

SelectPrime™ 421-23™ 1K Acrylic Primer-Surfacer (Gray)



GENERAL

DESCRIPTION

A 4.8 lb. /gal (580 g/l) VOC compliant, gray acrylic primer-surfacer designed to repair OEM or properly cured and prepared automotive finishes. It is fast drying, easy to use and features excellent filling properties and good topcoat holdout.

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



MIXING

COMPONENTS

SelectPrime™ 421-23™ 1K Acrylic Primer-Surfacer (Gray)
Ful-Base® 441-60™ Low VOC Reducer (Low Temp)

MIX RATIO

Component	Volume
SelectPrime™ 421-23™ 1K Acrylic Primer-Surfacer	1
Ful-Base® 441-60™ Low VOC Reducer	1

SPRAY VISCOSITY:

18-20 seconds for a Zahn #2 cup.

POT LIFE:

Not Applicable



APPLICATION

SUBSTRATES

Properly treated bare steel, galvanized steel, aluminum; properly prepared painted surfaces. Can be applied over sanded rigid plastic (excluding Polyethylene and Polypropylene).

Treat bare metal areas with SelectPrime™ 491-17™ 2K Etch Primer, Ful-Poxy® 491-16™ DTM Epoxy Primer/Sealer, Ful-Poxy® 491-35™ HS Epoxy Primer/Sealer or other Nason® etch primer or epoxy primer.

TOPCOATS

All Nason® Topcoats. However, primer must be sanded and sealed with a Nason® sealer prior to topcoating.

SURFACE PREPARATION

- Clean all surfaces with Nason® 441-05™ Silicone and Wax Remover or Nason® 481-75™ Surface Cleaner. In regulated areas use locally permitted Silicone and Wax remover or Surface Cleaner.
- Featheredge damaged areas with 180 grit paper and scuff edges around area to be filled with 320.
- Block sand and prime as necessary. Finish sand with 320 before topcoating.

SPRAY PRESSURE

Conventional

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

HVLP 8-10 PSI at the gun cap

GUN SET-UPS

Conventional

Siphon Feed: 1.8-2.2 mm
 Gravity Feed: 1.6-2.0 mm

HVLP 1.5-1.8 mm

APPLICATION

Apply 2 to 3 medium wet coats to desired film build. Flash 5-10 minutes between coats.

Tips for Success

Do not ignore flash times between coats; this prevents solvent entrapment that can cause pinholes, popping and shrinkage if flash is abused.

CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with lacquer thinner or low VOC cleaner in VOC regulated markets.

Important Notes

- For best results and maximum resistance to corrosion and humidity, prime bare metal with Ful-Poxy® 491-16™ DTM Epoxy Primer/Sealer, Ful-Poxy® 491-35™ HS Epoxy Primer/Sealer or SelectPrime™ 491-17™ 2K Etch Primer before applying SelectPrime™ 421-23™ 1K Acrylic Primer-Surfacer.
- Nason® primer-surfacer must be sanded thoroughly before application of sealer.
- Never apply heavy coats of any primer-filler in two passes of the spray gun; the flash abused primer-filler will surface dry and trap solvents. This will lead to difficult sanding (gummy), poor holdout, pinholes, or cracking.
- Never mix primer-filler in the gun cup. Always mix primer-filler in a separate container with vertical sides; strain the ready-to-spray mixture into the gun cup.



DRY TIMES

AIR DRY

To sand: 20-30 minutes at 70°F (21°C)

FORCE DRY

To sand: 15 minutes at 110°F (43°C)

Lower temperatures may require longer flash times.



SANDING

Must be sanded prior to sealing, or topcoating.

Single-stage topcoat: P-320 grit
 Basecoat: P-500 to P-600 grit



PHYSICAL PROPERTIES

All Values Ready To Spray

Max VOC (LE):	4.6 lb/gal (548 g/l)
Max VOC (AP):	2.3 lb/gal (274 g/l)
Avg. Gal. Wt.:	8.82 lbs./gal (1057 g/L)
Avg. Wt.% Volatiles:	63.4%
Avg. Wt.% Exempt Solvent:	37.5%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	50.0%
Avg. Vol.% Water:	0.0%
Recommended Dry Film Thickness:	1-4 mils in 2-4 coats
Flash Point:	See SDS/MSDS
Theoretical Coverage:	292 ft ² (27.1 m ²) per RTS gallon at 1 mil.

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 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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In the United States:
1.855.6.AXALTA
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In Canada:
1.800.668.6945
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