



Nason®XL 438-22 Panel Clearcoat




COMPONENTS
438-22 Panel Clearcoat
445-10, 445-11, 445-12, 445-13
Activator



APPLICATION
2-3 single coats
Allow 10 minutes flash off
between coats




MIX RATIO
3 : 1



DRY TIME
Air dry:
Hand slick: 20 minutes @77°F
Bake: 30-40 Minutes @140°F



VISCOSITY
Zahn #2
17-19 seconds



VOC
511 grams / liter
4.3 lbs / gallon



GENERAL

DESCRIPTION

This two-component high build medium solids clear coat is formulated for the NasonXL Basecoat system. It is quick dry with excellent gloss and flow characteristics. NasonXL 438-22 Panel Clearcoat is designed to provide a proper film build after application of two coats.

COMPATIBLE COATINGS

Compatible with NasonXL basecoat.

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



MIXING

COMPONENTS

Mix 3 parts NasonXL 438-22 Panel Clearcoat to 1 part NasonXL Activator. Mixed VOC 4.2 lbs/gal.

| Component | Volume |
|---|--------|
| NasonXL 438-22 Panel Clearcoat | 3 |
| NasonXL National Rule Activator (445-10 Super Fast, 445-11 Fast, 445-12 Standard, 445-13 Slow) | 1 |

Package Sizes

- 1 gallon (3.785 liters)
- 1 quart (0.95 liters)

INITIAL APPLICATION VISCOSITY

Zahn #2 Viscosity 17-19 seconds

POT LIFE

When mixed, 3 hours @ 77°F (25°C).



APPLICATION

APPLICATION EQUIPMENT

| | | | |
|-----------------|--------------|-----------|--------------|
| HVLP Gravity | 1.3 -1.4 mm | 8-10 PSI | at the cap |
| High Efficiency | 1.3 - 1.4 mm | 27-32 PSI | at the gauge |

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

SURFACE PREPARATION

Apply basecoat as needed and allow to flash 20 to 30 minutes @ 77°F (25°C).

APPLICATION

Apply 2 to 3 single coats allowing 10 minute flash off between coats or hand slick.

Notes:

- Cooler temperatures and thicker films may require longer flash times. Do not expose to rain or excessive moisture for 24 hours after spraying.
- Applying graphics best after 7 days or a full cure to avoid decal blistering.
- When baking, no flash time needed. Go straight to bake.

RECOAT

Can be recoated after 24 hours. Best after full cure: 7 days @ 77°F (25°C).



DRY TIMES

**AIR DRY
77°F (25°C)**

| | |
|---------------------|--|
| Hand Slick | 20 Minutes |
| Hard Dry | 24 Hours |
| To Light Polish | 6 Hours |
| To Heavy Compound | 10 Hours |
| Force Dry Time | 30-40 Minutes @140°F (60°C) |
| Infrared Short Wave | 3-5 Minutes half power followed by 10-15 Minutes full power @ 36" |



PHYSICAL PROPERTIES

| | |
|---------------------------------|---|
| Theoretical Coverage at 1 mil | 526 ft ² /RTS Gal (12.9 m ² /RTS L) |
| Recommended Dry Film Thickness: | 2.0 to 2.5 mil in 2 coat |
| Flash Point: | See SDS |

STORAGE CONDITIONS

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

VOC REGULATED AREAS

All Values Ready To Spray

| | Standard Reduction (3:1) |
|---------------|-------------------------------------|
| Max. VOC (LE) | 511 g/L (4.3 lbs./gal) |

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 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
NasonXL.us

