

# Nason<sup>®</sup> Industrial HB Etch Primer

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## Product Description

A single pack epoxy PVB High-Build etch primer, which can be applied as wet-on-wet or with intermediate sanding.

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## Gloss

Matt.

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## Colour

Mid Grey.

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## Product Features

- Excellent adhesion to ferrous & non-ferrous metals; fibreglass
- Rapid dry
- Overcoat with most 1K/2K topcoats
- As a metal primer at higher DFT
- Barrier coat on unknown coatings

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## Product Benefits

- More competitive applied costs than abrasive blasting
- Fast to topcoat high productivity
- Flexible performance & cost systems
- Corrosion protection for smooth steel
- Cost effective for site maintenance

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## Product Uses / Applications

As a shop or site primer directly over properly prepared metal substrates including: mild steel, stainless steel, galvanized steel, zinc plated steel, Zinccaneal, Zincolume<sup>®</sup>, Colorbond<sup>®</sup>, aluminium, chrome, brass, copper, lead and alloys.

- Metal fabrications;
- Mobile mining, earthmoving, construction and agricultural equipment;
- Industrial plant equipment and machinery;
- Internal architectural elements.

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## Not recommended for

Immersion service or over thermoplastic paintwork.

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## Physical Data

Volume Solids:	19.87%
VOC (RFU):	649 g/L
Specific Gravity:	1.07 g/cm <sup>3</sup>
Theoretical Coverage at 20 µm DFT:	9.94 m <sup>2</sup> /L



**Dry Time** 20°C & 50% RH at recommended film thickness

Dry to Sand:	30-60 minutes or bake for 30 minutes @ 60°C
Dry to Handle:	30-60 minutes
Full Cure:	90 minutes
Time to recoat with a topcoat:	from point of egg shell gloss (minimum 15 min) to 24 hours. Sanding is recommended after 24 hours to ensure optimum adhesion with topcoat.

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## Surface Preparation

Cleaning:	Degrease using an Axalta approved wax and grease remover.
Sanding:	P120 sandpaper.



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### Application

Mix thoroughly. Add up to 20% by volume of 861-61 Nason® Industrial QD HD Reducer or 821-65 Nason® Industrial Multi Thinner or 861-62 Nason® Industrial Epoxy Reducer. Filter material prior to spray application.



This product is intended for use by professional trade and industrial applicators in compliance with relevant Health, Safety & Environmental standards and legislation. The applicator must use suitable Personal Protective Equipment (PPE), in particular full body coverall, gloves, goggles and air respirator. Provide adequate ventilation when using in confined spaces. For more detailed information, refer to Material Safety Data Sheets of the products used.

This Technical Data Sheet is issued by Axalta Coatings Systems as a guidance only. The information contained herein is current and correct to the best of our knowledge at the time of issuance. The user must ensure suitability of the product and its performance for the application at hand. Axalta Coating Systems assumes no responsibility nor provides any warranty.

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### Application Conditions

Do not apply if material, substrate or ambient temperature is less than 10°C or above 45°C. The substrate must be at least 3°C above the dew point. Relative humidity should be below 85%.

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### Spray Gun Setup

Airless: 0.23 – 0.28 mm min. 1500 psi  
Conventional: 1.8 – 2.0 mm 3 - 4 bar 45 – 60 psi  
Refer to spray equipment documentation for setting recommendations.  
Number of coats: 1 (10-15 µm) – wash primer  
1-2 (20-35 µm) – wet-on-wet  
2-3 (30-50 µm) – with sanding  
Flash-off times between coats : 10 - 15 minutes

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### Cleanup Solvents

Axalta recommended gun cleaning thinner, such as 861-61 Nason® Industrial QD HD Reducer or 861-62 Nason® Industrial Epoxy Reducer.

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### Topcoat With

1K topcoats Nason® Industrial QD Gloss Enamel, 303-30 Nason® Industrial Silver Enamel or Nason® Industrial QD HD Gloss Enamel), or 1K Nason Industrial NI640/650 enamels, 2K primer/surfacer, or 2K topcoats Nason® Industrial Full-Thane 2K Urethane or NI610/620 PU topcoats.

NOTE: Do not recoat with polyester products or epoxy primers.

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### Dry Film Characteristics\*

Heat Resistance: up to 65°C dry heat  
Exterior Exposure (when topcoated): VERY GOOD  
Acid Resistance: GOOD  
Alkali Resistance: GOOD  
Oil and Petrol Resistance: GOOD  
Water Resistance (when topcoated): GOOD

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### Shelf Life

6 months minimum in sealed original container.  
Store at room temperature away from direct sunlight.

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### Availability

Nason® Industrial HB Etch Primer grey	20 L	707-05
Nason® Industrial QD HD Reducer	4 L	861-61
Nason® Industrial QD HD Reducer	20 L	861-61
Nason® Industrial Epoxy Reducer	20 L	861-62
Nason® Industrial Epoxy Reducer	4 L	861-62
Nason® Industrial Multi Thinner	20 L	821-65
Nason® Industrial NI 640 enamel binder	20L	ST100-640
Nason® Industrial NI 640 enamel binder	12L	ST100-640
Nason® Industrial NI 650 enamel binder	20 L	ST100-650
Nason® Industrial NI 650 enamel binder	12L	ST100-650
Nason® Industrial Std High OH 2K PU binder	10 L	ST100-610
Nason® Industrial Std High OH 2K PU binder	20 L	ST100-610
Nason® Industrial Std 2K PU binder	10 L	ST100-620
Nason® Industrial Std 2K PU binder	20 L	ST100-620

