

Finishing Primer 401

Technical Data Sheet: 153-11
P4098 / P4095

- 1. Introduction** ALEXSEAL® Finishing Primer 401 is a superior two component coating based on state of the art epoxy resins with excellent adhesion promoting properties on various substrates.
- After curing, ALEXSEAL® Finishing Primer 401 offers a stable and chemical resistant surface that is an ideal base for the “wet look” of ALEXSEAL® Premium Topcoat 501.
- 2. Range of application** ALEXSEAL® Finishing Primer 401 is used for adhesion promotion on various substrates including fiberglass and other properly prepared and primed surfaces. This product may be used above and below the waterline. ALEXSEAL® Finishing Primer 401 must be used to achieve the “wet look” of ALEXSEAL® Premium Topcoat 501.
- 3. Color** Colors of mixture: White
Dark Gray
- 4. Coverage** Coverage for ALEXSEAL® Finishing Primer 401 when applying 2 - 3 coats or passes in the same application period.
- Volume Solids catalyzed without reduction: 51 %.
- Theoretical:** 3.6 m² / l (152 sq. ft. per gallon) at recommended dry film thickness of 75 - 100 microns (3 - 4 mils).
- Practical:** **Conventional Air Spray Equipment:** 2.4 m² / l (100 sq. ft. per gallon) at recommended dry film thickness of 75 - 100 microns (3 - 4 mils).
HVLP Air Spray Equipment: 2.7 m² / l (115 sq. ft. per gallon) at recommended dry film thickness of 75 - 100 microns (3 - 4 mils).
Brush / Roller and Airless Spray Equipment: 3.6 m² / (152 sq. ft. per gallon) at recommended dry film thickness of 75 - 100 microns (3 - 4 mils).
- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust, grease, oil and other contamination.
- Fiberglass and gel coat should be coated directly with ALEXSEAL® Finishing Primer 401 after sanding with 100 - 150 grit.
- Refit and repair: Old coatings must have good adhesion and chemical resistance and must be sanded with 100 - 150 grit. A compatibility test should be performed if the old coating is questionable.
- Steel and Aluminum should initially be coated with P1095 ALEXSEAL® Protective Primer 101.
- Fairing Systems: ALEXSEAL® Finishing Primer 401 should be applied over ALEXSEAL® Super Build 302 after block sanding with 100 - 150 grit.
- 6. Trade names**
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|---------------|-------|--|
| Base Material | P4098 | ALEXSEAL® Finishing Primer 401, White |
| | P4095 | ALEXSEAL® Finishing Primer 401, Dark Gray |
| Converter | C4051 | ALEXSEAL® Finishing Primer 401 Converter |
| Reducer | R4042 | ALEXSEAL® Epoxy Primer Reducer (Spray) |
| Reducer | R5015 | ALEXSEAL® Topcoat Reducer Brush (Brush) |
| Accelerator | A4030 | ALEXSEAL® Epoxy Primer Accelerator 401 / 302 |
- 7. Mixing ratio**
- | | |
|-----------------------------|--|
| 2 parts by volume | ALEXSEAL® Finishing Primer 401 |
| 1 part by volume | C4051 ALEXSEAL® Finishing Primer 401 Converter |
| 20 to 25 % reduction (vol.) | R4042 ALEXSEAL® Epoxy Primer Reducer (Spray) |
| 10 to 15 % reduction (vol.) | R5015 ALEXSEAL® Topcoat Reducer (Brush) |
- Allow a 15 minute induction period after mixing base and converter, add reducer and remix.
Example: 2 : 1 : 3/4 = 25 % reduction for spray application
Example: 2 : 1 : 1/2 = 15 % reduction for brush application

Professional Use Only

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8. Application

Viscosity (Zahn #2)	approx. 25 sec
Fluid Nozzle Size	1.2 to 1.6 mm (0.046 to 0.060) - 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
Airless Equipment	Tip 0.35 - 60 to 0.43 - 60 mm (0.014 - 60 to 0.017 - 60)
Airless Equipment	Pressure 3.0 to 5.0 bar (42 to 70 PSI)

Spray & Brush

Apply 2 coats to a wet film thickness (WFT) of 75 - 125 microns (3 - 5 mils) per coat. This will achieve a dry film thickness (DFT) of 75 - 125 microns (3 - 5 mils) for a 2 coat application. Minimum recommended film thickness before sanding is 75 microns (3 mils) DFT. Maximum recommended film thickness during a spray application is 2 coats totaling 250 microns (10 mils) WFT, or 125 microns (5 mils) DFT.

Accelerator

A4030 ALEXSEAL® Epoxy Primer Accelerator for 401 / 302 is used to reduce the drying time of ALEXSEAL® Finishing Primer 401. At the same time, use of A4030 ALEXSEAL® Epoxy Primer Accelerator for 401 / 302 reduces the pot life.

Per each 1 gallon of ALEXSEAL® Finishing Primer 401 base, a maximum of 1 Pint (16 ounces) of A4030 ALEXSEAL® Epoxy Primer Accelerator for 401 / 302 may be added. Additional quantities of accelerator reduce pot life, and are not recommended. When applying ALEXSEAL® Finishing Primer 401 directly on metal substrates do not use A4030 ALEXSEAL® Epoxy Primer Accelerator 401 / 302. Mix ratio quantity for A4030 is for base quantity used in mixture.

9. Pot life and Drying

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.	12 hrs	12 hrs	12 hrs	12 hrs	N/A
Pot Life - with A4030 ALEXSEAL® Epoxy Primer Accelerator 401 / 302	6 hrs	6 hrs	6 hrs	6 hrs	N/A
Dust Free	90 min	60 min	45 min	30 min	N/A
Tape Dry - without accelerator	30 hrs	24 hrs	18 hrs	12 hrs	N/A
Tape Dry - with A4030 ALEXSEAL® Epoxy Primer Accelerator 401 / 302	24 hrs	18 hrs	12 hrs	12 hrs	N/A
Fully Cured - without accelerator	11 days	9 days	7 days	5 days	N/A
Recoat with another coat of ALEXSEAL® Finishing Primer 401	3 hrs minimum	2 hrs minimum	1 hr minimum	1 hr minimum	24 hrs maximum
Overcoat with another product including 302, 442, and 501. Sanding is required after max. time.	12 hrs minimum	12 hrs minimum	12 hrs minimum	12 hrs minimum	24 hrs maximum

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity of reducer, and film thickness will effect actual times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F).

10. Packaging

P4098	ALEXSEAL® Finishing Primer 401, White	1 QT & 1 Gal & 2 Gal
P4095	ALEXSEAL® Finishing Primer 401, Dark Gray	1 QT & 1 Gal
C4051	ALEXSEAL® Finishing Primer 401, Converter	1 PT & ½ Gal & 1 Gal
R4042	ALEXSEAL® Epoxy Primer Reducer	1 QT & 1 Gal
R5015	ALEXSEAL® Topcoat/Primer Reducer Brush	1 QT & 1 Gal
A4030	ALEXSEAL® Epoxy Primer Accelerator 401 / 302	1 PT

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