



Axalta™ 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray



GENERAL

DESCRIPTION

A zinc chromate-free one component primer surfacer recommended for cars requiring wet-on-wet finishes on small areas or finishes with intermediate sanding. Axalta™ 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray are easy to use and apply and offers reliable adhesion and corrosion protection and may also be used as a weld-through primer.

Axalta 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray are 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 1K Primer Surfacer 400A Dark Gray
Axalta 1K Primer Surfacer 410A Light Gray

MIX RATIO

Ready-to-Use

SPECIAL TIPS

1. Shake aerosol for 2 minutes to ensure contents are uniformly mixed.
2. 0.3 mil dry film thickness is necessary for adequate corrosion resistance.
3. **Metal substrates must be primed within one half-hour of sanding or re-sanding is required.**
4. All traces of rust must be removed before applying Axalta 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray.
5. Do not recoat with polyester or epoxy products.
6. Do not use on reversible finishes.
7. We recommend the following three-stage system:
 - a. Prime with Axalta 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray.
 - b. Apply Spies Hecker® Permasolid® Surfacer, Cromax® Primer-Fillers, Standox® Fillers.
 - c. Apply Topcoat.
8. Once Axalta 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray has been applied at a film thickness of 1.0 – 1.2 mils, the repair area must be primed within a week's time or re-sanding or re-application of an additional layer of Axalta 1K Primer Surfacer 400A Dark Gray and 410A Light Gray Spray is required.
9. **Axalta 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray can be top-coated directly on small areas such as sand-throughs.**
10. **Do not apply seam sealer or chip guard directly to Axalta 1K Primer Surfacer 400A Dark Gray Spray and 410A Light Gray Spray or other 1K products.**

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)

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.

APPLICATION

Apply 1 to 2 medium coats with approximately 5 minutes intermediate flash-off between coats.

RECOMMENDED FILM THICKNESS

1 coat for 0.3 – 0.7 mil dry film thickness
 2 coats for 0.7 – 1.2 mils dry film thickness



DRY TIMES

AIR DRYING

Drying time at 68°F/20°C: 10-15 minutes

Dry to Sand: 45-60 minutes

DRY SANDING

Sanding: P500 – 800

RECOAT

With Spies Hecker® 2K Permasolid® Surfacer, Cromax® Primer-Fillers, Standox® 2K Fillers.



PHYSICAL PROPERTIES

Coating Category: Auto Body Primer - aerosol

Axalta 1K Primer Surfacer 400A Dark Gray

Max. VOC (AP): 482 g/l; 4.0 lbs/gal

Max. VOC (LE): 673 g/l; 5.6 lbs/gal

Avg. Gallon Weight: 796 g/l; 6.6 lbs/gal

Avg. Weight % Volatiles: 88.7%

Avg. Weight % Water: 0.2%

Avg. Weight % Exempt Solvent: 28.0%

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Avg. Volume % Water: 0.1%
Avg. Volume % Exempt Solvent: 28.2%

Axalta 1K Primer Surfacer 410A Light Gray

Max. VOC (AP): 481 g/l; 4.0 lbs/gal
Max. VOC (LE): 673 g/l; 5.6 lbs/gal
Avg. Gallon Weight: 801 g/l; 6.7 lbs/gal
Avg. Weight % Volatiles: 88.3%
Avg. Weight % Water: 0.2%
Avg. Weight % Exempt Solvent: 28.0%
Avg. Volume % Water: 0.1%
Avg. Volume % Exempt Solvent: 28.4%

Theoretical Coverage: 70.0 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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