



# 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	Volume
420	1
421	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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**Revised: August 2020**

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