

Astro Clear 419-00™ Integrated Clear



GENERAL

DESCRIPTION

Designed for use with Nasco™ and Ful-Base® Enamels, Astro Clear 419-00™ Integrated Clear adds depth of gloss and durability to color coats and can be used both as a topcoat or integrated clear.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Astro Clear 419-00™ Integrated Clear
 Kwik-Kure 483-08™ Enamel Activator
 Ful-Base® 441-XX Reducer
 Nasco™ Gloss-E™ 483-13 Gloss Additive (Mid-Temp)
 Nasco™ Gloss-E™ 483-14 Gloss Additive (Low-Temp)

MIX RATIO

Combine the components by volume. Mix thoroughly prior to activation.

Option 1

Component	Volume
Astro Clear 419-00™ Integrated Clear	4
Kwik-Kure 483-08™ Enamel Activator	1
Ful-Base® 441-XX Reducer	1

Option 2

Component	Volume
Astro Clear 419-00™ Integrated Clear	2
Nasco™ Gloss-E™ 483-13 / 483-14 Gloss Additive	1

SPRAY VISCOSITY

12-13 seconds in a #2 Zahn Cup

POT LIFE

4 hours 70°F (21°C)



APPLICATION

SPRAY PRESSURE

Conventional

Gravity Feed:	40-70 PSI at the gun
HVLP:	8-10 PSI at the cap

TYPICAL GUN SET-UPS

Conventional & HVLP:	1.3-1.6 mm
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APPLICATION

Allow color coat to flash 20 minutes. Apply 2-3 (max) coats. Flash 15 minutes between coats.

BUFFING

Allow to dry overnight. Use fine grit (1200 or finer). Follow Polish Manufacturer's recommendations.

CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with lacquer thinner or low VOC cleaner in VOC regulated markets.

IMPORTANT NOTES

When integrating Astro-Clear 419-00™ Integrated Clear, use the appropriate Nason® hardener in the proper ratios in both the color and the clear.



DRY TIMES

AIR DRY

Out of dust:	30 minutes
Tack Free:	45-60 minutes
Hard:	Overnight
To Tape:	Overnight

FORCE DRY

20-30 minutes at 120-140°F (49-60°C)



PHYSICAL PROPERTIES

All Values Ready To Spray

419-00 Clearcoat

Max. VOC (LE)	
Max. VOC (AP)	
Avg. Gal. Wt.	
Avg. Wt.% Volatiles	
Avg. Wt.% Exempt Solvent	
Avg. Wt.% Water	
Avg. Vol.% Exempt Solvent	
Avg. Vol.% Water	

Mix Ratio 4:1:1

4.7 lbs./gal (563 g/L)
4.6 lbs./gal (552 g/L)
7.72 lbs./gal (925 g/L)
60.8%
1.2%
0.0%
1.2%
0.0%

Mix Ratio 2:1

4.9 lbs./gal (583 g/L)
4.8 lbs./gal (575 g/L)
7.65 lbs./gal (917 g/L)
63.9%
1.1%
0.0%
1.2%
0.0%

Theoretical Coverage:	471 ft ² (43.8 m ²) at 1 mil
Recommended Dry Film Thickness:	2.0 mils in 2 coats
Flash Point:	See SDS/MSDS

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/MSDS 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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In the United States:
1.855.6.AXALTA
nasonfinishes.com

In Canada:
1.800.668.6945
nasonfinishes.ca

