



# 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 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.

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In the United States:  
**1.855.6.AXALTA**  
**cromax.us**

In Canada:  
**1.800.668.6945**  
**cromax.ca**

