

# SelectPrime™ 421-17™ & 421-19™ 2K Urethane Primer



## GENERAL

### DESCRIPTION

A 4.8 lb. /gal (580 g/l) VOC compliant, 2K urethane primer-filler designed to maximize DOI while providing high build and an exceptional free sanding film without shrinkage or sand scratch swelling.

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



## MIXING

### COMPONENTS

SelectPrime™ 421-17™ 2K Urethane Primer (Beige)  
 SelectPrime™ 421-19™ 2K Urethane Primer (Gray)  
 SelectPrime™ 483-87™ 2K Activator (Mid-Temp)  
 SelectPrime™ 483-88™ 2K Activator (Hi-Temp)

### MIX RATIO

Combine the components by volume (4:1). Mix thoroughly prior to activation.

Component	Volume
SelectPrime™ 421-17™ / 421-19™ 2K Urethane Primer	4
SelectPrime™ 483-88™ / 483-87™ 2K Activator	1

### TINTABILITY

Not recommended

### POT LIFE

1 Hour at 70°F (21°C)

### SPRAY VISCOSITY

28-32 seconds in a Zahn #2



## APPLICATION

### SUBSTRATES

- Properly treated bare fiberglass, steel and aluminum
- Thoroughly sanded, painted surfaces

Note: Aluminum, galvanized, and steel must be pretreated with SelectPrime™ 491-17™ 2K Etch Primer, SelectPrime™ 491-55™ 2K Chrome Free Etch Primer or Ful-Poxy® 491-16™ DTM Epoxy Primer/Sealer or other Nason® etch primer or epoxy primer.

### TOPCOATS

All Nason® Topcoats

### 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, Nason® 481-75™ Surface Cleaner, or locally permitted cleaner.
- Sand and featheredge according to the following minimum grit recommendations:

Steel: P180 grit

Aluminum:	P320 grit, then pretreat
Galvanized:	P320 grit, then pretreat
E-coat:	P320 grit
Cured paint:	P320 grit
OEM featheredge:	P180 grit followed by P240 grit
Body filler:	P180 grit
2K putty:	P180-P240 grit
SMC/fiberglass:	P180-P240 grit

**Tips for Success**

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes.
- Finish sensitive substrates in P320 grit.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.

**GUN SETUP**

**Conventional**

Siphon Feed:	1.6-1.8 mm
Gravity Feed:	1.6-1.8 mm

**HVLP**

Siphon Feed:	1.6-1.9 mm
Gravity Feed:	1.6-1.9 mm

**SPRAY PRESSURE**

**Conventional**

Siphon Feed:	35-45 PSI
Gravity Feed:	35-45 PSI

HVLP:	8-10 PSI
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**APPLICATION**

Apply 2-4 medium wet coats to achieve 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.

**SANDING**

Sand wet or dry with #400 or finer paper. Clean sanding debris with Nason® 441-05™ Silicone and Wax Remover or locally permitted cleaner.

**SEALERS**

No sealer is required but may be sealed with SelectSeal™ 422-50™ / 422-51™ / 422-52™ 2K Urethane Sealers, or any other Nason® sealer.

**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.

**Important Notes**

- Sanding is required for optimal appearance and adhesion of topcoat.
- SelectPrime™ 421-17™ / 421-19™ 2K Urethane Primers can be used under any Nason® topcoat system.



## DRY TIMES

### AIR DRY

2 hours at 70°F (21°C)

### FORCE DRY

30 minutes at 140°F (60°C) after 10 minute flash



## PHYSICAL PROPERTIES

### All Values Ready To Spray

2K Urethane Primer	421-17	421-19
Max. VOC (LE)	4.3 lbs./gal (511 g/L)	4.3 lbs./gal (516 g/L)
Max. VOC (AP)	4.2 lbs./gal (505 g/L)	4.2 lbs./gal (509 g/L)
Avg. Gal. Wt.	11.43 lb./gal (1370 g/L)	11.15 lbs./gal (1336 g/L)
Avg. Wt.% Volatiles	37.5%	38.9%
Avg. Wt.% Exempt Solvent	.7%	.8%
Avg. Wt.% Water	0.0%	0.0%
Avg. Vol.% Exempt Solvent	1.2%	1.3%
Avg. Vol.% Water	0.0%	0.0%

Recommended Dry Film Thickness: 4-5 mils in 3 coats  
 Flash Point: See SDS/MSDS  
 Theoretical Coverage: 635 to 657 Ft<sup>2</sup> (59 to 61 m<sup>2</sup>) 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.

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In the United States:  
**1.855.6.AXALTA**  
**nasonfinishes.com**

In Canada:  
**1.800.668.6945**  
**nasonfinishes.ca**

