

Nason® 491-21™ Oxide & 491-22™ Gray Machinery & Equipment Primer



GENERAL

DESCRIPTION

A one-component, fast drying, corrosion resistant, lead and chromate free primers formulated for use on machinery & equipment. 491-21™ & 491-22™ can be used under any single-stage topcoat or used as a “shopcoat” or “onecoat” system to inhibit corrosion during transport and construction.

TYPE

Acrylic modified medium oil alkyd primer.

SUGGESTED USE:

- Shopcoat primer
- Intermediate coat
- General machinery and equipment

NOT RECOMMENDED FOR:

- Immersion service
- Application over inorganic zinc
- Galvanized surfaces
- Severe chemical environments
- Use under damp insulation

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



MIXING

COMPONENTS

491-21™ Oxide Machinery & Equipment Primer
 491-22™ Gray Machinery & Equipment Primer

MIX RATIO

Ready to spray.

Primer can be reduced with Ful-Base® 441-20™, 441-21™ or 441-22™ Reducers. Any thinning will eliminate compliance with VOC limitation of 3.5 lbs/gal.

VISCOSITY

65-85 KU

POTLIFE

Indefinite



APPLICATION

COMPATIBILITY W/ OTHER COATINGS

- Can be applied directly to steel or over most old coatings in good condition
- Can be topcoated with alkyd, acrylic and polyurethane coatings

SURFACE PREPARATION

A commercial blast to an SSPC-SP-6 specification is highly desired. If this is not possible, then hand clean to an SSPC-SP-2 specification or power tool clean to an SSPC-SP-3.

ADDITIONAL COMMENTS

Colors will vary by batch. If using more than 1 batch on a job, blend materials to transition from the first batch to the next batch.

APPLICATION CONDITIONS

Do not apply when application surface temperature is below 40°F (4°C) or higher than 110°F (43°C) or when the atmospheric temperature is within 5°F of the dew point. Relative humidity should be below 90%.

APPLICATION EQUIPMENT

Apply by spray for best results. Small area can be touched up by brush. Manufacturers listed below are a guide, others may be used. Changes in pressure and tip size may be required to achieve proper application.

Conventional Airspray

	Binks 2001	Devillbiss JGA	Sata K3rp
Fluid Nozzle	63BSS	FF(1.4)	1.1
Air cap	63 PB	765	

Airless Spray

Pump	Graco Extreme 33.1
Fluid Hose	3/8" x 100'
Airless Gun	Graco 208663
Tips	413-419
Minimum Pressure to Avoid Fingering	2400 psi

CLEAN UP THINNERS

Use Nason® 481-06™ Lacquer Thinner or Nason® SelectThinner™ 481-16™. Refer to appropriate Air Quality District requirements for proper use of equipment and solvent.



DRY TIMES

77°F (25°C) AND 50% RH

Dry to Touch:	30 min
Dry to Handle:	60 minutes
Dry to Recoat:	30 minute
Hard Dry:	48 hours



PHYSICAL PROPERTIES

All Values Ready To Spray – No reduction

Max. VOC (LE):	412 g/L (3.4 lbs./gal)
Max. VOC (AP):	412 g/L (3.4 lbs./gal)
Avg. Gallon Weight:	1447 g/L (12.07 lbs./gal)
Avg. Weight % Volatiles:	28.5%
Avg. Weight % Exempt Solvent:	0.0%
Avg. Weight % Water:	0.0%
Avg. Volume % Exempt Solvent:	0.0%
Avg. Volume % Water:	0.0%
Theoretical Coverage:	827 ft ² /gal at 1 mil
Recommended Dry Film Thickness:	2 mil
Flash Point:	See MSDS
Shelf life:	12 months

DRY FILM CHARACTERISTICS

Weather:	Very good
Humidity:	Good
Chemical:	Fair, with appropriate topcoat

MAXIMUM SERVICE TEMPERATURE

200°F (93°C)

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C)

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
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