

# Ful-Fil® 421-08™ 1K Acrylic Primer



## GENERAL

### DESCRIPTION

A 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-Base® 441-xx Thinner

### MIX RATIO

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

Component	Volume
Ful-Fil® 421-08™ 1K Acrylic Primer	1
Ful-Base® 441-xx 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 all surfaces with with an Axalta Coatings System approved silicone and wax remover.
- Featheredge damaged areas with P180 grit paper and scuff edges of area to be filled with P320.
- Block sand and prime as necessary. Finish sand with P320 before topcoating.

### SPRAY PRESSURE

#### Conventional

Siphon Feed:	2.1-3.1 bar at the gun
Gravity Feed:	2.1-2.8 bar at the gun
HVLP:	0.55-0.7 bar 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**

- Observe flash times between coats; this prevents solvent entrapment that can cause pinholes, popping and shrinkage.
- For best results and maximum resistance to corrosion and humidity, prime bare metal with Ful-Poxy® 491-35™ HS Epoxy Primer/Sealer.
- Nason® Ful-Fil 421-08 1K Acrylic Primer must be sanded thoroughly before application of sealer.
- Never apply heavy coats of any primer in two passes of the spray gun. This will lead to difficult sanding (gummy), poor holdout, pinholes, or cracking. A flash between coats is required to avoid the surface drying too quickly and trapping solvent.

**CLEANING OF PAINT EQUIPMENT:**

Clean spray equipment as soon as possible with Duxone® Gun Wash Solvent.



**DRY TIMES**

**AIR DRY**

20-30 minutes at 20°C

**FORCE DRY**

15 minutes at 45°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**

Max. VOC (LE)	576 g/L
Max. VOC (AP)	324 g/L
Avg. SG	1.02 g/mL
Avg. Wt.% Volatiles	65.7%
Avg. Wt.% Exempt Solvent	33.5%
Avg. Wt.% Water	0.0%
Avg. Vol.% Exempt Solvent	42.9%
Avg. Vol.% Water	0.0%

Recommended DFT:	25-100 µm in 2 to 4 coats
Flash Point:	See SDS
Theoretical Coverage:	7.4 m <sup>2</sup> L at 25 µm

**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 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.