

## **NASON® SELECTPRIME™ 421-20™ PRIMER-SURFACER**

Nason® SelectPrime™ 421-20™ Primer-Surfacer is designed to optimize DOI (Distinctness of Image) and topcoat holdout. 421-20™ also provides high build and exceptionally free sanding film without shrinkage or sand scratch swelling.

### **MIXING:**

**4-1**

#### **Mix:**

4 parts Nason® SelectPrime™ 421-20™  
1 part Nason® SelectPrime™ 483-83™ or  
483-53™ (Fast) Primer-Surfacer Activa-  
tor

#### **Example:**

To 1 gallon 421-20™ Primer-Surfacer add 1 quart Activator 483-83™.

### **POT LIFE:**

1 Hour at 70°F.

### **SUBSTRATE PREP:**

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

*When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sandscratch swelling in OEM finishes. Also, sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the 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 Wax Remover. In regulated areas use locally permitted Silicone and Wax Remover. 421-20™ 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 491-17™ or 491-30™ Etch Primers. See Product Data Sheets for information on these products.

### **SPRAY VISCOSITY:**

26" #4 Ford Cup

### **SPRAY PRESSURE:**

**Conventional:** 30-40 PSI

**HVLP:** 8-10 PSI @ gun cap.

**APPLICATION:**

Apply 3 medium wet coats. Allow 5-10 min. flash between coats.

**DRYING TIME: TO SAND**

2.5 hours at 70°F

**SANDING THE PRIMER:**

400 grit DA or P500 grit hand or P600 grit wet.

**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:**

55.9

**PERCENT SOLIDS BY VOLUME:**

36.5

**FLASH POINT: CLOSED CUP**

Below 77°F

**IMPORTANT NOTES:**

Sanding is required for adhesion of topcoat to primer and optimal appearance.

421-20™ can be used under any Nason® topcoat system.

**VOC READY-TO-SPRAY:**

4.8 lbs/gal.