Ful-Fil®
421-08™ & 421-09™ 1K Acrylic Primer

GENERAL

DESCRIPTION
A 4.8 lb/gal (580 g/l) VOC compliant, acrylic primer designed to be used under all Nason® topcoats. It is fast drying, easy to sand and has good filling and topcoat holdout properties.

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

MIXING

COMPONENTS
Ful-Fil® 421-08™ 1K Acrylic Primer - Gray
Ful-Fil® 421-09™ 1K Acrylic Primer - Red
Ful-Base® 441-62™ Thinner

MIX RATIO
Combine the components by volume (1:1). Mix thoroughly prior to use.

Component	Volume
Ful-Fil® 421-08™ / 421-09™ 1K Acrylic Primer	1
Ful-Base® 441-62™ Thinner	1

Never mix primer in the gun cup. Always mix primer in a separate container with vertical sides; strain the ready-to-spray mixture into the gun cup.

TINTABILITY
Not recommended

POT LIFE
Not applicable

SPRAY VISCOSITY
18-20 seconds in a Zahn #2

APPLICATION

SURFACE PREPARATION:
- Clean surface thoroughly with mild detergent and water. For substrates other than plastic or fiberglass, wipe surface with Nason® 441-05™ Wax and Grease Remover, 481-75™ Surface Cleaner or locally permitted cleaner.
- Featheredge damaged areas with 180 grit paper and scuff edges of area to be filled with 320.
- Block sand and prime as necessary. Finish sand with 320 before topcoating.

SPRAY PRESSURE
Conventional

Siphon Feed:	30-45 PSI at the gun
Gravity Feed:	30-40 PSI at the gun
HVLP:	8-10 PSI at the gun cap

TYPICAL GUN SET-UPS:

Conventional

Siphon Feed:	1.8-2.2 mm
Gravity Feed:	1.6-2.0 mm
HVLP	1.5-1.8 mm

APPLICATION:

Apply 2 to 3 medium wet coats to desired film build. Flash 5-10 minutes between coats.

Tips for Success

- Do not ignore flash times between coats; this prevents solvent entrapment that can cause pinholes, popping and shrinkage if flash is abused.
- For best results and maximum resistance to corrosion and humidity, prime bare metal with Ful-Poxy® 491-16™ DTM Epoxy Primer/Sealer or Ful-Poxy® 491-35™ HS Epoxy Primer/Sealer or SelectPrime™ 491-17™ 2K Etch Primer, 491-55™ 2K Chrome Free Etch Primer or other Nason® etch primer or epoxy primer.
- Nason® primer must be sanded thoroughly and application of sealer is ***required*** before topcoating.
- Never apply heavy coats of any primer in two passes of the spray gun. A flash between coats is required to avoid the surface drying too quickly and trapping solvent. This will lead to difficult sanding (gummy), poor holdout, pinholes, or cracking.

CLEANING OF PAINT EQUIPMENT:

Use Cromax® 105™ Gun Cleaner, Cromax® 107™ Low VOC Gun & Equipment Cleaning Solvent, or any other equipment cleaner as permitted by local regulations.

DRY TIMES

AIR DRY

20-30 minutes at 70°F (21°C)

FORCE DRY

15 minutes at 110°F (43°C)

Lower temperatures may require longer flash Times.

SANDING:

Must be sanded prior to sealing.

- P-320 grit for single-stage topcoats
- P-400 to P-600 grit for basecoat topcoats

PHYSICAL PROPERTIES

All Values Ready To Spray

	421-08	**421-09**
Max. VOC (LE)	4.8 lbs./gal (573 g/L)	4.8 lbs./gal (573 g/L)
Max. VOC (AP)	2.7 lbs./gal (328 g/L)	2.6 lbs./gal (311 g/L)
Avg. Gal. Wt.	8.47 lbs./gal (1015 g/L)	8.30 lbs./gal (995 g/L)
Avg. Wt.% Volatiles	65.7%	67.7%
Avg. Wt.% Exempt Solvent	33.5%	36.4%
Avg. Wt.% Water	0.0%	0.0%
Avg. Vol.% Exempt Solvent	42.9%	45.7%
Avg. Vol.% Water	0.0%	0.0%

Recommended DFT:	1-4 mil in 2 to 4 coats
Flash Point:	See SDS/MSDS
Theoretical Coverage:	301 ft^2 (28 m^2) at 1 mil

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.

Revised: November 2016

In the United States:
1.855.6.AXALTA
nasonfinishes.com

In Canada:
1.800.668.6945
nasonfinishes.ca