



# 1480S™ Spot Productive Primer



## GENERAL

### DESCRIPTION

A two-component, non-isocyanate, primer-filler designed for very productive spot and panel repairs. It delivers minimal overspray, good filling properties, and is easy-to-sand.

### SUGGESTED USES

For use over properly treated substrates such as aluminum, steel, and fiberglass. Stainless and galvanized steel substrates should be sanded and treated with Metalok® 250S™ or Metalok 235S™ Pretreatments.

### COMPATIBLE COATINGS

Compatible with all Axalta Transportation topcoat systems.

### NOT RECOMMENDED FOR

Immersion service

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
1480S™ Primer	4
148XS™ Activator	1
1481S™ Mid Temp Activator	
1489S™ High Temp Activator	

### INDUCTION TIME

No induction is required

### POT LIFE - 70°F (21°C)

1 hour



## 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 FOR REPAIRS USING BODY FILLER

- #36 grit grind areas for repair
- Apply body filler on each area. Air dry per product instructions (minimum 15 minutes). Block sand with #36 / #80. Finish with #150.
- Apply metal glaze finishing putty. Air dry per product instructions (minimum 15 minutes). Block sand with #80. Finish with #150.
- Finishing: prep D.A. outer edges with #220 to smooth down. Finish with #400.
- Apply three coats of 1480S primer-filler to each area with a 10-minute flash between coats.



- Flashed 15-20 minutes prior to lamp bake (30 x 170°F) or 1-hour air dry before sanding.
- Blocked sand all areas with #320.

**APPLICATION FOR REPAIRS WITHOUT BODY FILLER**

- Finishing: prep D.A. outer edges w/ #220 to smooth down.
- Finish with #400.
- Apply three coats of 1480S primer to each area with a 10-minute flash between coats
- Flashed 15-20 minutes prior to lamp bake (30 x 170°F) or 1-hour air dry before sand.
- Blocked sand all areas with #320.

**APPLICATION EQUIPMENT**

Refer to spray equipment documentation for setting recommendations.

Pressure Pot  
Gravity Feed  
Siphon Gun

**APPLICATION SOLVENTS**

Product has a ready-to-spray VOC content below 2.1 lbs. /gallon upon activation. When application conditions require reduction, reduce up to 5% by volume with 130™ or 32030S™.

**CLEANUP SOLVENTS**

3602S™ Lacquer Thinner  
106™ Lacquer Thinner  
107™ Low VOC Gun Cleaner  
108™ Low HAPS Cleaning Solvent



**DRY TIMES**

**AIR DRY**

60-90 minutes at 77°F (25°C)

**FORCE DRY**

20 minutes at 140°F (60°C)



**PHYSICAL PROPERTIES**

Maximum Service Temperature	200°F (92°C) in continuous service 200°F (92°C) in intermittent heat
Weight Per Gallon (component only)	13.82 lbs.
Weight Per Liter (component only)	1656 grams
Suggested Dry Film Thickness	1.5 – 2.0 mils
Gloss	Satin
Color	Gray
Flash Point (Closed Cup)	See SDS
Shelf Life	12 months minimum

**RTS mixed 4:1 with:**

	<b>1481S</b>
	<b>1489S</b>
Gallon Weight pounds per gallon - Average	12.90
Gallon Weight grams per liter - Average	1545
VOC AP pounds per gallon - Maximum	1.3
VOC AP grams per liter - Maximum	157
VOC LE pounds. per gallon - Maximum	1.9
VOC LE grams per liter - Maximum	224
Weight Solids - Average	67.3%
Volume Solids - Average	51.5%
Weight Volatiles - Average	32.6%
Weight Water - Average	0.0%
Volume Water - Average	0.0%



Weight Exempt Solvents - Average	22.5%
Volume Exempt Solvents - Average	29.3%
Theoretical Coverage per RTS Gallon at 1 mil DFT	827 ft <sup>2</sup> (76.9 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 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**  
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