



# FILL'N SAND® 131S™ ACRYLIC PRIMER SURFACER



## GENERAL

### DESCRIPTION

An acrylic primer-surfacer designed for spot and small repairs. It is fast-drying and easy to use.

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



## MIXING

### COMPONENTS

Fill 'N Sand® 131S™ Acrylic Primer Surfacer Gray  
32030S™ Acetone

### MIX RATIO

Component	Volume
131S™ Acrylic Primer Surfacer Gray	1
32030S™ Acetone	1

### VISCOSITY

18-20 seconds in a Zahn #2 cup.

### POT LIFE

Indefinite

### ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not recommended
Flex Additive:	Not recommended
Retarder:	Not required

### TINTING

Not recommended

### TOPCOATS

ChromaBase® Basecoat



## APPLICATION

### SUBSTRATES

Properly treated steel  
Properly sanded OEM finishes and OEM replacement parts  
Direct to Variprime® 615S™ Self-Etching Primer

### SURFACE PREPARATION

- Clean painted surface thoroughly with mild detergent.
- For substrates other than unprimed plastic or fiberglass, wipe surface with First Klean™ 3900S™ Surface Cleaner, Prep-Sol® 3919S™ Cleaning Solvent, 3949S™ Low VOC Cleaner.
- For unprimed plastic or fiberglass, refer to the ChromaSystem™ procedures for preparing plastic or fiberglass parts. Sand and featheredge with P180 DA grit paper, followed by P240 DA grit paper.
- Remove sanding sludge with Final Klean™ 3901S™ Surface Cleaner, 3939S™ Lacquer



and Enamel Cleaner, 3909S™ Low VOC Surface Cleaner.

- Over bare metal, apply 2 coats of Variprime® 615S™ Self-Etching Primer or treat steel and galvanized with 5717S™ Metal Conditioner and 5718S™ Steel and Galvanized Conversion Coating.
- Treat aluminum with 225S™ Aluminum Metal Cleaner and 226S™ Aluminum Conversion Coating.

**GUN SETUPS\***

Compliant

Siphon Feed: 1.8 mm-2.2 mm  
Gravity Feed: 1.6 mm-2.0 mm

HVLP

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

**AIR PRESSURE\***

Compliant

Siphon Feed: 35-45 psi at the gun  
Gravity Feed: 30-40 psi at the gun

HVLP

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

\*The listed setups cover the usual range for various application equipment.

**APPLICATION**

Apply 2-4 medium coats.

**Tips for Success**

Fill 'N Sand® 131S™ Acrylic Primer Surfacer is not recommended over flexible plastic parts.

**CLEANUP**

Clean spray equipment as soon as possible with lacquer thinner.




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**DRY TIMES**

**AIR DRY**

Flash between Coats: 5-10 minutes  
Wet Sanding: 20-30 minutes  
Dry Sanding: 20-30 minutes

**FORCE DRY**

Flash before Force Dry: 5-10 minutes  
Cycle Time: 15 minutes at 110°F (43°C)

**INFRARED DRY**

Refer to the Infrared Guide for setup recommendations

**RECOATABILITY/RE-REPAIR**

Fill 'N Sand® 131S™ Acrylic Primer Surfacer can be sanded or recoated at any stage of dry.

**SANDING**

Prior to sealing, sand with P400 DA grit paper or P500 dry or wet



## PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC(LE):	551 g/L (4.6 lbs./gal)
Max. VOC(AP):	273 g/L (2.3 lbs./gal)
Avg. Gal. Wt.:	1056 g/L (8.81 lbs./gal)
Avg. Wt.% Volatiles:	63.4%
Avg. Wt.% Exempt Solvent:	37.5%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	50.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	292 sq. feet per RTS gallon at 1 mil.
Recommended Dry Film Thickness:	1-4 mils in 2-4 coats.
Flash Point:	See MSDS/SDS

## 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**  
**cromax.us**

In Canada:  
**1.800.668.6945**  
**cromax.ca**

