

Ful-Poxy[®] 491-35[™] HS Epoxy Primer/Sealer



GENERAL

DESCRIPTION

A 420 g/L, VOC compliant, non-sanding, epoxy primer-sealer formulated for maximum adhesion and corrosion resistance to properly treated substrates.

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



MIXING

COMPONENTS

Ful-Poxy[®] 491-35[™] HS Epoxy Primer/Sealer
 Ful-Poxy[®] 483-35[™] HS Activator (Mid-Temp)
 Ful-Poxy[®] 483-45[™] HS Activator (High-Temp)

MIX RATIO

Component	Volume
Ful-Poxy [®] 491-35 [™] HS Epoxy Primer/Sealer	4
Ful-Poxy [®] 483-35 [™] / 483-45 [™] HS Activator	1

INDUCTION PERIOD

None

SPRAY VISCOSITY

14-16 Seconds Zahn #3

POT LIFE

4 Hours at 20°C



APPLICATION

SUBSTRATES

OEM replacement parts
 Properly sanded or blasted steel
 Properly cleaned or sanded aluminum, galvanized steel, or stainless steel
 Properly sanded SMC/fiberglass/body fillers/polyester putties

TOPCOATS

Any refinishing system

SURFACE PREPARATION

- Prior to sanding, remove all wax, grease, oil, and road tar with an Axalta Coating Systems approved silicone and wax remover using clean rags only
- Sand old finish.
- For Aluminum: Wash with detergent, rinse and dry well. Clean with an Axalta Coating Systems approved silicone and wax remover.

SPRAY PRESSURE

Conventional

Siphon Feed:	4.1-4.8 bar
Gravity Feed:	4.1-4.8 bar at the gun
Pressure Feed:	1.2 mm fluid tip, 4.1-4.8 bar at the gun (fluid flow 300-350 mL/minute)

HVLP

Siphon Feed:	0.5-0.7 bar at the gun cap
Gravity Feed:	0.5-0.7 bar at the gun cap

GUN SETUP

Conventional Siphon Feed:	1.6-1.8 mm
Gravity Feed:	1.4-1.6 mm

HVLP

Siphon Feed:	1.5-1.8 mm
Gravity Feed:	1.5-1.6 mm

APPLICATION

Spray one full wet coat. For maximum corrosion resistance, two medium wet coats may be applied in a cross-coat application. No flash is necessary between cross coats.

CLEANING OF PAINT EQUIPMENT

Use Duxone® Gun Wash Solvent

IMPORTANT NOTES

- Activator and primer must be thoroughly mixed for satisfactory performance.
- DO NOT USE if shop temperature is less than 10°C



DRY TIMES

AIR DRY

To topcoat:	60-90 minute at 20°C
To sand:	Overnight

FORCE DRY

30 minutes at 60-70°C

Product must be sanded if allowed to dry for more than 72 hours.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	372 g/L
Max. VOC (AP):	324 g/L
Avg. SG:	1.31 g/mL
Avg. Wt.% Volatiles:	33.9%
Avg. Wt.% Exempt Solvent:	11%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	17.4%
Avg. Vol.% Water:	0.0%
Recommended Dry Film Thickness:	25 - 30 µm
Flash Point:	See SDS
Theoretical Coverage, RTS:	18.2 m ² /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.