



NEW

NASON® FastDry® 1K Acrylic Single Stage (NIE Quality)




COMPONENTS
435-04 FastDry Binder
VS5160, VS5170, VS5180,
VS5190 Reducers



APPLICATION
2 - 3 coats
5 - 10 minute flash
between coats




MIX RATIO
4 : 1



DRY TIME
Air Dry 45 - 60 minutes



VISCOSITY
Zahn #2
18 - 21 seconds



VOC
588 grams / liter
4.9 lbs / gallon



GENERAL

DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, acrylic single-stage topcoat designed for easy refinishing of machinery and equipment.

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



MIXING

COMPONENTS

- Nason FastDry 1K Acrylic Single Stage "NIE" Quality Color
- Axalta VS5000 Series Toners
- Nason 435-04 FastDry Acrylic Binder
- Axalta VS5160 Low Temp Reducer (65°F-75°F)
- Axalta VS5170 Mid-Temp Reducer (75°F-85°F)
- Axalta VS5180 High Temp Reducer (85°F-100°F)
- Axalta VS5190 X-High Temp Reducer (Above 100°F)

MIX RATIO

Combine the components by volume (4:1). Mix thoroughly prior to activation.

Component	Volume
FastDry Acrylic Single Stage Color (NIE Quality)	4
Axalta VS5160 / VS5170 / VS5180 / VS5190 Reducer	1

MATTE GLOSS

FastDry 1K Alkyd Single Stage (NIE Quality) may be mixed with VS6200 Matte Base Additive to achieve various levels of desired gloss. For accurate mixing, refer to the matte mix formula in ColorNet® or Color Choice®.

ADDITIVE

Flow Additive

Nason 441-83 Flow Additive may be used to improve flow, leveling, and overspray absorption in hot weather conditions when spraying large repairs. 1 - 2 oz (30 - 60 ml or 30 – 61 grams) is recommended per RTS quart.

FACTORY PACKAGE COLORS

414-2005 Black
414-2006 Frost White

POT LIFE

4 hours at 70°F (21°C)



APPLICATION

SUBSTRATES

All OEM finishes, as well as properly prepared metal, fiberglass, plastic and fully cured previously painted surfaces.

SURFACE PREPARATION

Before sanding, wash with soap and water and remove wax and grease with Axalta VS1000™ Surface Cleaning Solvent or VS1100™ Surface Cleaning Solvent – Low VOC (use locally permitted cleaner in regulated areas) using clean rags. Sand finishes according to primer or substrate recommendations.

COMPATIBLE PRODUCTS

All Nason and NasonXL primers, primer-surfacers and sealers as locally permitted.

SPRAY VISCOSITY

18 - 21 seconds Zahn #2

SPRAY PRESSURE

Approved Transfer Efficiency:	As per gun manufacturer instructions
Pressure Feed:	10 - 12 ounces fluid flow per minute
HVLP:	8 - 10 PSI at the air cap

GUN SETUP

Approved Transfer Efficiency:	1.3 - 1.5 mm
Pressure Feed:	0.8 - 1.2 mm

HVLP

Gravity Feed:	1.3 - 1.5 mm
Pressure Feed:	0.8 - 1.1 mm

APPLICATION

Solid Colors:

Spray medium wet coat. Allow to tack. Follow with a full wet coat. Do not apply FastDry 1K Acrylic below 50°F (10°C).

Metallic Colors:

Apply 2 medium wet coats. Flash 5 -10 minutes between coats. A third and final orientation coat may be applied if necessary to even the metallic.

Matte Gloss:

Apply two medium coats being careful of over lapping during application, with minimum flash time between coats. Topcoat can remain soft even after a bake cycle. Best to allow system to dry overnight for assembly and delivery.

CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible using either Axalta 105 or 107 Low VOC / Low HAPS equipment cleaners.



DRY TIMES

AIR DRY

Out of dust:	30 minutes
Light assembly:	45 - 60 minutes
Full assembly/polishing:	16 hours

Matte gloss:	Overnight
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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

All Values Ready To Spray

Max. VOC (LE):	4.9 lbs/gal (588 g/L)
Max. VOC (AP):	4.6 lbs/gal (552 g/L)
Avg. Gal. Wt.:	8.4 lbs./gal (1008 g/L)
Avg. Wt.% Volatiles:	58.8%
Avg. Wt.% Exempt Solvent:	5.7%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	7.2%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	488 ft² (45.6 m²) at 1 mil
Recommended Dry Film Thickness:	2.0 mil
Flash Point:	See SDS

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.

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.

Revised: January 2023