



Rival™ RV450™ Epoxy Primer



GENERAL

DESCRIPTION

A 3.5 lb/gal (420 g/l) VOC compliant, high solids, non-sanding, epoxy primer-sealer formulated for maximum adhesion and corrosion resistance to properly treated substrates.

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 Axalta commercial transportation topcoat products.

NOT RECOMMENDED FOR

Immersion service and marginally treated metal substrates

DRY FILM CHARACTERISTICS

Chemical Resistance	VERY GOOD
Humidity Resistance over treated substrate	VERY GOOD
Weatherability with appropriate topcoat	VERY GOOD
Adhesion	VERY GOOD
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
RV450™ Primer	4
RV455™ Activator	1

INITIAL APPLICATION VISCOSITY

14-16 seconds in a #3 Zahn

INDUCTION TIME

No induction is required

POT LIFE - 70°F (21°C)

4 hours



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
- 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.
- Spray one full wet coat. For maximum corrosion resistance, two medium wet coats may be applied in a cross-coat application, achieving recommended 2-3 mils dry film thickness
- No flash is necessary between cross coats
- For increased build, apply a single pass with 10 minutes flash. This is followed by a cross-coat application as above (3-4 mils DFT).
- Topcoat can be applied wet on wet over RV450 after a 1 hour flash time.

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

ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel



DRY TIMES

AIR DRY

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

- | | |
|-------------|-----------------|
| To Topcoat: | 60 - 90 minutes |
| To Sand: | Overnight |

If more than 2 mil DFT (~4 mil wet) is applied, additional flash time is required. Product must be sanded if allowed to dry for more than 72 hours.

FORCE DRY

30 minutes at 140-160°F (60-71°C)

Note: Product must be sanded if force dried or allowed to dry for more than 72 hours. 30 min at 140-180°F (60-82°C)



PHYSICAL PROPERTIES

- | | |
|------------------------------------|--|
| Maximum Service Temperature: | 200°F (92°C) in continuous service
300°F (148°C) in intermittent heat |
| Weight Per Gallon (component only) | 12.02 lbs. |
| Weight Per Liter (component only) | 1440 grams |



Suggested Dry Film Thickness	2.0 – 3.0 mils
Gloss	Satin
Color	Gray
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

RTS mixed 4:1 with:	RV455
Gallon Weight pounds per gallon – Average	11.14
Gallon Weight grams per liter – Average	1335
VOC AP pounds per gallon – Maximum	2.7
VOC AP grams per liter – Maximum	327
VOC LE pounds. per gallon - Maximum	3.1
VOC LE grams per liter – Maximum	375
Weight Solids – Average	68.0%
Volume Solids – Average	48.0%
Weight Volatiles – Average	32.0%
Weight Water – Average	0.0%
Volume Water – Average	0.0%
Weight Exempt Solvents – Average	8.0%
Volume Exempt Solvents – Average	13.0%
Theoretical Coverage per RTS Gallon at 1 mil DFT	776 ft ² (72.5 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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