



# 1380S™ URO® Primer



## GENERAL

### DESCRIPTION

A two-component, fast drying, easy-to-sand urethane primer that delivers good filling properties and topcoat hold out.

### SUGGESTED USES

For use over properly treated substrates such as aluminum, steel, fiberglass and plastic. Treat bare steel with 5717S™ or 5718S™ conditioners. Treat aluminum with 225S™ or 226S™ conditioners. 1380S™ has outstanding adhesion performance over metal substrates treated with the Metalok® 230S™ Adhesion Promoter or Metalok® 250S™ or 235S™ Pretreatments.

### COMPATIBLE COATINGS

Compatible with all Axalta Transportation topcoat systems.

### NOT RECOMMENDED FOR

Immersion service and marginally treated metal substrates.

### DRY FILM CHARACTERISTICS

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

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.

Component	Volume
1380S™ Primer	4
194S™, 294S™ or 15309S™ 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  
45 minutes 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

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.
- 1380S™ builds at approximately 0.8-1.0 mils per pass with a recommended equipment setup.
- Apply using a cross-coat technique, top-to-bottom, and then side-to-side. Each coat should be medium-wet. No flash time is required between coats.
- Axalta topcoats can be applied wet on wet over 1380S™ after a 1-hour flash time (2 hours for maximum holdout).
- Paint heaters can help provide a smoother appearance by controlling the temperature and viscosity of the product, especially under adverse or changing conditions.

### APPLICATION SOLVENTS

Ready-to-spray below 2.1 lb/gal VOC upon activation. Further reduction may result in greater than 2.1 lb/gal 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

### AIR DRY

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

Dry to touch:	30-45 minutes
Tack free:	1-2 hours
Print free:	2-3 hours

Product must be sanded if allowed to dry for more than 16 hours.

### FORCE DRY

30 min at 160-180°F (71-82°C)



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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)	13.02 lbs.
Weight Per Liter (component only)	1560 grams
Suggested Dry Film Thickness	1.6 – 2.0 mils



Gloss	Satin
Color	Gray
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

**RTS mixed 4:1 with:**

<b>Includes 389S</b>	<b>194S</b>	<b>294S</b>	<b>15309S</b>
Gallon Weight pounds per gallon	12.00	12.00	12.04
Gallon Weight grams per liter	1438	1438	1443
VOC AP pounds per gallon	1.6	1.6	1.2
VOC AP grams per liter	193	193	140
VOC LE pounds per gallon	2.0	2.0	1.6
VOC LE grams per liter	244	244	188
Weight Solids	73.7%	73.7%	74.5%
Volume Solids	57.0%	57.0%	58.3%
Weight Volatiles	26.3%	26.3%	25.5%
Weight Water	0.0%	0.0%	0.0%
Volume Water	0.0%	0.0%	0.0%
Weight Exempt Solvents	12.8%	12.8%	15.8%
Volume Exempt Solvents	20.9%	20.9%	25.5%
Theoretical Coverage per RTS Gallon at 1 mil DFT	914 ft <sup>2</sup> (84.9 m <sup>2</sup> )	914 ft <sup>2</sup> (84.9 m <sup>2</sup> )	935 ft <sup>2</sup> (86.9 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:  
**1.855.6.AXALTA**  
 axalta.us

In Canada:  
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 axalta.ca

