



1220S™ URO® Primer



GENERAL

DESCRIPTION

A two-component, fast drying, easy-to-sand urethane primer-filler that delivers good filling properties.

SUGGESTED USES

For use with:

Properly cleaned and sanded cured finishes and fiberglass gelcoat substrates

Metalok Adhesion Promoter 230S™

Metalok Pretreatment Coatings 250S™ and 235S™

Properly cleaned and chemical treated metal substrates

COMPATIBLE COATINGS

Compatible with all Axalta Transportation topcoat systems.

NOT RECOMMENDED FOR

Immersion service and marginally treated metal substrates.

DRY FILM CHARACTERISTICS

| | |
|--|-----------|
| Chemical Resistance | VERY GOOD |
| Humidity Resistance over treated substrate | EXCELLENT |
| Weatherability with appropriate topcoat | EXCELLENT |
| Adhesion | EXCELLENT |
| Alkali Resistance | EXCELLENT |
| Solvent Resistance | EXCELLENT |

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



MIXING

MIX RATIO

Thoroughly mix prior to activation. The use of a Cyclone® shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

| Component | Volume |
|-----------------------------------|--------|
| 1220S™ Primer | 4 |
| 194S™, 294S™ or 15305S™ Activator | 1 |

ADDITIVES

Extend pot life and improve dry time:

Add up to 2 oz. of 389S™ Accelerator per activated gallon

Increased cure:

Add up to 1 oz. 8989S™ Accelerator per activated gallon

INDUCTION TIME

No induction is required.

POT LIFE - 70°F (21°C)

1 hour as activated

2 hours with 389S™ Accelerator

45 minutes with 8989S™ Accelerator



APPLICATION

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 EQUIPMENT

Refer to spray equipment documentation for setting recommendations.
Pressure Pot
Gravity Feed(recommended)
Siphon Gun
Airless Spray
Air Assisted Airless

APPLICATION

- Pressure pot application is recommended to provide the best atomization and delivery. Fluid delivery is recommended at 10-12 fluid oz/min.
- 1220S™ builds at approximately 0.8-1.0 mils per pass with a recommended equipment setup.
- Apply using a cross-coat technique, top-to-bottom, and then side-to-side. Each coat should be medium-wet. No flash time is required between coats.
- Axalta topcoats can be applied wet on wet over 1220S™ after a 1 hour flash time (2 hrs. for maximum holdout).
- Paint heaters can help provide a smoother appearance by controlling the temperature and viscosity of the product, especially under adverse or changing conditions.



DRY TIMES

AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

| | |
|---------------|---------------|
| Dry to touch: | 30-45 minutes |
| Tack free: | 1-2 hours |
| Print free: | 2-3 hours |

Note: Product must be sanded if force dried or allowed to dry for more than 16 hours.

FORCE DRY

30 min at 160-180°F (71-82°C)

APPLICATION SOLVENTS

Ready-to-spray below 3.5 lbs. /gal VOC upon activation. Further reduction may result in greater than 3.5 lbs. /gal VOC.

CLEANUP SOLVENTS

130™ Acetone
105™ Lacquer Thinner
107™ Low VOC Gun Cleaner
108™ Low HAPS Cleaning Solvent



PHYSICAL PROPERTIES

| | |
|------------------------------------|--|
| Maximum Service Temperature: | 200°F (92°C) in continuous service 300°F (148°C) in intermittent heat |
| Weight Per Gallon (component only) | 10.81 lbs. |
| Weight Per Liter (component only) | 1295 grams |
| Suggested Dry Film Thickness | 1.6 – 2.0 mils |
| Gloss | Satin |
| Color | Gray |
| Flash Point (Closed Cup) | See MSDS/SDS |
| Shelf Life | 12 months minimum |

RTS mixed 4:1 with: Includes 389S

| | 194S | 294S | 15305S |
|--|---|---|---|
| Gallon Weight pounds per gallon | 10.42 | 10.42 | 10.38 |
| Gallon Weight grams per liter | 1249 | 1249 | 1243 |
| VOC AP pounds per gallon | 3.0 | 3.0 | 2.8 |
| VOC AP grams per liter | 359 | 359 | 341 |
| VOC LE pounds. per gallon | 3.3 | 3.3 | 3.3 |
| VOC LE grams per liter | 400 | 400 | 397 |
| Weight Solids | 64.8% | 64.8% | 63.1% |
| Volume Solids | 47.9% | 47.9% | 45.8% |
| Weight Volatiles | 35.2% | 35.2% | 36.9% |
| Weight Water | 0.0% | 0.0% | 0.0 |
| Volume Water | 0.0% | 0.0% | 0.0 |
| Weight Exempt Solvents | 6.5% | 6.5% | 9.5 |
| Volume Exempt Solvents | 10.2% | 10.2% | 14.2 |
| Theoretical Coverage per RTS Gallon at 1 mil DFT | 769 ft ² (71.4 m ²) | 769 ft ² (71.4 m ²) | 735 ft ² (68.3 m ²) |

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 MSDS/SDS 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
axalta.us

In Canada:
1.800.668.6945
axalta.ca

