



Nason®XL 438-31 2.1 VOC Overall Clearcoat




COMPONENTS 438-31 Overall Clearcoat
435-14,435-15
Low VOC Activators



APPLICATION 2 single wet coats
10 minute flash between coats




MIX RATIO 2 : 1



DRY TIME Air dry
Dust-Free: 30 minutes @ 77°F
Bake: 30 Minutes @ 140°F



VISCOSITY Zahn #2
17-19 seconds



VOC 245 grams / liter
2.0 lbs / gallon



GENERAL

DESCRIPTION

NasonXL 438-31 2.1 VOC Overall Clearcoat is a two-component high build, medium solids clearcoat formulated for the NasonXL Low VOV basecoat system. It offers excellent gloss and flow characteristics and is designed to deliver 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 2 parts NasonXL 438-31 2.1 VOC Overall Clearcoat to 1 part NasonXL Low VOC Activator.

Component	Volume
NasonXL 438-31 2.1 VOC Overall Clearcoat	2
NasonXL Low VOC Activator (435-14 Standard, 435-15 Slow)	1

Package Sizes

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

INITIAL APPLICATION VISCOSITY

Zahn #2 Viscosity 17-19 seconds



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.2 -1.4 mm	8-10 PSI	at the cap
High Efficiency	1.2 -1.4 mm	28-35 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 15 to 20 minutes @ 77°F (25°C). When applying over a water basecoat, should flash an additional 20 minutes @ 77°F (25°C) after dry process.

APPLICATION

Apply 2 single wet coats with 10 minute flash off between coats.

Notes:

- Do not expose to rain or excessive moisture for 24 hours.
- Cooler temperatures and thicker films may require longer flash times.
- Applying graphics best after 7 days or a full cure.
- 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)

Dust Free	30 Minutes
Hard Dry	24 Hours
To Light Polish	6-8 Hours
To Heavy Compound	12 Hours
Force Dry Time	30 Minutes @ 140°F (60°C)
Infrared Short Wave	15-20 Minutes full power @36"



PHYSICAL PROPERTIES

Theoretical Coverage at 1 mil	665 ft ² /RTS Gal (16.3 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 (2:1)
Max. VOC (LE)	245 g/L (2.0 lbs./gal)
Max. VOC (AP)	143 g/L (1.2 lbs./gal)
Avg. Gal. Wt.:	1108 g/l (9.25 lbs/gal)
Avg. Wt.% Volatiles:	58.3%
Avg. Wt.% Exempt Solvent:	45.4%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	41.7%
Avg. Vol.% Water:	0.0%

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

