

nason® finishes

# Filler to Go!

## Nason® Ful-Fil™ HS 421-40™ Polyester Spray Filler



### A Price Fighting, Quality Nason® Finishes Product

Nason® Ful-Fil™ HS 421-40™ Polyester Spray Filler is a key part of the Nason® line up for shops that need low price products to do cost limited work. It's a "price fighter" from DuPont Performance Coatings, the world leader of respected and trusted refinish paint brands.

### Polyester Spray Filler Components

- Ful-Fil™ 421-40™ Polyester Spray Filler.
- Nason® 483-92™ Activator.

### Shop Benefits

- Most productive economy polyester spray filler.
- Best economy choice with value pricing and DuPont Performance Coatings quality.
- Outstanding Fill and Build with fast dry times.

### Colorcoat System Recommendations

- 421-40™ is ideal for use with properly applied basecoat or single-stage colors.
- Nason® Finishes colorcoats are recommended.

### Competition

Ful-Fil™ HS 421-40™ is formulated and positioned to be a superior choice versus all economy priced component manufacturers.

### Environmental

Ful-Fil™ HS 421-40™ is designed to be compliant with the strictest VOC rules in the US. Please read all safety information and directions for use.

# Nason® Ful-Fil™ HS 421-40™ Polyester Spray Filler

## Description

Nason® 421-40™ Ful-Fil™ HS is a two-component high build Gray Polyester Spray Filler. Nason® 421-40™ Ful-Fil™ HS Polyester Spray Filler is designed to provide excellent fill and adhesion to fiberglass, SMC, body filler and properly prepared steel, galvanized steel and aluminum. Offers excellent application performance with good dry times, and sanding properties.

## Mixing & Thinning

2% by weight Mix:  
½ oz. MEKP Liquid Activator (Nason® 483-92™) to 1 Quart Nason® 421-40™ Ful-Fil™ HS

## Spray Viscosity

30" – 32" #2 ZAHN

## Pot Life

30 Minutes @ 70°F / 50% Relative Humidity

## Substrates

Properly treated bare steel, galvanized steel and aluminum; properly prepared fiberglass, SMC, body filler and polyester putty. 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 Recommendations).

## Surface Preparation

Clean all surfaces with Nason® 441-05™ Silicone and Wax Remover. In regulated areas use locally permitted Silicone and Wax remover. Nason® 421-40™ can be applied directly to properly treated bare steel, galvanized steel and aluminum; properly prepared fiberglass, SMC, body filler and polyester putty. Remove sanding dust with Nason® 441-05™ Silicone and Wax Remover and allow to dry. For maximum corrosion resistance, 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 Nason® Product Data Sheets for information on these products.

## Spray Pressure

Conventional gun 35-45 PSI at the gun

HVLP: 8-10 PSI air cap pressure.

## Gun Setups

Conventional: 1.6mm – 1.8mm (0.63" - .071")

HVLP: 1.5mm – 1.8mm (0.59" - .071")

## Application

Apply 2 to 3 medium wet coats to achieve desired film build. Allow 5 – 10 minutes flash time between coats 70°. Do not ignore flash times between coats.

## Drying Time: To Sand

Air Dry: 45 – 60 minutes @ 70°F Force Dry: 20 minutes @ 140°F *Lower temperatures may require longer flash times.*

## Sanding

Must be sanded prior to sealing, or topcoating. P-320 to P-400 grit for Enamel topcoats P-400 to P-600 grit for Lacquer topcoats

## Cleaning of Paint Equipment

Use Nason® 481-06™ Universal Lacquer Thinner, Nason® 481-16™ Lacquer Thinner, Nason® 481-18™ Lacquer Thinner, Nason® 481-21™ Low VOC Gun & Equipment Cleaning Solvent.

## Theoretical Coverage

545.2 Sq. Ft. Mill Cov.

## Percent Solids by Weight

53.8%

## Percent Solids by Volume

34.0%

## Flash Point: Closed Cup

Below 20°F

## Important Notes

- Before mixing or opening Nason® 421-40™ Ful-Fil™ HS or the designated Activator; be sure to “READ” all warnings and safety statements on the Material Safety Data Sheet (MSDS), and Technical Data Sheet (TDS) to ensure safe use and handling.
- Nason® 421-40™ Ful-Fil™ HS Polyester Spray Filler must be sanded and sealed before application of topcoat.
- Never apply heavy coats any spray-filler in two passes of the spray gun; the flash abused filler will surface dry and trap solvents. This will lead to difficult sanding (gummy), port holdout, pinholes, or cracking.
- Never mix filler in the gun cup. Always mix filler in a separate can designated for this purpose. Strain the ready-to-spray body filler mixture into the gun.

## VOC Data

LE: 4.4  
AP: 3.7

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