



VARIPRIME® 615S™ SELF-ETCHING PRIMER



GENERAL

DESCRIPTION

A two-component, self-etching primer designed for spot, panel and overall repairs. It is fast-drying and provides excellent corrosion resistance and direct-to-metal adhesion.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Variprime® 615S™ Self-Etching Primer
 Variprime® 614S™ Slow Converter
 Variprime® 616S™ Converter
 Variprime® 620S™ Fast Converter

Tips for Success

Keep cans closed when not in use to prevent moisture absorption, which may lead to blistering, loss of adhesion or other product failure.

MIX RATIO

Combine the components either by volume or weight (cumulative). Mix thoroughly.

Component	Volume	Weight (qt.)
615S™ Self-Etching Primer	1	554 grams
616S™ Converter	1	950 grams

VISCOSITY

17-19 seconds in a Zahn #2 cup.

POT LIFE

72 hours

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Flex Additive:	Not recommended
Retarder:	Not recommended

TINTING

Not recommended

PRIMER/SEALER

Fill 'N Sand® 131S™ Acrylic Primer Surfacer
 4004S™ Ultra Productive 2K Primer Filler
 ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler
 ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
 ChromaPremier® Pro 33430S™ Productive Primer Sealer
 ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
 ChromaPremier® Pro 44410S™ / 44440S™ / 44470S™ 2K Premier Sealer

Tips for Success

For optimum holdout and performance, VariPrime® 615S™ Self-Etching Primer must always be primed or sealed prior to topcoat application.



APPLICATION

SUBSTRATES

Properly prepared/cleaned steel, aluminum and galvanized

SURFACE PREPARATION

- Wipe surface with First Klean™ 3900S™ Surface Cleaner or Prep-Sol® 3919S™ Cleaning Solvent.
- Sand and featheredge with P180 DA grit paper followed by P240 DA grit.
- Remove sanding residue with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer and Enamel Cleaner or 3909S™ Low VOC Surface Cleaner.

GUN SETUPS*

Compliant

Siphon Feed:	1.5 mm-1.8 mm
Gravity Feed:	1.4 mm-1.6 mm

HVLP

Siphon Feed:	1.5 mm-1.8 mm
Gravity Feed:	1.3 mm-1.6 mm

AIR PRESSURE*

Compliant

Siphon Feed:	30-45 psi at the gun
Gravity Feed:	25-35 psi at the gun

HVLP

Siphon Feed:	6-8 psi at the gun cap
Gravity Feed:	6-8 psi at the gun cap

*The listed setups cover the usual range for standard application equipment.

APPLICATION

Apply 2 medium coats. Flash between coats until dull (normally 5 minutes).

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

AIR DRY

Nib Sanding:	5-10 minutes after flash (wet sanding not recommended)
Priming:	30-45 minutes
Max Allowable Dry Time:	24 hours; then sanding is required

FORCE DRY

Not recommended

Note: Variprime® 615S™ should be primed or sealed within 16 hours for best performance.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	721 g/L (6.0 lbs./gal)
Max. VOC (AP):	700 g/L (5.8 lbs./gal)
Avg. Gal. Wt.:	992 g/L (8.28 lbs./gal)
Avg. Wt.% Volatiles:	72.0%
Avg. Wt.% Exempt Solvent:	6.8%
Avg. Wt.% Water:	1.0%
Avg. Vol.% Exempt Solvent:	9.7%
Avg. Vol.% Water:	1.0%
Theoretical Coverage:	200 sq. feet per RTS gallon at 1 mil
Recommended Dry Film Thickness:	0.8-1.0 mils in 2 coats
Flash Point:	See MSDS/SDS

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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/SDS 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 appropriate ventilation, and gloves.

Revised: April 2015

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

