

## **NASON® FUL-POXY® 491-18™ EPOXY PRIMER**

Ful-Poxy® 491-18™ Primer is a non-sanding epoxy primer especially formulated for maximum adhesion and corrosion resistance to properly treated metal surfaces. 491-18™ may be used over steel, aluminum, fiberglass and sanded finish coats. It can be recoated with all refinishing systems. 491-18™ is a two component product and must be activated with 483-20™ Epoxy Primer Activator.

### **MIXING AND THINNING:**

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#### **Mix:**

2 Parts Ful-Poxy® 491-18™ Primer-Sealer  
1 Part 483-20™ Epoxy Primer Activator

### **INDUCTION PERIOD:**

None.

### **SPRAY VISCOSITY:**

18-20" #2 Zahn

### **POT LIFE:**

12 hours at 70°F in a sealed container.

### **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  
Under all Nason® primers

### **TOPCOATS:**

Any refinishing system.

### **SURFACE PREPARATION:**

Prior to sanding, remove all wax, grease, oil and road tar with Nason® 441-05™ Silicone and Wax Remover or 481-75 Aerosol Cleaner using clean rags only. In regulated areas, use only permitted silicone and wax remover. For difficult to clean substrates, use appropriate etch cleaning agent. Sand substrate prior to applying 491-18™.

### **SPRAY PRESSURE:**

#### **Conventional**

Siphon Feed: 30 - 45 psi @ the gun.  
Gravity Feed: 30 - 40 psi @ the gun.  
*Pressure Feed 1.2 mm fluid tip, 35-40 psi @ the gun (fluid flow-14-16 oz/minute)*

#### **HVLP**

Siphon Feed: 8-10 psi @ the gun cap  
Gravity Feed: 8-10 psi @ the gun cap

### **TYPICAL GUN SET-UPS:**

#### **Conventional**

Siphon Feed: 1.6 mm - 1.8 mm (.063" - .071")  
Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

#### **HVLP**

Siphon Feed: 1.5 mm - 1.8 mm (.059" - .063")  
Gravity Feed: 1.5 mm - 1.6 mm (.059" - .063")

### **APPLICATION:**

Spray one full, wet coat. For maximum corrosion resistance, two medium coats may be applied.

### **DRYING TIME:**

Allow to dry for one hour at normal temperatures (70 °F to 80 °F) before applying topcoat. If sanding is required, allow overnight dry time at normal temperatures.

Force dry: 20 – 30 minutes at 120 – 140 °F

### **SANDING:**

491-18™ may be recoated at any stage of cure. It can be topcoated within 24 hours air dry without sanding. If 491-18™ is baked it must be sanded with P400-P600 before topcoating.

## CLEANING OF PAINT EQUIPMENT

Clean immediately with Nason<sup>®</sup> 481-06<sup>™</sup> Lacquer Thinner OR Nason<sup>®</sup> SelectThinner<sup>™</sup> 481-16<sup>™</sup>. Always refer to appropriate Air Quality District requirements for proper use of cleaning equipment and Nason<sup>®</sup> products.

## PHYSICAL PROPERTIES

VOC: 4.5 lbs/gal ready- to-spray.  
Theoretical Coverage: 621 sq. ft per RTS gallon at 1 mil.  
Weight Solids: 53% RTS.  
Volume Solids: 34.97% RTS.  
Recommended Dry Film Thickness: 0.8-1.2 mils.  
Flash Point: See MSDS.

## 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 and usage 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 MSDS precautions. If mixed with other components, mixture will have hazards of all components.

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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