

Ful-Poxy[®] 491-16[™] DTM Epoxy Primer/Sealer



GENERAL

DESCRIPTION

A 4.8 lb/gal (580 g/l) VOC compliant, non-sanding, gray epoxy primer formulated for maximum adhesion and corrosion resistance to properly prepared substrates.

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



MIXING

MIX RATIO

Component	Volume
Ful-Poxy [®] 491-16 [™] DTM Epoxy Primer/Sealer	1
Ful-Poxy [®] 483-19 [™] Epoxy Activator	1

INDUCTION PERIOD

Above 70°F (21°C):	30 minutes
Below 70°F (21°C):	60 minutes

SPRAY VISCOSITY

16-22 seconds in a #2 Zahn

POT LIFE

24 hours at moderate temperatures



APPLICATION

SUBSTRATES

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

Any refinishing systems

SURFACE PREPARATION

- Prior to sanding, remove all wax, grease, oil, and road tar with Nason[®] 441-05[™] Wax and Grease Remover or Nason[®] 481-75[™] Surface Cleaner. In regulated areas use locally permitted cleaners.
- Sand old finish.
- For Aluminum: Wash with detergent, rinse and dry well. Clean with Nason[®] 441-05[™] Wax and Grease Remover or Nason[™] 481-75[™] Surface Cleaner or locally permitted cleaner.

GUN SETUP

Conventional

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

HVLP

Siphon Feed:	1.5-1.8 mm
Gravity Feed:	1.5-1.6 mm

SPRAY PRESSURE

Conventional

Siphon Feed:	30-45 PSI
Gravity Feed:	30-40 PSI at the gun
Pressure Feed:	1.2 mm fluid tip, 35-40 PSI at the gun (fluid flow: 14-16 oz/minute)

HVLP

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

APPLICATION

Spray one full, wet coat. For maximum corrosion resistance, two medium coats may be applied.

CLEANING OF PAINT EQUIPMENT

Use Cromax® 105™ Gun Cleaner, Cromax® 107™ Low VOC Gun & Equipment Cleaning Solvent, or any other equipment cleaner as permitted by local regulations.

IMPORTANT NOTES:

- Activator and primer must be thoroughly mixed and allowed to induct for satisfactory performance.
- DO NOT USE if shop temperature is less than 50°F (10°C).



DRY TIMES

AIR DRY

To topcoat:	1 hour at 70-80°F (21-27°C)
To sand:	Overnight

FORCE DRY

20-30 minutes at 120-140°F (49-60°C)

SANDING

Ful-Poxy® 491-16™ DTM Epoxy Primer/Sealer may be recoated at any stage of cure. It can be topcoated within 24 hours air dry without sanding. If Ful-Poxy® 491-16™ DTM Epoxy Primer/Sealer is baked it must be sanded with P400-P600 before topcoating



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	4.7 lbs./gal (567 g/L)
Max. VOC (AP):	4.3 lbs./gal (518 g/L)
Avg. Gal. Wt.:	9.54 lbs./gal (1143 g/L)
Avg. Wt.% Volatiles:	51.2%
Avg. Wt.% Exempt Solvent:	5.9%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	8.5%
Avg. Vol.% Water:	0.0%
Recommended Dry Film Thickness:	0.7-1.0 mils
Flash Point:	See SDS/MSDS
Theoretical Coverage, RTS:	517 ft ² (48 m ²) 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
nasonfinishes.com

In Canada:
1.800.668.6945
nasonfinishes.ca

