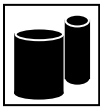




## Super Prime™ Direct to Metal Primer/Surfacer PS3121™ (White) PS3123™ (Gray) PS3125™ (Black)

READ ENTIRE PRODUCT INFORMATION SHEET PRIOR TO USE. IF ANY QUESTIONS ARISE, PLEASE CALL TECHNICAL SUPPORT.

### COMPONENTS



PS3121™ White DTM Primer/Surfacer  
 PS3123™ Gray DTM Primer/Surfacer  
 PS3125™ Black DTM Primer/Surfacer  
 PA3120M™ DTM Activator Medium  
 TH0800 Series Urethane Grade Reducer

### SPECIALTY COMPONENTS

VOC Compliant Urethane Reducers  
 PA3120S™ DTM Activator Slow

### DESCRIPTION:

Super Prime™ is a non-isocyanate, chromate-free, direct to metal primer that provides optimum adhesion with excellent corrosion protection on bare metals and OEM substrates. Super Prime™ is designed for use as a medium or high build primer-surfacer that easily sands by hand or machine. Super Prime™ offers superior color holdout and gloss retention for fast, high quality finishes.

### SURFACE PREPARATION

- **Note:** Be sure to completely remove rust or oxidation prior to applying primer. Rust and oxidation can be removed by media blasting, grinding, or sanding. Liquid metal cleaners may be used followed by the appropriate metal conditioner for optimum adhesion and corrosion protection. Be sure all surfaces are free of waxes, oils, grease or other contaminants. Wash painted surfaces and plastic parts with detergent and hot water. Clean metal and painted surfaces with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover or TH5953™ Zero VOC Waterborne Surface Cleaner. Clean bare plastics with AP100™ Plastic Cleaner before sanding.

#### Bare Substrates After proper cleaning;

- **Steel:** Finish sand with 80 - P180 grit sandpaper.
  - **Aluminum, Galvanized, Stainless Steel:** Sand with P320 grit or scuff using a red scuff pad to remove light oxidation and abrade the surface. Due to certain metal inconsistencies, we suggest using the appropriate metal conditioner for *optimum adhesion*.
  - **SMC, Fiberglass:** Finish sand with P180 to P240 grit sandpaper.
  - **Bare Plastic:** Use AP100™ Flexible Parts Cleaner and AP200™ Plastic Adhesion Promoter.
- √ **Tech Tip:** Refer to **PI SHEET #1020** for information and product use of AP100™ and AP200™.

#### Pre-painted Substrates After proper cleaning;

- **Repairs:** sand repair area and featheredge as needed, finish the featheredge with P320 grit sandpaper. Final sand the area surrounding the repair and featheredge using P400 or finer.
  - **Existing finishes:** sand with P220 to P320 grit sandpaper to remove oxidation before priming.
  - **E-coat:** scuff with P320 to P600 or a gray scuff pad.
- √ **Tech Tip:** Check for solubility by rubbing the E-coat with a rag and thinner or urethane reducer several times. If the E-coat dissolves with solvent, we recommend removing it prior to refinishing.
- Re-clean repairs with appropriate surface cleaner to remove sanding residue before priming.

## COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, aluminum, galvanized steel, fiberglass and SMC.
- Thoroughly scuffed OEM E-coat and sanded cured paint.
- Cured, sanded body filler.
- Properly prepared plastic.

**Note:** Do Not use over lacquer primer or lacquer finishes.

## MIX BY VOLUME



**As a Normal Build Surfer** Average per coat film build 1.5 mils approximately.

- 4 Part Super Prime™
- 1 Part DTM Activator
- 1/2 Part TH0800™ Series Urethane Reducer.

√ **Tech Tip:** Using the 4:1:1/2 reduction will apply easier and smoother than the 4:1 mixing ratio.

**As a High Build Surfer** Average per coat film build 2.0 mils approximately.

**Note:** Only two coats are suggested due to increased film builds, or extend dry times for a third coat.

- 4 Part Super Prime™
- 1 Part DTM Activator

**Note:** We recommend using activators within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

## TINTING

- DTM primers may be blended together to achieve various shades of the gray scale.
- No other tints or toners may be added. **Do not** mix with paint.
- See chart below for shading recommendations.

PS3121	PS3121 & PS3123 MIX 2:1	PS3121 & PS3123 MIX 1:2	PS3123	PS3123 & PS3125 MIX 2:1	PS3123 & PS3125 MIX 1:2	PS3125
Light Colors Very LT Colors Light Yellows Whites Silvers	Pastel Green Med. Yellow Light Tan Med. Silver Pastel Blue	Green Dark Silver Med. Light Tan Med. Light Red Med. Light Blue	Med. Red Med. Brown Med. Green Med. Blue Med. Gray	Dark Red Dark Brown Dark Blue Dark Green Med. Dark Gray	Dark Green Dark Blue Dark Brown Dark Red Dark Gray	Deep Dk Red Deep Dk Brown Deep Dk Green Deep Dk Blue Black

## POT LIFE



- 1 hour at 75°F/ 23°C. **Note:** Warmer temperatures will shorten pot life.
- Clean equipment immediately after use.

√ **Tech Tip:** Using the 4:1:1/2 reduction will help to increase the pot life.

## EQUIPMENT SETUP



EQUIPMENT SETUP	Fluid Tip (Normal Build)	(High Build)	Air Pressure
HVLP Gravity	1.4 – 1.6 mm	1.4 – 1.8 mm	7 – 10 PSI at the cap
HVLP Siphon	1.6 – 1.8 mm	1.6 – 2.0 mm	7 – 10 PSI at the cap
High Efficiency Gravity	1.4 – 1.6 mm	1.4 – 1.8 mm	30 – 40 (PSI) Inlet Pressure
High Efficiency Siphon	1.6 – 1.8 mm	1.6 – 2.0 mm	30 – 40 (PSI) Inlet Pressure
Conventional Gravity	1.4 – 1.6 mm	1.4 – 1.6 mm	35 – 45 (PSI) Inlet Pressure
Conventional Siphon	1.6 – 1.8 mm	1.6 – 1.8 mm	40 – 50 (PSI) Inlet Pressure

## APPLICATION AS A PRIMER



- Apply in single wet coats, allowing 5- 10-minutes flash at 75°F/ 23°C between coats.
- For normal build, apply 2-3 coats, depending on desired film build.
- For high build, we suggest 2 coats maximum. If three coats are applied, allow for overnight drying.
- Body filler may be applied 1 hour after a single coat of Super Prime™ has been applied.
- Additional heat may be applied to speed curing and drying. Allow to cool before sanding.

## Brushable / Rollable Option

- Mix according to directions. **Note:** The use of slower reducers will increase flow and leveling.

- Apply 1 even coat of Super Prime™, making sure to cover the repair area completely into the featheredge.
- Before the 2<sup>nd</sup> coat is applied, allow a 10 minute flash between coats.
- Apply the 2<sup>nd</sup> coat within the previous coats outer edge.
- For best results, do not apply more than 3 coats.

#### DRY TIME TO SAND

##### Primer Option (Allow for proper flash time between coats during application)



- Air Dry: 45 minutes to 1 hour per coat at 75°F/ 23°C. Overnight for 3 coats using high build 4:1 mix.
- Bake: 5 minute flash followed with 140°F for 30 – 40 minutes.
- Infrared short wave: 5 minute per coat air dry or low power heat), followed by a 5 minute per coat bake using full power @ 150°F.
- Final sand with P400 - P600 grit sandpaper and topcoat within 24 hours.

#### DRY TIME TO TOPCOAT

- After sanding and cleaning steps are completed.

#### FLEXIBLE PARTS

- For bare plastic repair, use AP100™ Flexible Parts Cleaner and AP200™ Plastic Adhesion Promoter. \*\*Refer to **PI SHEET #1020** for information and product use of AP100™ and AP200™.
- We suggest applying Super Prime™ mixed at a 4:1:1 ratio.
- Apply only 1 – 2 coats of primer over the repair area. Avoid excessive film builds.

#### COMPATIBLE TOPCOATS

- System 10™ Acrylic Enamel Color
- System 20™ Synthetic Enamel Color
- System 28™ 2.8 VOC Polyurethane Color
- System 50™ SkyBase® Basecoat Color
- Metalux2™ International Basecoat Color
- Polyurethane Topcoats
- Acrylic Urethane Primer-Surfacers
- System 12™ Acrylic Enamel Color
- System 22™ Acrylic Urethane Color
- System 35™ 3.5 VOC Polyurethane Color
- System 60™ 3.5VOC Polyurethane Color
- Acrylic Urethane Topcoats
- Acrylic Enamels
- Montana Branded DTM Primer/Sealer

√ **Tech Tip:** Activated basecoats offer improved chemical resistance and inter-coat adhesion.

#### SPECIAL NOTES

- Shop and surface temperatures should be maintained at or above 75°F/ 23°C for the first 24-hours of the cure cycle. Cooler temperatures may result in slower drying, curing and overall performance.
- Ensure proper metal conditioning/preparation procedures in early stages are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions are followed.
- Maintain accurate measuring during mixing.

#### Physical Data

	Mix 4:1	Mix 4:1:1/2
<b>Dry to Sand</b>	45 min. to 1 hour per coat	45 min. to 1 hour per coat
<b>Film Thickness</b>	2.0 ± .5 mils per coat	1.5 ± .4 mils per coat
<b>Volume Solids</b>	38.8%	35.2%
<b>VOC Applied</b>	4.30	4.6
<b>Theoretical Coverage RTS</b>	625 sq. ft. @ 1 mil dft	566 sq. ft. @ 1 mil dft
<b>Flash Point</b>	See MSDS	See MSDS

#### CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

**DISPOSAL**

Dispose of all paint and paint related materials in accordance with state and local regulations.

**SAFETY & HEALTH**

Read and follow all technical product information, labels, and MSDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

**MSDS REFERENCE**

Primer – MSDS #9  
Catalyst – MSDS #6  
Reducer – MSDS #1

**COMPANY INFORMATION**

ChemSpec USA  
9287 Smucker Road  
Orrville, Ohio 44667  
Toll Free: (800) 328-4892  
Fax: (330) 669-3965  
Website: [www.chemspecpaint.com](http://www.chemspecpaint.com)

**Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Material Safety Data Sheets (MSDS) supplied with the materials.  
KEEP OUT OF REACH OF CHILDREN**