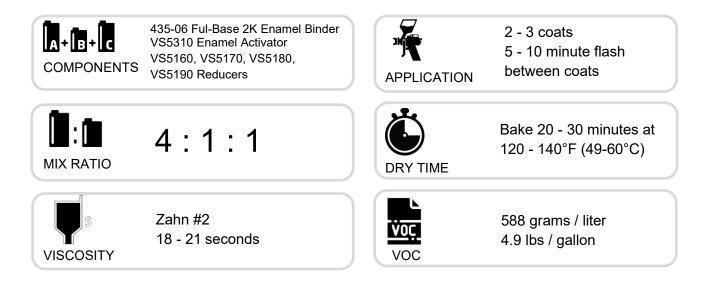


NEW Nason[®] Ful-Base[®] 2K Enamel Single Stage (NIC Quality)





GENERAL

DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, solvent-borne single-stage topcoat that is easy to apply and provides a wide range of colors.

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



MIXING

COMPONENTS

Nason Ful-Base 2K Enamel Single Stage "NIC" Quality Color Axalta VS5000 Series Toners Nason 435-06 Ful-Base Enamel Binder Axalta VS5310 Enamel Activator 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 (4:1:1). Mix thoroughly prior to activation.

Component	Volume
Nason Ful-Base Enamel Single Stage Color (NIC Quality)	4
Axalta VS5310 Enamel Activator	1
Axalta VS5160 / VS5170 / VS5180 / VS5190 Reducer	1



MATTE GLOSS

Ful-Base 2K Enamel Single Stage (NIC 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

419-105 Black 419-106 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: Pressure Feed: HVLP: As per gun manufacturer instructions 10 - 12 ounces fluid flow per minute 8 - 10 PSI at the air cap

GUN SETUP

Approved Transfer Efficiency: Pressure Feed:	1.3 - 1.5 mm 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 Ful-Base 2K Enamel 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: Light assembly: Full assembly/polishing:

30 minutes 45 - 60 minutes 16 hours

Matte gloss:

Overnight

FORCE DRY 20 - 30 minutes at 120-140°F (49-60°C)

INFRARED DRYING

Refer to the Infrared Guide for setup recommendations.

All dry times are at normal temperatures, lower temperatures will require longer dry times.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE): Max. VOC (AP): Avg. Gal. Wt.: Avg. Wt.% Volatiles: Avg. Wt.% Exempt Solvent: Avg. Wt.% Water: Avg. Vol.% Exempt Solvent: Avg. Vol.% Water: Theoretical Coverage: Recommended Dry Film Thickness: Flash Point: 4.9 lbs/gal (588 g/L) 4.5 lbs/gal (540 g/L) 8.3 lbs./gal (996 g/L) 60.5% 6.9% 0.0% 8.6% 0.0% 463 ft² (43.2 m²) at 1 mil 2.0 mil 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.

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AXALTA

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