



Fast Spot Primer 414

Technical Data Sheet: 483-40
P4145 / P4143

- 1. Introduction** ALEXSEAL® Fast Spot Primer 414 is an acrylic/epoxy-based fast dry and overcoat spot in finish primer with quick dry to sand characteristics.
- 2. Range of application** ALEXSEAL® Fast Spot Primer 414 is designed to spot prime a finished primed surface where break through areas have occurred to seal exposed under lying products.

Fast Spot Primer 414 should NOT be used below the waterline.
- 3. Color** Colors of mixture: Sand / Dark Gray
 Base material: Sand / Dark Gray
 Converter: Clear
- 4. Coverage** Volume Solids catalyzed without reduction: 33%
Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	Rec. DFT in μm (mils)
Theoretical	38	145	1558	13 - 25 (0.5 - 1)
Practical				
Conventional Air Spray Equipment	18	68	737	13 - 25 (0.5 - 1)
HVLP Air Spray Equipment	21	79	848	13 - 25 (0.5 - 1)

- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust, grease, oil and other contamination.

Break through spots in Urethane Topcoats, Epoxy Primers, and gel coat surfaces should be spot primed directly with ALEXSEAL® Fast Spot Primer 414 after sanding with 220 - 400 grit.

Refit and repair: Old coatings must have good adhesion and chemical resistance and must be cleaned and sanded with 220 - 400 grit. A compatibility test should be performed if the old coating is questionable.

Steel and Aluminum should initially be coated with an ALEXSEAL® Protective Primer.

ALEXSEAL® Fast Spot Primer 414 should NOT be applied to bare metal.

- 6. Trade names**
- | | | |
|---------------|-------|--|
| Base Material | P4145 | ALEXSEAL® Fast Spot Primer 414 Sand |
| | P4143 | ALEXSEAL® Fast Spot Primer 414 Dark Gray |
| Converter | C4147 | ALEXSEAL® Fast Spot Primer 414 Converter |
| Reducer | R4042 | ALEXSEAL® Epoxy Primer Reducer |

- 7. Mixing ratio**
- | | | |
|----------------------------|--------|--|
| 1 part by volume | P..... | ALEXSEAL® Fast Spot Primer 414 Base |
| 1 part by volume | C4147 | ALEXSEAL® Fast Spot Primer 414 Converter |
| 0 to 25 % reduction (vol.) | R4042 | ALEXSEAL® Epoxy Primer Reducer |
- Example: 1 : 1 : 1/2 = 25 % reduction for spray application

The amount of reducer required may vary depending on the application conditions.

Allow a 15 minute induction period after mixing base and converter, add reducer and remix.

414 may be reduced 0% up to 25% for a thin smooth application for use as a spot primer where necessary except on bare metal.

DO NOT USE Any ACCELERATOR ADDITIVES WITH THIS PRODUCT.



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8. Application

Viscosity	Zahn #2: ≈ 15 - 18 sec, DIN 4 cup 4mm: ≈ 14 - 18 sec
Nozzle Size Gravity Gun	1.0 to 1.4 mm (0.040 to 0.050) - Conventional & HVLP
Nozzle Size Siphon Cup	1.6 mm (0.060) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	1.0 to 1.3 mm (0.040 to 0.050) - Conventional & HVLP
Atomizing Pressure	3.0 to 5.0 bar (42 to 70 PSI) - Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 20 PSI) - Conventional & HVLP

Spray

Apply 1 or 2 coats to a wet film thickness (WFT) of 25 - 50 microns (1 - 2 mils) per coat. This will achieve a dry film thickness (DFT) of 15 - 30 microns (0.5 - 1 mils) for a 2 coat application. Maximum recommended film thickness during a spray application is 2 coats totaling 75 microns (3 mils) WFT, or 38 microns (1.5 mils) DFT.

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life - approx.	1 hrs	1 hrs	30 min	30 min	N/A
Dust Free	90 min	60 min	45 min	30 min	N/A
Tape Dry - without accelerator	30 hrs	24 hrs	18 hrs	14 hrs	N/A
Dry to sand	2 hrs	2 hrs	1 hr	1 hr	N/A
Fully Cured	11 days	9 days	7 days	5 days	N/A
Recoat with another coat of ALEXSEAL® Fast Spot Primer 414	30 min minimum	30 min minimum	15 min minimum	15 min minimum	12 hrs maximum
Overcoat with another product including 202, 302, 303, 328, 442 and 501. Sanding is required after max time.	3 hrs minimum	3 hrs minimum	2 hrs minimum	2 hrs minimum	12 hrs maximum
Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will effect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.					

10. Packaging

P4145	ALEXSEAL® Fast Spot Primer 414 Sand	1 QT
P4143	ALEXSEAL® Fast Spot Primer 414 Dark Gray	1 QT
C4147	ALEXSEAL® Fast Spot Primer 414 Converter	1 QT
R4042	ALEXSEAL® Epoxy Primer Reducer	1 QT & 1 GAL