

SelectPrime™ 421-10™ / 421-11™ / 421-12™ 2K DTM Urethane Primer



GENERAL

DESCRIPTION

A 2.1 lb. /gal (250 g/l) VOC compliant, 2K urethane, direct to metal primer-filler designed to provide high build and an exceptionally free sanding film without shrinkage or sand scratch swelling. When modified as a sealer, it is easily applied, offers good hold out and lays down smooth for excellent topcoat appearance. It is available in white, gray and black.

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



MIXING

COMPONENTS

SelectPrime™ 421-10™ 2K DTM Urethane Primer (Gray)
 SelectPrime™ 421-11™ 2K DTM Urethane Primer (White)
 SelectPrime™ 421-12™ 2K DTM Urethane Primer (Black)
 SelectPrime™ 483-03™ 2K Urethane Activator
 Optional Sealer Modifier: Nason 401-75™ / 401-85™ Primer to Sealer Modifier

MIX RATIO AS A PRIMER

Combine the components by volume (4:1). Mix thoroughly prior to activation.

Component	Volume
SelectPrime™ 421-1X™ 2K DTM Urethane Primer	4
SelectPrime™ 483-03™ 2K Urethane Activator	1

Tips for Success:

Use Nason® 3-NA371 mixing stick and a cup with vertical sides for accurate measurements

MIX RATIO AS A SEALER

Combine the components by volume (3:1:2). Mix thoroughly prior to activation.

Component	Volume
SelectPrime™ 421-1X™ 2K DTM Urethane Primer	3
SelectPrime™ 483-03™ 2K Urethane Activator	1
Nason® 401-75™ / 401-85™ Primer to Sealer Modifier	2

Tips for Success:

Use Cromax® M-6435 mixing stick and a cup with vertical sides for accurate measurements

TINTABILITY

Not recommended.

POT LIFE

1 hour at 70°F (21°C) at 50% Relative Humidity

SPRAY VISCOSITY

As a primer: 11-13 seconds in a ZAHN #3

As a sealer: 15-19 seconds in a ZAHN #2



APPLICATION

SUBSTRATES

Properly treated bare steel, aluminum, and fiberglass
Thoroughly sanded, painted surfaces

Note: For the ultimate corrosion protection prime bare metal areas with Ful-Poxy® 491-10™ DTM Epoxy Primer/Sealer, SelectPrime™ 2K 491-55™ Chrome-Free Etch Primer or other locally permitted Nason® etch primer or epoxy primer.

TOPCOATS

All locally permitted Nason® Topcoats.

SURFACE PREPARATION

Clean surface thoroughly with mild detergent and water. For substrates other than plastic or fiberglass, wipe surface with Nason® 441-05™ Wax and Grease remover, 481-75™ Surface Cleaner or locally permitted cleaner.

Tips for Success For Primer

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes.
- Finish sensitive substrates in P320 grit.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.

SPRAY PRESSURE

HVLP: 7-9 PSI

GUN SETUP

HVLP for primer: 1.7-1.9 mm
HVLP for sealer: 1.3-1.4 mm

APPLICATION

As a primer: Apply 2 to 3 medium wet coats to achieve desired film build. Flash 8-10 minutes between coats.

As a sealer: Apply 1 medium wet coat. Flash 20 minutes prior to topcoat. Maximum 2 hour flash without sanding or scuffing.

Tips for Success For Primer

- Do not ignore flash times between coats. This prevents solvent entrapment that can cause pinholes, popping and shrinkage.
- Never apply heavy coats of any primer-filler in two passes of the spray gun; the flash abused primer-filler will surface dry and trap solvents. This will lead to difficult sanding (gummy), poor holdout, pinholes, or cracking.
- Never mix primer-filler in the gun cup. Always mix primer-filler in a separate container with vertical sides; strain the ready-to-spray mixture into the gun cup.

Tips for Success For Sealer

- Do not apply heavy coats of the sealer.

CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with lacquer thinner or low VOC cleaner in VOC regulated markets.



DRY TIMES

AIR DRY

To sand: Primer: 2-3 hours at 70°F (21°C) Sealer: 20-30 min at 70°F (21°C)

FORCE DRY

To sand: Primer: 30 minutes at 140°F (60°C) Sealer: 10 min at 110°F (43°C)

Lower temperatures may require longer dry times.

SANDING FOR PRIMER

Must be sanded prior to sealing or topcoating.
 P-320 to P-400 grit for single stage topcoats
 P-400 to P-600 grit for basecoats

SANDING FOR SEALER

No sanding required unless it is allowed to dry for more than two hours. If it has dried more than two hours, scuff, and then topcoat.



PHYSICAL PROPERTIES

All Values Ready To Spray

Nason® 421-1X	Primer Recommendation	Sealer Recommendation
Max. VOC (LE)	244 g/L (2.0 lbs./gal)	243 g/L (2.0 lbs./gal)
Max. VOC (AP)	143 g/L (1.2 lbs./gal)	125 g/L (1.0 lbs./gal)
Avg. Gal. Wt.	1523 g/L (12.71 lbs./gal)	1402 g/L (11.70 lbs./gal)
Avg. Wt.% Volatiles	43.4%	54.4%
Avg. Wt.% Exempt Solvent	35.7%	45.4%
Avg. Wt.% Water	0.0%	0.0%
Avg. Vol.% Exempt Solvent	41.6%	49.1%
Avg. Vol.% Water	0.0%	0.0%

Recommended Dry Film Thickness: 5 mils in 3 coats
 Flash Point: See SDS/MSDS
 Theoretical Coverage: 681 ft² (63.2 m²) at 1 mil

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
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In Canada:
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