



Nason®XL 431-12 2.1 VOC DTM Primer




COMPONENTS
431-12 2.1 VOC DTM Primer
435-14, 435-15 Low VOC
Activator



APPLICATION
1-3 coats
5-10 minute flash off between
coats




MIX RATIO
4 : 1



DRY TIME
Air dry: 1 hour @75°F (24°C)
per 1-2 coats
Bake: 20 minutes @140°F (60°C)



VISCOSITY
Zahn #3
11-13 seconds



VOC
250 grams / liter
2.1 lbs / gallon



GENERAL

DESCRIPTION

NasonXL 431-12 is 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.

COMPATIBLE SUBSTRATES

Properly cleaned and prepared steel, aluminum and galvanized metal. Properly sanded and prepared OEM finishes, cured paint, cured body filler and properly sanded fiberglass. Properly prepared rigid plastic.

Use Axalta VS3000 Etch Primer over galvanized steel is an industry best practice.

COLOR

- 431-12 Grey

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



MIXING

COMPONENTS

Mix 4 parts NasonXL 431-12 2.1 VOC DTM Primer to 1 part NasonXL 435-14 Low VOC Standard Activator or 435-15 Low VOC Slow Activator. Spray viscosity 11-13 secs with #3 Zahn @ 77°F (25°C).

| Component | Volume |
|---|--------|
| NasonXL 431-12 2.1 VOC DTM Primer | 4 |
| NasonXL Low VOC Activator (435-14 Standard, 435-15 Slow) | 1 |

Package Size

- 1 gallon (3.785 liters)

INITIAL APPLICATION VISCOSITY

Zahn #3 Viscosity 11-13 seconds

POT LIFE

1 Hour @75°F (24°C)



APPLICATION

APPLICATION EQUIPMENT

| | | | |
|-----------------|--------------|-------------|--------------|
| HVLP Gravity | 1.7 - 1.9 mm | 7 - 9 PSI | at the cap |
| High Efficiency | 1.7 - 1.9 mm | 21 - 28 PSI | at the gauge |

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

SURFACE PREPARATION

Remove dust or oxidation prior to applying primer by media blasting, grinding or sanding. Be certain all surfaces are free of waxes, oils, grease or other contaminants.

Over galvanized steel, an industry best practice is to use an etch primer such as Axalta VS3000 Etch Primer.

NOTE: Do not use over lacquer primer, lacquer finishes or uncured substrates.

APPLICATION

Apply in single wet coats, allowing 5-10 minute flash at 75°F (24°C) between coats. For HIGH BUILD: We suggest 2 coats maximum. If 3 coats are applied, allow for overnight drying. 2 mils minimum final film is need to provide good corrosion protection.



DRY TIMES

AIR DRY

1 hour @75°F (24°C) per 1-2 coats
Over night for high build 3 coats

BAKE

20 minutes @140°F (60°C)

INFRARED SHORT WAVE

20 minutes full power @36"



PHYSICAL PROPERTIES

| | |
|----------------------------|---|
| Recommended Film Thickness | 50 microns /2.0 mils per coat – Dry Film Build |
| VOC as Applied | 2.1 lbs/gallon (RFU) |
| Mixed Volume Solids | 43% (Average) |
| Theoretical Coverage | 693 ft ² (54.4 m ²) at 1 mil |
| Recommended Coats | 1-3 (x1) |
| DFT per Coat | Approximately 2.0 mils |
| Flash Point: | 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 (4:1) |
|----------------------------|-------------------------------------|
| Max. VOC (LE) | 233 g/L (1.86 lbs./gal) |
| Max. VOC (AP) | 127 g/L (1.06 lbs./gal) |
| Avg. Gal. Wt.: | 1530 g/L (12.76 lbs./gal) |
| Avg. Wt.% Volatiles: | 44.5% |
| Avg. Wt.% Exempt Solvent: | 36.2% |
| Avg. Wt.% Water: | 0.0% |
| Avg. Vol.% Exempt Solvent: | 43.0% |
| Avg. Vol.% Water: | 0.0% |

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

