

# SelectPrime™ 421-30™ 1K Acrylic Lacquer Primer (Gray)



## GENERAL

### DESCRIPTION

A 2.1 lb. /gal (250 g/l) VOC compliant, highly pigmented primer-surfacer that flows evenly with little to no shrinkage and is non-settling. 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™ 421-30™ 1K Acrylic Lacquer Primer (Gray)  
Ful-Base® 441-60™ Low VOC Reducer (Low-Temp)

### MIX RATIO

Combine the components by volume (1:1). Mix thoroughly prior to activation.

| Component                                      | Volume |
|--|--------|
| SelectPrime™ 421-30™ 1K Acrylic Lacquer Primer | 1      |
| Ful-Base® 441-60™ Low VOC Reducer              | 1      |

Never mix primer-filler in the gun cup. Always mix primer-filler in a separate container with vertical sides. Strain the RTS mixture into the gun cup.

### POT LIFE

Not applicable.

### SPRAY VISCOSITY

10-15 seconds in a Zahn #2



## APPLICATION

### SUBSTRATES

- Properly treated bare steel, galvanized steel, aluminum
- Properly prepared painted surfaces.
- Can be applied over sanded rigid plastic (excluding polyethylene and polypropylene)

Prime bare metal areas with Ful-Poxy® 491-10™ DTM Epoxy Primer/Sealer, SelectPrime™ 491-55™ 2K Chrome-Free Etch Primer or other locally permitted Nason® etch primer or epoxy primer.

### TOPCOATS

All Nason® topcoats. Universal primer-surfacer must be sealed 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.

**GUN SETUP**

**Conventional**

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

HVLP 1.5-1.8 mm

**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

**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.
- Universal Primer-Surfacer must be sealed prior to topcoating.

**SANDING**

Must be sanded prior to sealing.

- P-320 grit for single-stage topcoats
- P-400 to P-600 grit for basecoat topcoats

**CLEANING OF PAINT EQUIPMENT**

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



**DRY TIMES**

**AIR DRY**

20-30 minutes at 70°F (21°C)

**FORCE DRY**

15 minutes at 110°F (43°C)

Lower temperatures may require longer flash times.



**PHYSICAL PROPERTIES**

**All Values Ready To Spray**

|                                 |   |
|---------------------------------|---|
| Max. VOC (LE):                  | 246 g/L (2.0 lbs./gal)                              |
| Max. VOC (AP):                  | 74 g/L (.6 lbs./gal)                                |
| Avg. Gal. Wt.:                  | 1052 g/L (8.78 lbs./gal)                            |
| Avg. Wt.% Volatiles:            | 59.6%   |
| Avg. Wt.% Exempt Solvent:       | 52.6%   |
| Avg. Wt.% Water:                | 0.0%  |
| Avg. Vol.% Exempt Solvent:      | 69.9%   |
| Avg. Vol.% Water:               | 0.0%  |
| Recommended Dry Film Thickness: | 1-4 Mils in 2-4 coats                               |
| Flash Point:                    | See SDS/MSDS  |
| Theoretical Coverage:           | 376 ft <sup>2</sup> (34.9 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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In the United States:  
**1.855.6.AXALTA**  
**nasonfinishes.com**

In Canada:  
**1.800.668.6945**  
**nasonfinishes.ca**

