



# Nason<sup>®</sup>XL National Rule Blending Additive




**COMPONENTS**  
NasonXL Blending Additive  
447-65, 447-75, or 447-85  
Reducers




**APPLICATION**  
1 coat  
4 - 8 minute flash before  
applying color




**MIX RATIO**  
2 : 1



**DRY TIME**  
To Clearcoat  
15 - 20 Minutes



**VISCOSITY**  
Ford #4  
16 seconds



**VOC**  
779 grams / liter  
6.5 lbs / gallon



## GENERAL



### DESCRIPTION

Blending Additive 442-56 is a specialized, colorless basecoat designed for tri-coats, wet beds, intercoat clear, design work and light or hard to control metallics. Color blender is not intended for use as a durable topcoat clear, it must be over coated with clearcoat. Specially formulated to be intermixed with NasonXL topcoats.

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



## MIXING

### COMPONENTS

Wet bed-intercoat clear: Mix 2 parts NasonXL Blending Additive 442-56 to 1 part Nason XL Reducer (447-65, 447-75, or 447-85).

Translucent blending procedure: Add equal amounts of reduced NasonXL Blending Additive 442-56 to the remaining reduced NasonXL basecoat and mix well. This creates a translucent basecoat to be used in the blending process only, when spraying difficult colors.

Option for longer re-coating: Add 5% hardener to premixed basecoat

### Component

Component	Volume
Nason XL Blending Additive 442-56	2
Nason XL Reducers (447-65 Fast, 447-75 Medium, or 447-85 Slow)	1

### Package Sizes

- 1 Gallon (3.75 Liters)

### INITIAL APPLICATION VISCOSITY

Ford #4 Viscosity 16 seconds



## APPLICATION



### APPLICATION EQUIPMENT

HVLP Gravity	1.3 -1.4 mm	1.0 - 1.5 (Bar)	6-8 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	1.0 - 1.5 (Bar)	17-19 PSI	At gauge

Note: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

### APPLICATION

Wet bed: Apply a single coat with 4 - 8 minute flash off before applying colors over wet bed.

Translucent blending: Apply an additional coat of this translucent basecoat color, blending out past the repair area.

### RECOAT

Blending Additive must be clearcoated for durability. Allow Blending Additive and basecoat to thoroughly flash before applying clearcoat. Apply clearcoat within 12 hours or extend up to 24 hours when hardener is added to the basecoat. Cooler temperatures may require longer flash times.



## DRY TIMES

### AIR DRY

**75°F (23°C)**

Hand Slick	5 Minutes
Dust Free	5 Minutes
Tape Free	20 Minutes
To Clearcoat	15 - 20 Minutes
Dry to Handle	Overnight (after clear)



## PHYSICAL PROPERTIES

Recommended Film Thickness	± 10 Micron / 0.39 mils
VOC as Applied	6.5 lbs/gallon (RFU)
Mixed Volume Solids	11-13% (Average)
Theoretical Coverage	Approx. 193 Sq. Ft. @ 1 Mil DFT/mixed gallon
Recommended Coats	2-3 (x1)
DFT per Coat	Approximately 0.5 mil
Ford #4 Viscosity	16 Seconds

### STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

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## VOC REGULATED AREAS

Max VOC (LE): 791.8 g/L (6.6 lbs./gal)

Max VOC (AP): 791.3 g/L (6.6 lbs./gal)

Avg. Gal. Wt: 7.71 lbs./gal

Avg. Wt.% Volatiles: 85.682%

Avg. Wt.% Exempt Solvent: 0%

Avg. Wt.% Water: 0.076%

Avg. Vol.% Exempt solvent: 0.0%

Avg. Vol.% Water: 0.071%

Flash Point: See SDS

Theoretical Coverage: 184.66 Sq Ft/Gal at 1 Mil

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.

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## 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 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.

**Revised: December 2021**

In the United States:  
**1.855.6.AXALTA**  
**nasonXL.us**

In Canada:  
**1.800.668.6945**

