



Axalta™ Etch Primer 420



GENERAL

DESCRIPTION

Axalta™ Etch Primer 420 is a two-component adhesion promoter that promotes adhesion and serves as passive pretreatment of metal substrates, especially aluminum and top-grade steel. It must be used as part of a three-layer system.

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



MIXING

COMPONENTS

Axalta Etch Primer 420

HARDENER

Axalta Etch Primer Activator 421

MIX RATIO

Component

420

421

Volume

1

1

APPLICATION VISCOSITY

15 - 16 seconds at 68°F/20°C, DIN 4

POT LIFE

Approximately 8 hours at 68°F/20°C.

SPECIAL TIPS

1. 0.3 mil dry film thickness is necessary for adequate corrosion resistance.
2. All traces of rust must be removed before applying Axalta Etch Primer 420.
3. Do not recoat with polyester or epoxy products.
4. Do not use on reversible finishes.
5. We recommend the following three-layer system:
 - a. Prime with Axalta Etch Primer 420.
 - b. Apply appropriate filler, surfacer and/or sealer from Cromax®, Spies Hecker®, or Standox®.
 - c. Apply Topcoat.
6. **Metal substrates must be primed within one half-hour of sanding or re-sanding is required.**
7. **Must be over coated within 8 hours for moisture protection.**

In the United States:
1.855.6.AXALTA
 axalta.us

In Canada:
1.800.668.6945
 axalta.ca





APPLICATION

SUBSTRATES

Properly prepared Bare Steel
Properly prepared Galvanized Steel
Properly prepared Aluminum
Cut throughs on Sanded E-Coat
Cut throughs on original or old paintwork (except reversible substrates, Example: lacquer)

SURFACE PREPARATION

- Degrease and sand.
- Prior to applying a sanding surfacer, sand body filler with P180 or finer grit sandpaper and/or sand feather edge areas with P180, then P240, and finish with P320.
- Before further treatment, clean all substrates thoroughly with Axalta™ Silicone Remover 200 Slow, Axalta Silicone Remover 205A Spray, Axalta Silicone Remover 210 Water or Axalta Silicone Remover 220 Low VOC.

SPRAYGUN SETUP

HVLP 1.3-1.4mm

Approved Transfer Efficiency 1.2-1.3mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- Option 1: Apply 1 medium coat followed by 1 full coat without intermediate flash-off.
- Option 2: Apply 2 coats with approximately 5 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

0.3 mil dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C: 30 minutes

RECOAT

With appropriate 2K filler, surfacer and/or sealer from Cromax®, Spies Hecker®, or Standox®..

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PHYSICAL PROPERTIES

Coating Category: Primer

Max. VOC (AP): 757 g/l; 6.3 lbs/gal
 Max. VOC (LE): 764 g/l; 6.4 lbs/gal
 Avg. Gallon Weight: 924.7 g/l; 7.7 lbs/gal
 Avg. Weight % Volatiles: 82.9%
 Avg. Weight % Water: 1.1%
 Avg. Weight % Exempt Solvent: 0.0%
 Avg. Volume % Water: 0.1%
 Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 145.7 sq. ft. @ 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 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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