



400 Clear Flash Bond Primer/Sealer/Bonder

Surface Applications:

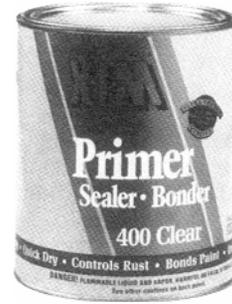
- Wood
- Plywood
- Hardboard
- Rattan
- Wicker
- Wallboard
- MDO Board
- PVC Plastic
- Fiberglass
- Glass
- Tile
- Porcelain
- Iron
- Steel
- Tin
- Aluminum
- Copper
- Brass
- Magnesium

Features & Benefits

- Quick Dry
- Interior/Exterior
- Dries Clear
- Helps Paint Bond
- Used as an Alkyd Fortifier
- Seals and Protects
- Helps Inhibit Rust
- Helps Prevent Flaking,
Blistering, Peeling

Product Description:

400 Clear is an ultra-premium solvent based primer/sealer/bonder developed to solve many painting problems. It provides excellent adhesion, sealing and bonding on many hard-to-coat surfaces. Most clean and dull paintable surfaces may not need sanding, but sanding or dulling the surface is required on hard, glossy surfaces for maximum adhesion. XIM 400 Clear can be used as an alkyd paint fortifier to improve the alkyd's adhesion and durability.



Product No. 1101

Product Use:

400 Clear is an ideal prime coat for Wood, Ferrous metals and Non-ferrous metals, Plaster, Formica, Some Plastics, Glass, Tile, Fiberglass and Hardboard. Because there are many types of surfaces, plastics and composite materials, always test a small area first for adhesion and topcoat compatibility. 400 Clear is not recommended for tubs, sinks or showers where continuous water contact occurs. If extra corrosion protection is needed when coating iron or steel, XIM 360 Rust Inhibiting Bonding Metal Primer is recommended. On extremely porous surfaces, very rough or severe staining types of wood a second coat of XIM 400 Clear may be needed prior to application of the finish coat(s). 400 Clear can be used for both indoor and outdoor applications and is recommended for use with oil/alkyd topcoats. If you are planning to use a latex topcoat use XIM 400 White or completely dull or sand the 400 Clear's film for better adhesion by the latex. Some highly tinted/deep custom mixed topcoats can cause the 400 Clear to soften and lift. Always check a small area for compatibility before proceeding with the job. Not recommended for use with two component top coats or top coats that contain strong solvents such as lacquers. Not to be used where any alkalinity or high pH is present. Not recommended for use on polyethylene, Teflon, Kynar or Nylon. 400 Clear is not intended to be used as an exterior clear wood finish or as a topcoat clear finish.

Packaging Data: 400 Clear is available in:

16 oz. Aerosols	-	12 per carton
Pints	-	12 per carton
Quarts	-	6 per carton
Gallons	-	4 per carton
Pails	-	5 gallon capacity (pull out spout)
55-Gallon Drums		

Technical Service Information: For further information about this or any X-1-M architectural product, contact our Technical Service Staff at 1-800-262-8469.

Product Preparation: 400 Clear is ready to use from the can. No mixing, shaking or thinning is required. If tinting is desired, use universal tinting colors, not to exceed two ounces of tint to each gallon.

Surface Preparation: Careful surface preparation is the key to a good result. Be sure the surface is thoroughly clean and dry, free from all grease, wax, oil, loose paint, and dirt. Where bare wood is exposed, feather the edge around the bare spots. Avoid painting during damp weather. On exterior wood surfaces, allow at least three days of good drying weather before applying 400 Clear. When 400 Clear is applied over a previously painted surface, a trial test should be made on a small area to be sure no lifting of the old paint occurs. When coating difficult-to-coat surfaces such as glass or metal, solvent wiping is first recommended. Wipe down surface with X-1-M GON™ Cleaner, or xylene. Do not use mineral spirits, turpentine, or any oily cleaning solvent. For very hard glossy surfaces, roughing the surface with a carbide sandpaper before applying 400 Clear will improve adhesion.

Limited Warranty: This product is made to the highest standards in order to provide you with consistently optimum results. If this product fails to perform as specified herein, X-1-M will furnish an equivalent amount of replacement X-1-M product, or will refund the purchase price upon proof of purchase. X-1-M will not be liable for any indirect or consequential damages. **There are thus no warranties of fitness or merchantability** beyond that provided above. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

X-I-M ... When Ordinary Primers Are Not Enough!™



400 Clear Flash Bond Primer/Sealer/Bonder

How to Apply: Use brush, roller or spray. Temperature should be between 50°F and 100°F. X-1-M 400 Clear will dry to touch very quickly (1 hour). When using brush or roller, avoid excessive brushing or rolling because the 400 Clear can tack the applicator to the recently applied sealer. Work in small areas and apply evenly. If an area is missed, wait a few minutes until the sealer has dried before touching up. X-1-M 400 Clear can be topcoated in one to two hours. On extremely porous surfaces a second coat of XIM 400 Clear may be needed prior to application of the finish coat(s). One gallon will cover approximately 500 square feet of non-porous surface.

Spray Gun Usage: When applying with spray gun equipment, vapors can build up rapidly and may cause flash fire. With all applications: Vapors may travel to areas away from work site and ignite; use only where moving air will carry vapors outside. For conventional spray equipment reduction is not required. Recommended air pressure is 30 to 40 psi at the gun. Best results are obtained at temperatures in the range of 50°F to 100°F.

Clean-up: Clean equipment with XIM GON, XIM Reducto™, VMP thinner or mineral spirits, as soon as possible following application.

Caution: Close container after each use. Use only with adequate ventilation. Do not take internally. Keep out of reach of children. Harmful or fatal if swallowed. Keep away from heat, sparks and flame. Vapors may cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn off stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation.

First Aid: If swallowed, do **not** induce vomiting. Call a physician, poison control center or hospital emergency room immediately. Avoid contact with eyes. If there is eye irritation, get medical attention immediately. Avoid prolonged skin contact and avoid breathing in vapor.

Potential Applications:

Building Material Plastic: Including PVC sheeting and piping, vinyl shutters, vinyl molding and mill work, laminated Formica paneling and cabinets as well as fiberglass garage doors and other molded parts. First remove old, loose paint then clean away wax, dirt, grease and other contaminants from the surface with a strong abrasive detergent. Wipe the surface with a cleaning solvent such as XIM GON Prep or Xylene (especially important to remove any mold-release compounds). Dry, then scuff sand the surface for maximum adhesion. Apply the 400 bonding primer (only one coat required). Allow the 400 C to dry for 1-2 hours, then apply the top coat.

Tile, Glazed Block and Brick, Porcelain: Decorative surfaces such as these can be restored and painted. First remove old, loose paint and debris. Repair or patch broken or damaged areas. Then clean away wax, dirt, grease and other contaminants from the surface with a strong abrasive detergent. Wipe the surface with a cleaning solvent such as XIM GON Prep or Xylene (especially important to remove any mold-release compounds). Dry, then scuff sand the surface for maximum adhesion. Apply the 400 C bonding primer (only one coat required). Allow the 400 to dry for 1-2 hours, then apply the top coat. Note: XIM 400 C is not recommended for sinks, tubs or shower areas where standing water accumulates.

Oil/alkyd paint fortifier: 400 Clear can be added to oil/alkyd paint to improve the adhesion and durability. The blending ratio is generally one half to one quart of 400 Clear per gallon of alkyd paint. Always check for compatibility by mixing small amounts before proceeding.

Physical Data:	For 400 Clear as Supplied
Weight per Gallon	6.74 lbs.
Non-Volatile	22.6% by weight, 16.5% by volume
Viscosity	16 +/- 1 sec. (#2 Zahn Cup)
Spreading Rate	300 sq. ft. @ 1.0 mil DFT 600 sq. ft. @ 0.5 mil DFT
Applications conditions	50 deg. to 100 deg. F
Dry schedule to touch	1 hour+ at 77 deg. F and 50% RH
ASTM D1640 to recoat	1-2 hours at 77 deg. F and 50% RH
dry hard	24-48 hrs at 77 deg. F and 50% RH
Flash point	ASTM 3278-82 55 deg.F
VOC	626 gm/l, 5.22 lb/gal.

Physical Data:	For 400 Clear as Cured Film
Recommended film thickness	0.30 to 0.75 mils dry
Cross Hatch	ASTM D3359, Method B, no loss (Surface applications as recommended)
Impact resistance	ASTM D2794, 120 in-lb., steel
Gloss	Glossy
Top Coats	Oil / alkyds Latex (400 Clear must be scuff sanded)
(Test gloss and semi-gloss latex paints before proceeding)	
Not Recommended: 2 Component Urethanes and Epoxies Lacquers & strong solvent Paints	

Note: Read MSDS before use and follow label instructions.

X-1-M Products, Inc
11 69 Bassett Road, Westlake, Ohio 44145 U.S.A.
1-(800)262-8469