

# FastDry™ 1K Acrylic Enamel



414-49053 Frost White



414-40507 John Deere Green



414-9745 New Cat. Yellow



414-3006 White



414-41925 Silver Metallic



414-6294 Omaha Orange



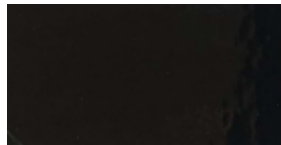
414-30073 Tractor Gray



414-9728 John Deere Yellow



414-6295 A.C. Orange



414-1000 Black



414-9726 Transport Yellow



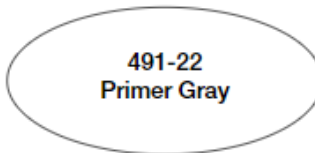
414-70437 Implement Red



414-2659 National Blue



414-9725 Caterpillar Yellow



**FastDry™ 1K Acrylic Enamel single-stage, factory packaged topcoat is designed for quick, easy and economical refinishing of machinery and equipment.**

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**MIXING & REDUCING:**

Mix:

8 parts Nason® FastDry™ Acrylic Enamel

2 parts Ful-Base® Reducer

Ful-Base® 441-20™ Fast (50-65°F)

Ful-Base® 441-21™ Medium (65-85°F)

Ful-Base® 441-22™ Slow (85°F +)

Example: Reduce one gallon of Nason® FastDry™ Acrylic Enamel with 1 quart Ful-Base® 441-XX™ Reducer.

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**POT LIFE:**

Not applicable for non-catalyzed material.

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**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™ Aerosol 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.

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**PRIMER:**

Compatible with all Nason® Primers

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**PRIMER-SURFACER:**

Compatible with all Nason® Primer-Surfacers

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**SEALER:**

Compatible with all Nason® Sealers

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**SPRAY VISCOSITY:**

19-21" #2 Zahn Cup

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**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 and usage recommendations in the VOC Compliant Products Chart for your area.

Visit [www.nasonfinishes.com](http://www.nasonfinishes.com) for additional product information.

**1.855.6.AXALTA**  
**nasonfinishes.com**

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**TYPICAL GUN SET-UPS:**

**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

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**APPLICATION:**

**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

**Solid Colors:**

Spray medium wet coat, allow to tack, then follow with a full wet coat.

**Metallic Colors:**

Apply 2 medium wet coats with 5-10 minutes flash time between coats. A third and final "mist" coat may be applied, if necessary, to even the metallic.

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**DRYING TIME:**

Out of Dust: 30 minutes

Tack Free: 45-60 minutes

Hard: Overnight

Force Dry: 20-30 minutes at 120-140°F

All dry times are at normal temperatures. Lower temperatures will require longer dry times.

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**PHYSICAL PROPERTIES:**

VOC LE: 5.0 lbs/gal maximum, ready-to-spray

Theoretical Coverage: 448 Sq. Ft. @ 1 mil

Weight Solids: 35.5% average

Volume Solids: 28.0% average

Recommended Dry Film Thickness: 2.0 mils

Flash Point: See MSDS