



## GENERAL INFORMATION

CPSDTM is a neutral-color Direct to Metal primer base formulated with a hybrid of epoxy and acrylic polymers, providing excellent adhesion, good corrosion resistance, productive dry times, and ease of sanding. CPSDTM primer emits very low amounts of Volatile Organic Compounds (VOCs), Hazardous Air Polluting Solvents (HAPS), and contains no isocyanates.



## 1. COMPONENTS

- CPSDTM Neutral Primer
- CPS 1-5 Colorants
- DTMA Activator
- 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 above
- X01 Fast Exempt Uni-Solvent



## 2. MIXING RATIO

Mix three (3) parts CPSDTM to one (1) part CPS 1-5. Mix four (4) parts CPSDTM tinted primer to one (1) part DTMA activator and reduce with one (1) part reducer as a primer, 2 parts reducer for sealing. Use X01 reducer for 2.1 VOC compliance or urethane reducers otherwise. When used as a filler, lower amounts of reducer are required.



## 3. POT LIFE @ 77°F (25°C)

2-3 hours.



## 4. CLEAN UP

Valspar Refinish 100 Thinner, VL10 Wash Thinner, or X01 Series Uni-Solvent (check local regulations).



## 5. ADDITIVES

ACCELERATOR: DO NOT USE  
FISHEYE: N/A  
FLEX ADDITIVE: Not Required

**NOTE:** Do not spray when surface temperature is below 50°F (10°C).



## 6. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with 155 Surface Cleaner (steel) or 170 (steel/aluminum) and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with 360 grit sandpaper or equivalent.
- Clean surface with 156 Surface Cleaner or 170 and wipe dry with clean cloth before product flashes.



## 7. 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.



## 8. APPLICATION

- Spray one to three medium wet coats
- Allow 10-20 minutes between coats.



## 9. FLASH / DRY TIMES

**AIR DRY @ 77°F (25°C)**

Flash between coats	10 - 20 Minutes.
To Sand	60 - 90 Minutes
To Topcoat	30 Minutes*

*Note: Reduction may accelerate flash times.*

*To Topcoat without sanding	24 Hours maximum
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## 10. GUN SET UP

### CONVENTIONAL GUN

Gravity Feed 1.6 mm - 2.0 mm  
Siphon Feed 1.8 mm - 2.0 mm



### HVLP

Gravity Feed 1.5 mm - 1.8 mm

### AIR PRESSURES

#### Conventional @ Gun

	PANEL	OVERALL
Gravity Feed	30-35 psi	40-45 psi
Siphon Feed	30-40 psi	45-55 psi
HVLP @ Cap	8-10 psi	8-10 psi



## 11. PHYSICAL DATA (4:1:1) Base Color (Reduced)

Solvent Mixed	VOC (4:1:1)
X Series Uni-Solvent	2.1 lbs./gal. (Average)
170 Series Uni-Solvent	3.2 lbs./gal. (Average)
Weight Solids	58.75% (Average)
Volume Solids	42.52% (Average)
Recommended DFT	0.5 - 4 mils.
Flash Point	-4°F