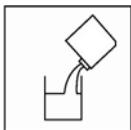
Thoroughly mix DuPont™ 18530S™ prior to activation.

<i>Two Component System</i>	<i>Parts by Volume</i>
DuPont™ 18530S™/18532S™ Urethane Primer	4
DuPont™ 18100S™ Urethane Activator	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 Accelerator
Induction Time: None



Additives

DuPont™ 18820S™ accelerator 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

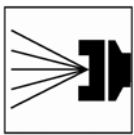
DuPont™ 18530S™ can be applied with conventional, HVLP, and electrostatic spray equipment using pressure, siphon, or gravity fluid delivery.

Conventional Fluid Tip

Pressure Pot	1.2 mm – 1.5 mm (.047" - .059")
Siphon Feed	1.2 mm – 1.5 mm (.047" - .059")
Gravity Feed	1.3 mm – 1.6 mm (.051" - .063")

HVLP

Pressure Pot	1.0 mm – 1.4 mm (.039" - .055")
Siphon Feed	1.0 mm – 1.4 mm (.039" - .055")
Gravity Feed	1.2 mm – 1.5 mm (.047" - .059")

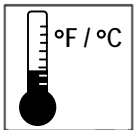


Fluid Delivery

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

Air Pressure

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



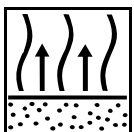
Environmental Conditions

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). DuPont™ 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™ 18530S™ with itself, sanding is required if the primer has air dried longer than 24 hours or force dried. To ensure optimum adhesion, DuPont™ 18530S™ should be topcoated within 72 hours.



Cleanup Solvents

DuPont™ 105™ Thinner or DuPont™ 106™ Thinner

Physical Properties

VOC	Less Exempts (LE)	As Packaged (AP)
DuPont™ 18530S™ / 18532S™	2.9 lbs/gal	2.3 lbs/gal
Ready-to-Spray DuPont™ 18530S™ / 18532S™	2.8 lbs/gal	2.3 lbs/gal

Factory-Packaged Clearcoat

Color	18530S™ Gray, 18532S™ White
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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Revised 8/2010

