

FastDry™ 1K Acrylic Enamel Topcoat (IE Quality)



GENERAL

DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, acrylic enamel single-stage topcoat designed for easy refinishing of machinery and equipment.

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



MIXING

COMPONENTS

- FastDry™ 1K Acrylic Enamel Topcoat (IE Quality)
- Ful-Base® 430-XX System Tints
- FastDry™ 435-96™ 1K Acrylic Enamel Binder
- Ful-Base® 441-20™ Reducer (Low-Temp)
- Ful-Base® 441-21™ Reducer (Mid-Temp)
- Ful-Base® 441-22™ Reducer (High-Temp)

MIX RATIO

Combine the components by volume (8:2). Mix thoroughly prior to activation.

Component	Volume
FastDry™ 1K Acrylic Enamel Topcoat (IE Quality)	8
Ful-Base® 441-2X Reducer	2

POT LIFE

Not applicable for non-catalyzed material.

SPRAY VISCOSITY

19-21 seconds in a Zahn #2



APPLICATION

SURFACE PREPARATION

Before sanding, wash with soap and water and remove wax and grease with Nason® 441-05™ Silicone and Wax Remover or 481-75™ Surface Cleaner (use locally permitted cleaner in regulated areas) using clean rags. Sand finishes according to primer or substrate recommendations and chemically treat large bare metal areas.

COMPATIBLE PRODUCTS

Compatible with all Nason® primers, primer-surfacers and sealers.

SPRAY PRESSURE

Conventional

Siphon Feed:	40-70 PSI at the gun
Pressure Feed:	40-70 PSI at the gun
	8-12 PSI Fluid Flow on the pot

HVLP:	8-10 PSI at the air cap
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GUN SETUP

Conventional

Siphon Feed:	1.6-1.8 mm
Gravity Feed:	1.4-1.6 mm
Pressure:	0.8-1.2 mm

HVLP

Siphon Feed: 1.5-1.8 mm
 Gravity Feed: 1.3-1.6 mm

APPLICATION

Solid Colors: Apply 1 medium wet coat. Allow to tack. Apply 1 full wet coat.

Metallic Colors: Apply 2 medium wet coats. Flash 5-10 minutes between coats. A third and final "mist" coat may be applied if necessary to even the metallic.

CLEANING OF PAINT EQUIPMENT

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



DRY TIMES

AIR DRY

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

FORCE DRY

20-30 minutes at 120-140°F (49-60°C)

All dry times are at normal temperatures, lower temperatures will require longer dry times.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE): 5.0 lbs./gal (600 g/L)
 Max. VOC (AP): 4.9 lbs./gal (588 g/L)
 Avg. Gal. Wt.: 7.97 lbs./gal (955 g/L)
 Avg. Wt.% Volatiles: 63.2%
 Avg. Wt.% Exempt Solvent: 1.6%
 Avg. Wt.% Water: 0.0%
 Avg. Vol.% Exempt Solvent: 1.9%
 Avg. Vol.% Water: 0.0%
 Theoretical Coverage: 448 ft² (41.6 m²) at 1 mil
 Recommended Dry Film Thickness: 2.0 mils
 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

