
FUL-THANE® SENTRY™ 421-15™ 2K CATALYZED PRIMER-SURFACER AT 4.8 VOC

Ful-Thane® Sentry™ 421-15™ Primer-Surfacer is designed to maximize DOI (Distinctness of Image) when used under any Nason topcoat color. 421-15™ provides high build combined with an exceptionally free sanding film without shrinkage or sand scratch swelling.

MIXING

4-1

Mix:

4 parts Ful-Thane® Sentry™ 421-15™

1 part Ful-Thane® Sentry™ 483-77™

Primer-Surfacer Activator

Example:

To 1 gallon 421-15™ Primer-Surfacer add 1 quart Activator

TINTABILITY:

Can be tinted up to 5% with Ful-Base® 430-XX™ Toners. (Over tinting will slow dry and cause poor sanding capability).

POT LIFE:

3 hours at 70°F

SUBSTRATES:

Properly treated bare steel and aluminum as well as thoroughly sanded painted surfaces.

Etch-Primer: Nason® 491-17™ Etch Primer or Nason® 491-30™ Chrome-Free Etch Primer.

TOPCOATS:

Nason® Ful-Cryl® II, Ful-Thane® Urethane, Ful-Base® Basecoat.

With proper sealer: Nasco™, Astron® and Ful-Base® Enamel. (See Topcoat Data Sheets for Sealer Recommendation).

SURFACE PREPARATION:

Clean all surfaces with Nason® 441-05™ Silicone and Wax Remover. In regulated areas use locally permitted Silicone and Wax remover.

421-15™ can be applied over properly treated bare steel and aluminum as well as thoroughly sanded painted surfaces.

Remove sanding dust with permitted Silicone and Wax remover and allow to dry.

Bare metal areas should be treated with the appropriate metal conditioner or preferably, coated with Nason® 491-17™ Etch Primer or Nason® 491-30™ Chrome-Free Etch Primer.

See Product Data Sheets for information on these products.



Technical Manual

SPRAY VISCOSITY:

12"-13" #4 Ford Cup

SPRAY PRESSURE:

40-50 PSI

HVLP: 8-10 PSI

APPLICATION:

Apply 2 to 4 medium wet coats to achieve desired film build. Allow 5-10 minutes flash time between coats.

DRYING TIME: TO SAND

2 hours at 70°F.

SANDING:

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

CLEANING OF PAINT EQUIPMENT:

Clean with Nason® 481-06™ Lacquer Thinner or Nason® SelectThinner™ 481-16™. Refer to appropriate Air Quality District requirements for proper use of equipment and solvent.

THEORETICAL COVERAGE:

500 Sq. Ft. Mill. Cov.

PERCENT SOLIDS BY WEIGHT:

52.86

PERCENT SOLIDS BY VOLUME:

31.21

FLASH POINT: CLOSED CUP

Below 80°F

IMPORTANT NOTES:

Sanding is required for optimal appearance and adhesion of topcoat.

421-15™ can be used under any Nason® topcoat system using the recommended sealer.

VOC—READY TO SPRAY

4.8 lb./gal.