**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.

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
<th>Weight (qt.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>615S™ Self-Etching Primer</td>
<td>1</td>
<td>554 grams</td>
</tr>
<tr>
<td>616S™ Converter</td>
<td>1</td>
<td>950 grams</td>
</tr>
</tbody>
</table>

**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 Filler
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: January 2017