



TECHNICAL DATA SHEET

RS3401 – 2.1 2K High Build DTM Primer



DESCRIPTION

RS3401 is a two component, low VOC primer surfacer. This primer offers a high film build, excellent gloss holdout, and excellent sanding characteristics.

PHYSICAL DATA

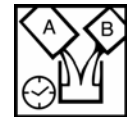
- VOC Sprayable: 1.9 lbs/gal
- Pot Life (below 90°F and 50%RH): 1 hour



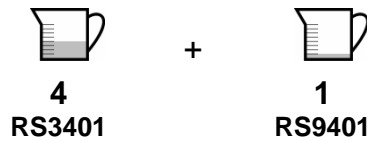
SUBSTRATES

- Properly Treated Steel*
- Treated Aluminum*
- Fiberglass / SMC
- OEM Finishes
- Refinish Lacquers, Enamels, and Urethanes
- Etching Primers

* For complete refinishing of larger bare metal areas, it is recommended to use an etch primer or metal etch, to ensure complete corrosion protection.



MIXING



APPLICATION



- Apply 2 – 3 even, full wet coats, at a gun distance of 5” – 7” inches. Allow each coat to flash to a dull finish, until necessary film build is achieved.
- HVLP = 5 – 7 psi @ cap.
- Recommended dry film thickness after sanding is 2.0 – 2.5 mils.
- Clean spray gun with an appropriate gun cleaner, immediately after use.

DRYING



Air Dry: 1 – 2 hours @ 70°F
 Force Dry: 20 – 30 minutes up to 140°F
 Short Wave Infrared: 5 minutes flash, 10 minutes on high setting @ 36” inches distance.
Note: Purge for 10 minutes before using short wave infrared.
 To sand: 90 minutes for air dry. Upon cool down for force dry and short wave infrared.

Note: Excessive film builds and cooler temperatures will extend dry times.

Final Sanding

To seal
To topcoat

Sandpaper Grit

P400*
P600*

*or equivalent