

# Painter Application Tips

## **XIM 400W ES**

**Low VOC Modified Alkyd Bonding Primer**  
[ Meets 200 g/l VOC Rule Limits ]

400W ES is a low VOC alkyd bonding primer that uses acetone as an exempt solvent.

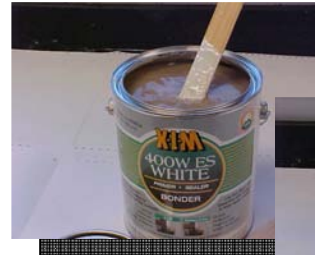
**Acetone** is the strong solvent used in aerosol cans to lower the viscosity and promote easy atomization for spraying.

The first thing you may notice when you open the can is a dark acetone layer may have formed at the top of the primer.

This will stir in easily.

As you stir the primer you will notice that it seems very thin. It actually has higher solids than the regular XIM 400W. The lower viscosity is due to acetone!

Handling low viscosity primers and sealers is done all the time by professional painters applying acetone thinned lacquers and furniture varnishes. **Here's how!**



### **When Spraying -**

**First . .** As you pour or transfer the 400W ES to the **Spray Cup** or the **Pressure Pot**, make sure you are grounded.

**Second . .** Pour carefully so you don't spill. The technique is the same as pouring straight solvent.

Recommended Spray Settings:

**HVLP:** Any Manufacturer  
Pressure: 8 psi  
Tip size: 9 Cap

**Airless:** Any Manufacturer  
Pressure: Less than 1500 psi  
Tip size: 0.011 to 0.015

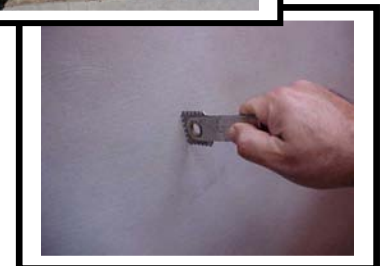
Because of the acetone, the 400W ES will atomize easily.

The acetone solvent will evaporate quickly, **BUT** there is also a slower solvent present – it is this slower solvent that allows you to build a thicker film – if you need to.

The slower solvent also **eliminates “Dry Spray”**.

Apply a light, but wet mist coat followed by a second light to medium coat. **Remember – With XIM 400W ES all you need is 1 mil DFT, or a total wet film of 1.3 mils after the acetone has flashed off. (3.0 mils wet before flash off)**

**Do not build 400W ES to hide. This is a “bonding primer” and should be applied thinly.**



## When Brushing -

### **Recommended Brushes:**

**China Bristle / Nylon Fiber blend brush** such as Wooster Advantage 4737 or equivalent, or Wooster Advantage 4732 Sash brush. Brushes designed for thin, solvent based varnishes.

**First . .** When you load the brush, wipe off the excess  
The trick is not to load the brush too heavily.

**Second . .** When starting to brush, stroke out with light pressure.

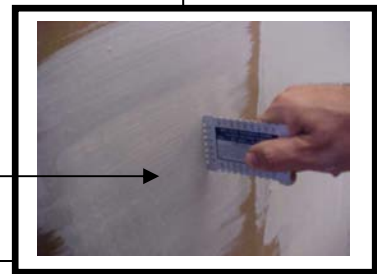
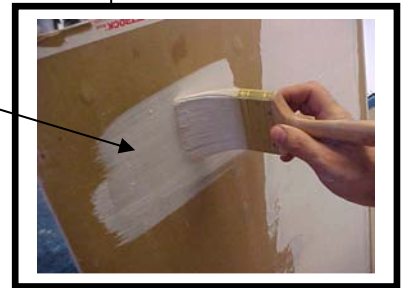
The easy brushing stroke will eliminate drips and runs while the



The acetone solvent will evaporate quickly

The slower solvent that remains allows good brushability !

**Remember – With XIM 400W ES all you need is 1 mil DFT, or a total wet film of 3 mils.**



## When Using A Roller-

### **Recommended Roller Cover:**

**¼ inch mohair cover**, such as Wooster R 209 or equivalent, designed for epoxies, urethanes and smooth surfaces.

**3/16 inch nap, shed resistant cover** designed for varnishes and enamels, or **3/16 inch foam cover – Wooster R-265 Pro Tiz**

**First . .** When you load the roller, roll off the excess. The trick is not to load the roller too heavily.

**Second . .** When starting to roll, roll with light pressure.

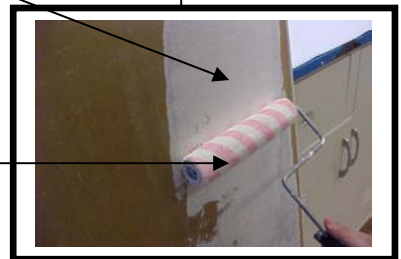
The easy rolling stroke will eliminate drips and runs while the acetone evaporates.



The acetone solvent will evaporate quickly

The slower solvent that remains allows good workability !

**Remember – With XIM 400W ES all you need is 1 mil DFT, or a total wet film of 3 mils.**



## **Application Properties**

### **Drying Schedule (ASTM D1640)**

**To Touch:** Generally 20-30 min. Can be up to 24 hours depending on Temperature and film thickness.

**To Top Coat:** 2-3 hours @ 77deg. F and 50% RH. 24 hours if fast-dry Dry Fall or Deep-Tinted Top Coat

**Dry Hard:** 7-14 days @ 77deg. F and 50% RH.

**Full Cure:** 7-14 days. (Will depend on temperature and film thickness)

**Application Conditions:** 50 deg. F to 90 deg. F (Mix or Agitate before Use)

**Spreading Rate:** 650 to 750 sq feet per gallon depending on thickness

**Recommend Film Thickness:** 0.75 to 1.25 mils dry

(Since acetone evaporates quickly a measurement of 1.0 to 1.7 mils wet)

**Top Coats Recommended:** Oil Alkyd, Latex

**Not Recommended:** 2K Urethane, 2K Epoxy, or Lacquers

**Viscosity:** 15 seconds #2 Zahn Cup

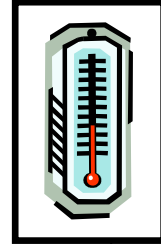
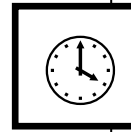
**Flash Point:** 0 deg. F (ASTM 3278-82)

**VOC:** Less than 200 gm/l, 1.17 lb/gal

### **Special Considerations:**

- When the top coat is a deep, heavily tinted custom color or a Dry Fog top coat, allow the 400W ES to dry for 24 hours before applying the top coat.
- When 400W ES is applied over existing paints and finishes, it may soften or wrinkle the finish. Always test a small area first for compatibility.
- Flexible seams or caulks may cause cracking or loss of adhesion when coated with 400W ES. Not recommended for 100% silicone caulks.
- Plan your job in advance and always caulk seams and edges after painting
- When priming over previously painted surfaces, always test a small area by applying the 400W ES to see if the strong solvent acetone is going to "lift" or "wrinkle" the old paint.
- The container lid employs a gasket to prevent evaporation of the acetone. When less than the full container has been used, careful resealing with the gasket in position is important to prevent solvent evaporation during storage.

**Clean Up:** XIM Reducto, XIM GON Cleaner or mineral spirits.



## **Safety Tips**

### **CONTAINS : Acetone, Methyl Ethyl Ketone, Petroleum Distillates**

Vapor Harmful. May affect the brain and nervous system causing dizziness, headache or nausea. Causes eye, nose, throat, lung and skin irritation. Harmful if swallowed

**Use only with adequate ventilation.** Do not breathe vapor or spray mist. Ensure fresh air entry during application and drying. If you experience eye watering, headache or dizziness or if air monitoring demonstrates vapor or mist levels are above applicable limits, wear and appropriate, properly fitted respirator (NIOSH approved) during and after application. Follow the respirator manufacturer's directions for respirator use. Avoid contact with eyes, skin and clothing. Wear safety glasses or goggles. Wash thoroughly after handling.

**FIRST AID:** If you experience difficulty in breathing, leave the area to obtain fresh air. If continued difficulty is experienced, get medical assistance immediately. In the case of eye contact, flush with plenty of water for at least 15 minutes and get medical attention immediately; for skin, wash thoroughly with soap and water. If swallowed, do not induce vomiting. Get medical attention immediately.

**Spray Gun Usage:** When applying with spray gun equipment, vapors can build up rapidly and may cause flash fire. Contact the spray equipment manufacturer for recommendations when spraying with acetone based products. With all applications: vapors may travel to areas away from the work site and ignite; use only where moving air will carry vapors outside.

**KEEP OUT OF REACH OF CHILDREN**

If spilled, contain spilled material and remove with inert absorbent. Dispose of contaminated absorbent, container and unused contents in accordance with local, state and federal regulations.

