



Axalta™ Epoxy 2K 460A Spray



GENERAL

DESCRIPTION

A two-component chromate-free aerosol delivers good corrosion resistance and excellent adhesion for direct-to-metal applications. It can be applied over cleaned aluminum, galvanized steel and stainless steel or over appropriately sanded or blasted carbon steel, sanded fiberglass and sanded OEM e-coat primers.

Axalta™ Epoxy 2K 460A Spray is available as an aerosol only.

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



MIXING

COMPONENTS

Axalta™ Epoxy 2K 460A Spray

MIX RATIO

This is a 2K aerosol can that must be activated prior to use. Temperature must be above 59°F/15°C for activation and air drying.

1. Please remove the red button from the cap and place it on the hardener mixing valve at the bottom of the can.
2. Press the hardener mixing valve inwards.
3. Shake can for at least 2 minutes.

POT LIFE

Three days @ 68°F (20°C)

SPECIAL TIPS

1. Do not apply Axalta Epoxy 2K 460A Spray on reversible substrates or over etch primers.
2. All traces of rust must be removed before priming with Axalta Epoxy 2K 460A Spray.
3. Metal substrates must be primed within 30 minutes of sanding or re-sanding is required.
4. With air drying, a minimum temperature of 59°F/15°C must be maintained for 12 hours. If temperatures are lower, the material will remain soft and sanding will not be possible.
5. Can be used as an isolator for solvent sensitive finishes.
6. Axalta Epoxy 2K 460A Spray can be applied after drying and prior to seam sealer to complete body work.
7. For use under body filler, allow to dry overnight (minimum of 16 hours) or bake 20 minutes at 140°F (60°C).

In the United States:
1.855.6.AXALTA
 axalta.us

In Canada:
1.800.668.6945
 axalta.ca





APPLICATION

SUBSTRATES

Sanded Bare Steel
 Sanded Galvanized (cut-through)
 Sanded Aluminum (cut-through)
 Sanded E-Coat
 Original or old paintwork (except reversible substrates, Example: lacquer)
 SMC, fiberglass, body fillers, polyester putties
 Over properly sanded primers
 Under all primers

SURFACE PREPARATION

- Degrease and sand.
- Prior to applying, 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.

APPLICATION

Distance to the substrate should be 8-10 inches (20-25 cm).

- 2 coats = 0.8-1.2 mil (20-30 micron)
- Apply 1 coat, allow to flash off. Then, apply a second coat to cover.

IR drying may be used to enhance flash off/drying.

RECOMMENDED FILM THICKNESS

2 coats for 0.8 – 1.2 mils dry film thickness



DRY TIMES

AIR DRYING

Prior to application of Polyester Products: Flash off 60 min/ 68°F (20°C).

Prior to application of 2K Fillers: Flash off 30 min/ 68°F (20°C).

For small sand-throughs prior to application of Topcoats: Flash-off 20-30 min/ 68°F (20°C).

RECOATABILITY/RE-REPAIR

Axalta Epoxy 2K 460A Spray may be recoated at any stage of cure. It can be topcoated within 24 hours air dry without sanding. If Axalta Epoxy 2K 460A Spray is baked or air dried longer than 24 hours, it must be sanded with P400-P600 before topcoating.



PHYSICAL PROPERTIES

Coating Category: Two Component Coating - aerosol

Max. VOC (AP): 498 g/l; 4.2 lbs/gal

Max. VOC (LE): 587 g/l; 4.9 lbs/gal

Avg. Gallon Weight: 945 g/l; 7.9 lbs/gal

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Avg. Weight % Volatiles: 65.4%
Avg. Weight % Water: 0.0%
Avg. Weight % Exempt Solvent: 12.7%
Avg. Volume % Water: 0.0%
Avg. Volume % Exempt Solvent: 15.2%

Theoretical Coverage: 252.6 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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