

# Nasco™ Alkyd Enamel



## GENERAL

### DESCRIPTION

A modified alkyd enamel that provides good durability and gloss. It is designed for overall finishing of automobiles, trucks, and other commercial vehicles.

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



## MIXING

### COMPONENTS

Nasco™ Alkyd Enamel Topcoat  
 Kwik-Kure™ 483-08™ Enamel Activator  
 Ful-Base® 441-20™ Reducer (Low-Temp)  
 Ful-Base® 441-21™ Reducer (Mid-Temp)  
 Ful-Base® 441-22™ Reducer (High-Temp)  
 Or Nason® Enamel Reducers

### MIX RATIO

Combine the components by volume (8:1:2). Mix thoroughly prior to activation.

Component	Volume
Nasco™ Alkyd Enamel Topcoat	8
Kwik-Kure™ 483-08™ Enamel Activator	1
Ful-Base® 441-20™ / 441-21™ / 441-22™ Reducer	2

Note: Nasco™ may be used without catalyst.

### VISCOSITY

20-21" #2 Zahn Cup

### POT LIFE

4 hours 70°F (21°C) at 50% Relative Humidity

### ADDITIVES

Fisheyes: Use Smoothie Additive as needed



## 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.

### COMPATIBILITY

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

### 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
Pressure:	0.8-1.1 mm

### APPLICATION

Solid Colors: Spray medium wet coat, allow to tack, then follow with a 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.

Integrated Clear: For added gloss and durability, use Astro Clear 419-00™ Integrated Clear.

### 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

VOC LE:	5.0 lb/gal (600 g/l) maximum, RTS
Recommended Dry Film Thickness:	2.0 mil
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.

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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/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**

