




# Axalta™ VS3200 DTM Epoxy Primer




**COMPONENTS**  
 VS3200 DTM Epoxy Primer  
 VS3201 DTM Epoxy Activator




**APPLICATION**  
 1 medium wet coat  
 2 coats for maximum protection




**MIX RATIO**  
 2 : 1



**DRY TIME**  
 Air dry @ 70-80°F (21-27°C)  
 1 coat: 30-40 minutes  
 2 coats: 60 minutes



**VISCOSITY**  
 20-22 seconds  
 #2 Zahn



**VOC**  
 250 grams / liter  
 2.1 lbs / gallon



## GENERAL

### DESCRIPTION

A 2.1 lb/gal (250 g/l) VOC compliant, non-sanding, gray epoxy primer-sealer that is formulated for maximum adhesion and corrosion resistance to properly treated surfaces.

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



## MIXING

### COMPONENTS

Axalta VS3200™ DTM Epoxy Primer (Grey)  
 Axalta VS3201™ DTM Epoxy Activator

### MIX RATIO

#### Component

Axalta VS3200 DTM Epoxy Primer  
 Axalta VS3201 DTM Epoxy Activator

#### Volume

2  
 1

### PACKAGE SIZE

VS3200 DTM Epoxy Primer: Gallon, Quart  
 VS3201 DTM Epoxy Activator: Quart

### POT LIFE

12 hours at moderate temperatures

### SPRAY VISCOSITY

20-22 seconds #2 Zahn



## APPLICATION

### SUBSTRATES

Properly sanded OEM replacement parts  
 Properly sanded or blasted steel  
 Properly cleaned or sanded aluminum, galvanized steel, or stainless steel  
 Properly sanded SMC, fiberglass, body fillers, polyester putties

### TOPCOATS

Axalta Challenger<sup>®</sup>, Duxone<sup>®</sup>, Metalux, Nason<sup>®</sup> Finishes or Nason<sup>®</sup>XL topcoats

### SURFACE PREPARATION

- Prior to sanding, remove all wax, grease, oil, and road tar with Axalta VS1000<sup>™</sup> Surface Cleaning Solvent or VS1150<sup>™</sup> Surface Cleaning Solvent Aerosol. In regulated areas use locally permitted cleaners such as VS1100<sup>™</sup> Surface Cleaning Solvent.
- Sand old finish.
- For direct to steel application as non-sanding primer, sand with 80 grit followed by 180 grit.
- For all other substrates, finish sand with 320 grit

### GUN SETUP

#### Conventional

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

#### HVLP

Siphon Feed: 1.9-2.1 mm  
 Gravity Feed: 1.4-1.5 mm

### SPRAY PRESSURE

#### Conventional

Siphon Feed: 35-45 PSI  
 Gravity Feed: 30-40 PSI at the gun

#### HVLP

Siphon Feed: 8-10 PSI at the gun cap  
 Gravity Feed: 8-10 PSI at the gun cap

### APPLICATION

Spray one medium-wet coat. For maximum corrosion resistance, apply two medium coats, allowing first coat to dry to dull finish before applying second coat.

### CLEANING OF PAINT EQUIPMENT

Use Axalta 105<sup>™</sup> Gun Cleaner, Axalta 107<sup>™</sup> Low VOC Gun & Equipment Cleaning Solvent, or any other equipment cleaner as permitted by local regulations.

### IMPORTANT NOTES

For one coat, time to topcoat is 30-40 minutes. For two coats of primer, increase dry time to topcoat to 60 minutes.



## DRY TIMES

### AIR DRY

To topcoat: 1 coat: 30-60 minutes at 70-80°F (21-27°C)  
 2 coats: 60 minutes @ 70-80°F (21-27°C)



**FORCE DRY**

20-30 minutes at 120-140°F (49-60°C)

**SANDING**

Axalta VS3200 DTM Epoxy Primer may be recoated at any stage of cure. It can be topcoated within 48 hours air dry without sanding. If VS3200 DTM Epoxy Primer is force dried, it must be sanded with P400-P600 before topcoating.




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**PHYSICAL PROPERTIES**

**All Values Ready To Spray**

Max. VOC (LE):	186 g/L (1.5 lbs./gal)
Max. VOC (AP):	85 g/L (.7 lbs./gal)
Avg. Gallon Weight:	1145 g/L (12.06 lbs./gal)
Avg. Wt.% Volatiles:	51.4%
Avg. Wt.% Water:	0.0%
Avg. Wt.% Exempt Solvent:	47.1%
Avg. Vol.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	54.1%
Flash Point:	See SDS
Theoretical Coverage, RTS:	555 ft <sup>2</sup> (51.6 m <sup>2</sup> ) at 1 mil

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**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.

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**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 SDS/MSDS 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.

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