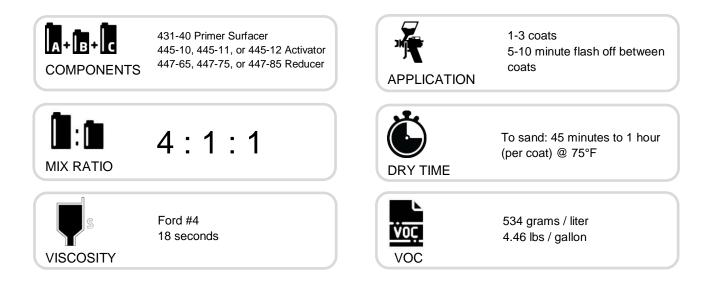


Nason®XL 431-40 Primer Surfacer





GENERAL



DESCRIPTION

Nason[®]XL 431-40 Primer Surfacer is a two-component high-build primer filler (surfacer) for automotive refinishing and new bodywork. 431-40 offers fast dry times, delivering excellent sanding characteristics while providing a stable substrate for all refinishing essentials.

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

COLOR

• 431-40 Grey

A+B+C MIXING

COMPONENTS

Mix 4 parts NasonXL 431-40 Primer Surfacer to 1 part NasonXL Activator to 1 part NasonXL National Rule Reducer (a spray viscosity of 18 secs with Ford #4 @77°F/25°C).

NOTE: If used without thinning, can cause improper drying issues.

| Component | Volume |
|---|--------|
| Nason XL 431-40 Primer Surfacer | 4 |
| Nason XL Activator | 1 |
| (445-10 Super Fast, 445-11 Fast, 445-12 Medium) | |
| Nason XL National Rule Reducer | 1 |
| (447-65 Fast, 447-75 Medium, 447-85 Slow) | |



Package Sizes

1 gallon (3.75 liters)

INITIAL APPLICATION VISCOSITY Ford #4 - 18 seconds

POT LIFE 1 hour @75°F(24°C)



APPLICATION



APPLICATION EQUIPMENT

| HVLP Gravity | 1.4 - 1.6 mm | 1.0 - 1.25 (Bar) | 6 - 8 PSI | *At the cap |
|-----------------|--------------|------------------|-------------|-------------|
| High Efficiency | 1.4 - 1.6 mm | 1.0 - 1.25 (Bar) | 17 - 19 PSI | At gauge |

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

SURFACE PREPARATION

Degrease then sand body filler with P180 – P320 grit sandpaper. Abrade steel with P180 grit sandpaper. Existing surfaces (Featheredge); use P180 – P400 grit sandpaper. Large bare metal areas should be coated with an etch primer before priming with 431-40.

APPLICATION

Apply 1 - 3 single coats depending on desired film build. Allow 5 - 10 minutes flash off between coats. Brush or roll on for small repairs; apply 1 even coat to beyond the featheredge; a second coat if needed, after the first coat has tacked up, to within $\frac{3}{4}$ inch of the first coat.



DRY TIMES

AIR DRY 75°F (24°C) To Sand To Topcoat Rolled or Brushed

45 minutes – 1 hour (per coat) Must be sanded first Overnight dry is required

INFRARED SHORT WAVE 15 Minutes full power @36"

NOTE: Topcoat within 6 – 7 hours after initial sanding or re-scuffing is necessary.



PHYSICAL PROPERTIES

Recommended Film Thickness VOC as Applied Mixed Volume Solids Theoretical Coverage Recommended Coats Film Thickness Recommended Dry Film After Sanding Flash Point \pm 63.5 microns / 2-3 mils per coat 4.46 lbs/gallon (RFU) 45.5% (Average) Approx. 611 SqFt @ 1 Mil DFT/mixed gallon 2-3 (x1) 2.0 – 3.0 mils per coat 1.5 – 3.0 mils per coat See SDS



STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

VOC REGULATED AREAS

All Values Ready To Spray

| | Standard Reduction (5:1:1) |
|---|---|
| Max. VOC (LE) | 538 g/L (4.5 ĺbs./gal) |
| Max. VOC (AP) | 538 g/L (4.5 lbs./gal) |
| Avg. Gal. Wt.: | 1245 g/L (10.4 lbs./gal) |
| Avg. Wt.% Volatiles: | 43.2% |
| Avg. Wt.% Exempt Solvent: | 0.0% |
| Avg. Wt.% Water: | 0.0% |
| Avg. Vol.% Exempt Solvent: | 0.0% |
| Avg. Vol.% Water: | 0.0% |
| Theoretical Coverage: | 603 ft ² (56.0 m ²) at 1 mil |
| Recommended Dry Film Thickness: Flash Point: | 0.8 to 1.2 mil in 1 coat See SDS |

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 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 nasonXL.us In Canada: 1.800.668.6945

