**DuPont™ 681P34277™**

**ALKYD PRIMER**

**TYPE**
Light gray, non-sanding, lead free and chromate free alkyd primer.

**DESCRIPTION**
DuPont 681P34277™ is a medium solids non-sanding primer designed as a single package offering that is fast dry and easy to apply. DuPont 681P34277™ can be used under a variety of DuPont topcoats.

**SUGGESTED USES**
For use over properly treated substrates. Wash surface with a mild detergent. Clean and degrease substrate to remove contaminants. Treat bare metal with conditioner and conversion coating:

<table>
<thead>
<tr>
<th>CONDITIONER</th>
<th>CONVERSION</th>
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<tbody>
<tr>
<td>STEEL 5717S™</td>
<td>5718S™</td>
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<tr>
<td>ALUMINUM 225S™</td>
<td>226S™</td>
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**NOT RECOMMENDED FOR**
- Immersion service
- Stainless steel
- Do not use over galvanized metals

**COMPATIBILITY WITH OTHER COATINGS**
- Compatible with all DuPont OEM/Fleet Topcoat systems.

**DRY FILM CHARACTERISTICS**
- Chemical Resistance GOOD
- Weatherability GOOD
- Humidity Resistance GOOD

**MAXIMUM SERVICE TEMPERATURE**
- 150°F (65°C) in continuous or intermittent service.

**VOLUME SOLIDS**
- 45.3% as packaged and ready to use

**WEIGHT SOLIDS**
- 66.3% as packaged and ready to use

**WEIGHT PER GALLON**
- 11.43 lbs/gal as packaged

**SUGGESTED FILM THICKNESS**
- 1.5 – 2.0 mils dry film thickness as primer

**THEORETICAL COVERAGE PER GALLON**
- 727 sq. ft./gal @ 1 mil DFT

**GLOSS**
- Flat

**COLOR**
- Light gray

**FLASH POINT (CLOSED CUP)**
- 57°F (-7 - 23°C)

**SHELF LIFE**
- 12 months minimum

**CLEANUP SOLVENTS**
- DuPont 3602S™ Thinner or TP33364 Low HAPS Flush Solvent

**ACTIVATION (MIX RATIO)**
- No activation required.
- May be reduced up to 20% with 7285S™ (Summer) or 32030S™ (Winter).

**INDUCTION TIME**
- None required

**ADDITIONAL COMMENTS**
- Dry to topcoat or lightly scuff sand in 30 minutes.
- Formulated to comply with Rule 66 (photochemically reactive)

**POT LIFE**
- Not applicable

**APPLICATION CONDITIONS**
- Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C)
- The substrate must be at least 5°F (3°C) above the dew point
- Relative humidity should be below 90%
APPLICATION

Over Bare Metal:
- Clean metal in order to remove oils, grease and other contaminants.
- Treat metal with appropriate DuPont Metal Conditioner.
- Apply one cross-coat application technique (two passes with no flash time) to a recommended dry film thickness of 1.5 – 2.0 mils. Air pressure for pressure pot application should be between 55-65 psi at the gun.

Over Painted Surfaces:
- Clean surfaces with water and a mild detergent.
- Clean with Prep-Sol™ 3919S solvent to remove wax and other contaminants.
- Sand thoroughly.
- Remove sanding dust with DuPont 3939™.
- Apply one cross-coat application technique (two passes with no flash time) to a recommended dry film thickness of 1.5 – 2.0 mils. Air pressure for pressure pot application should be between 55-65 psi at the gun.

CURE TIME AT RECOMMENDED THICKNESS – 77°F (25°C) & 50% RH
- Dry to touch 30 min
- Dry to handle 2 – 4 hours
- Dry to topcoat 30 min
- Hard Dry 8 - 10 hrs
- Full Cure 5 days
Product may be force dried 30 min @ 140°-180°F (60-82°C).

APPLICATION EQUIPMENT
- Pressure Pot (recommended) 1.1-1.4 tip size
- Gravity Feed Gun
- Suction Spray
- HVLP

ENVIRONMENTAL
- VOC content (lbs/gal) LE AP
  DuPont 681P34277™ 3.8 3.8

FOR VOC REGULATED AREAS
These directions refer to the use of products which may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

SAFETY AND HANDLING
DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling or using. These products are for industrial use by trained professional painters only.

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.

06/09