



# 373P23290™ Flexible Weatherable Primer



## GENERAL

### DESCRIPTION

A two-component, low VOC, lead- and chrome-free, flexible weatherable urethane primer recommended for plastic and fiberglass substrates. It is designed to deliver maximum performance properties and provide outstanding impact and chip resistance.

### SUGGESTED USES

For use over properly treated, non-ferrous substrates as fiberglass and plastic. May also be used over properly treated metal substrates such as aluminum and steel. This weatherable primer can be topcoated or used without topcoat.

### COMPATIBLE COATINGS

Compatible with all Axalta Transportation primer and topcoat systems.

### NOT RECOMMENDED FOR

Immersion service and marginally treated ferrous substrates.

### DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Humidity Resistance	EXCELLENT
Weatherability with appropriate topcoat	EXCELLENT
Acid Resistance	EXCELLENT
Alkali Resistance	EXCELLENT
Solvent Resistance	VERY GOOD

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.

### COMPONENTS

	Volume
373P23290™ Primer	4
Imron® 194S™ 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
- 1 hour with 8989S™ Accelerator



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## 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 (recommended)

Gravity Feed Gun

Siphon Gun

Air Assisted Airless

Airless Spray

### APPLICATION

- Pressure pot application is recommended to provide the best atomization and delivery. Fluid delivery is recommended at 10-12 fluid oz/min.
- Apply using a cross-coat technique, top-to-bottom, and then side-to-side. Each coat should be medium-wet with no flash between coats.
- Paint heaters can help provide a smoother appearance by controlling the temperature and viscosity of the product.

### APPLICATION SOLVENTS

Ready-to-spray below 3.5 lb/gal (420 g/l) VOC upon activation. Further reduction may result in greater than 3.5 lb/gal (420 g/l) VOC.

### CLEANUP SOLVENTS

3602S™ Lacquer Thinner

106™ Lacquer Thinner

107™ Low VOC Gun Cleaner

108™ Low HAPS Cleaning Solvent



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## DRY TIMES

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

### AIR DRY

With 2 oz. /gal. 389S™ Accelerator

Dry to Touch:	4 hours
Tack Free:	6 hours
Dry to Sand:	8 hours
Dry to Topcoat:	2 hours

### FORCE DRY

30 min at 180°F (82°C)

60 min at 140°F (60°C)

90 min at 100°F (38°C)

### RECOAT

When recoating with itself, scuff sanding is required if the primer has been allowed to dry more than 30 days. For optimum appearance sand with 320 grit or finer until smooth.



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## PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	10.26 lbs.



Weight Per Liter (component only)	1230 grams
Suggested Dry Film Thickness	1.3-1.7 mil when used as a primer 1.8-2.2 mil when used as a topcoat
Gloss	Flat
Color	Gray
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

**RTS mixed 4:1 with:  
Includes 389S**

	<b>194S</b>
Gallon Weight pounds per gallon	9.99
Gallon Weight grams per liter	1197
VOC AP pounds per gallon	3.0
VOC AP grams per liter	363
VOC LE pounds. per gallon	3.4
VOC LE grams per liter	406
Weight Solids	62.7%
Volume Solids	46.4%
Weight Volatiles	37.3%
Weight Water	0.0%
Volume Water	0.0%
Weight Exempt Solvents	6.9%
Volume Exempt Solvents	10.5%
Theoretical Coverage per RTS Gallon at 1 mil DFT	744 ft <sup>2</sup> (69.1 m <sup>2</sup> )

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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 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:  
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