

SelectPrime™ 491-55™ 2K Chrome-Free Etch Primer



GENERAL

DESCRIPTION

A 5.5 lb/gal (660 g/l) VOC compliant, non-sanding, chrome free etch primer that provides exceptional adhesion and corrosion resistance over bare metal. It eliminates the need to chemically pretreat metal surfaces before priming.

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



MIXING

COMPONENTS

SelectPrime™ 491-55™ 2K Chrome-Free Etch Primer
SelectPrime™ 441-55™ Activator-Reducer

MIX RATIO

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

Component	Volume
SelectPrime™ 491-55™ Chrome-Free Etch	2
SelectPrime™ 441-55™ Activator-Reducer	1

INDUCTION

Not required

POT LIFE

8 hours at 70°F (21°C)



APPLICATION

SUBSTRATES

Bare metal, steel, aluminum, galvanized, featheredged old paint.

TOPCOATS

Etch primer may be used under any Nason® primer-surfacer or sealer to improve corrosion performance. SelectPrime™ 491-55™ Chrome-Free Etch Primer must be followed with a primer-surfacer or Sealer prior to topcoating.

SURFACE PREPARATION

Before sanding, wash with soap and water and remove wax and grease with locally permitted cleaner.

GUN SETUP

Conventional

Siphon Feed:	1.4-1.6 mm
Gravity Feed:	1.3-1.6 mm

HVLP

Siphon Feed:	1.6-1.8 mm
Gravity Feed:	1.3-1.6 mm

SPRAY PRESSURE

Conventional

Siphon Feed: 30-45 PSI
 Gravity Feed: 25-40 PSI

HVLP: 6-8 PSI

APPLICATION

Spray one medium wet coat.

CLEANING OF PAINT EQUIPMENT

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



DRY TIMES

To primer-surfacer or sealer: Allow to tack 20 to 30 minutes

If allowed to air dry more than 8 hours, sand and recoat with 491-55™.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	642 g/L (5.4 lbs./gal)
Max. VOC (AP):	280 g/L (2.3 lbs./gal)
Avg. Gal. Wt.:	930 g/L (7.76 lbs./gal)
Avg. Wt.% Volatiles:	84.8%
Avg. Wt.% Exempt Solvent:	53.5%
Avg. Wt.% Water:	1.2%
Avg. Vol.% Exempt Solvent:	55.3%
Avg. Vol.% Water:	1.1%
Theoretical Coverage:	130 ft ² (12 m ²) at 1 Mil
Recommended Dry Film Thickness:	0.5 Mil Dry Film
Flash Point:	See SDS/MSDS

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:
1.800.668.6945
nasonfinishes.ca

