



GENERAL INFORMATION

CPS2035 Multi-Use Direct to Metal Primer surfacer/sealer is formulated to provide the ultimate in performance, productivity, versatility, adhesion, durability, moisture and corrosion resistance, and superior sanding and sealing characteristics.



1. COMPONENTS

- CPS2035 Primer
- CPS1-5 Colorants
- DTMA2035 Activator
- X01 Exempt Reducer
- X02 Medium Exempt Reducer
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- 173 Slow Uni-Solvent 85°-95°F (29°-35°C)
- 174 Very Slow Uni-Solvent 95°F (35°C) and over
- 171HP High Performance Reducer Fast
- 172HP High Performance Reducer Medium
- 173HP High Performance Reducer Slow
- 174HP High Performance Reducer Very Slow



2. MIXING RATIO

Mix three (3) parts CPS2035 to one (1) part CPS 1-5 to create desired color then activate and reduce for desired application.

PRIMER- 4:1:1 (by volume)

Mix four (4) parts CPS2035 to one (1) part DTMA2035 activator and reduced with one (1) part solvents or reducers listed above.

USA VOC compliant rules:

For VOC 3.5 compliant use Exempt Reducers X01 or X02.

For VOC national rule use solvents or reducers listed above.

SEALER- 4:1:2 (by volume)

Mix four (4) parts CPS2035 to one (1) part DTMA2035 activator and reduced with two (2) parts solvents or reducers listed above

USA VOC compliant rules:

For VOC 3.5 compliant use Exempt Reducers X01 or X02.

For VOC national rule use solvents or reducers listed above.



3. POT LIFE @ 77°F (25°C)

45-60 Minutes



4. CLEAN UP

Uni-Solvent 171-174 or Exempt Reducers X01, X02 (check local regulations).



5. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with 155 Surface Cleaner (steel) or 170 AquaClean (steel/aluminum) and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with P320 grit sandpaper or equivalent.
- Clean surface with 155 Surface Cleaner or 170 AquaClean and wipe dry with clean cloth before product flashes.



6. SUBSTRATES

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel
- Properly cleaned and sanded fiberglass, SMC, E-Coat and OEM Finish
- Properly cleaned OEM E-Coat.



7. APPLICATION

Primer:

- Spray one to three medium wet coats
- Allow 10-15 minutes between or until surface has dulled to a matte finish
- Recommended Dry Film Thickness 1.0-4.0 mils (25-100 µm)

Sealer:

- Spray one medium coat
- Recommended Dry Film Thickness 0.6-1.0 mils (15-25 µm)

Note:

- Surface temperature should be 50-100°F (10-38°C) with less than 80% humidity preferred



7. APPLICATION (Continued)

- If primer is allowed to dry more than 24 hours before topcoating. Primer must be resanded



8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

| | PRIMER | SEALER |
|----------------------------|---------------|---------------------|
| Flash Time | 10-15 Minutes | 5-10 Minutes |
| To Sand | 60-90 Minutes | Nib Sand 20 Minutes |
| To Topcoat | 30 Minutes | 20-30 Minutes |
| To Topcoat Without Sanding | N/A | 8 Hours Maximum |



9. GUN SET UP

CONVENTIONAL GUN

| | PRIMER | SEALER |
|--------------------|-------------------------|-------------------------|
| Nozzle | 1.5-1.9 mm | 1.3-1.5 mm |
| Air Cap | 1.5-1.9 mm | 1.3-1.5 mm |
| Inlet Air Pressure | 30-45 psi (2.0-3.1 bar) | 30-45 psi (2.0-3.1 bar) |

HVLP

| | PRIMER | SEALER |
|--------------------|-------------------------|-------------------------|
| Nozzle | 1.5-1.9 mm | 1.3-1.5 mm |
| Air Cap | 1.5-1.9 mm | 1.3-1.5 mm |
| Inlet Air Pressure | 20-30 psi (1.5-2.0 bar) | 25-35 psi (1.7-2.5 bar) |

See spray gun manufacturer info



10. PHYSICAL DATA

AS SURFACER

| RTS REGULATORY DATA | 4:1:1 (Exempt Reducer Line) | | 4:1:2 (Exempt Reducer Line) | |
|--|--------------------------------|-------------|--------------------------------|-------------|
| | LBS./GAL. | g/L | LBS./GAL. | g/L |
| | Actual VOC | 2.8 Max. | 340 Max. | 2.45 Max. |
| Regulatory VOC (less water and exempt solvents) | 3.5 Max. | 420 Max. | 3.5 Max. | 420 Max. |
| Density | 9 - 13 | 1080 - 1560 | 9 - 13 | 1080 - 1560 |
| | WT. % | VOL. % | WT. % | VOL. % |
| Total Volatile Content | 35 - 50 | 55 - 70 | 40 - 60 | 60 - 75 |
| Water Content | 0 | 0 | 0 | 0 |
| Exempt Compound Content | 15 - 30 | 20 - 35 | 20 - 40 | 30 - 45 |



10. PHYSICAL DATA (Continued)

AS SEALER

| RTS REGULATORY DATA | 4:1:1 | | 4:1:2 | |
|--|--------------------|-------------|--------------------|-------------|
| | (170 Reducer Line) | | (170 Reducer Line) | |
| | LBS./GAL. | g/L | LBS./GAL. | g/L |
| Actual VOC | 4.0 Max. | 480 Max. | 4.4 Max. | 525 Max. |
| Regulatory VOC (less water and exempt solvents) | 4.2 Max. | 505 Max. | 4.6 Max. | 550 Max. |
| Density | 9 - 13 | 1080 - 1560 | 9 - 13 | 1080 - 1560 |
| | WT. % | VOL. % | WT. % | VOL. % |
| Total Volatile Content | 35 - 50 | 55 - 70 | 40 - 55 | 60 - 75 |
| Water Content | 0 | 0 | 0 | 0 |
| Exempt Compound Content | 5 - 15 | 5 - 20 | 5 - 15 | 5 - 15 |

NOTES