

**NEW**

# Nason® Ful-Base® 2K Enamel Single Stage (NIC Quality)

<p><b>COMPONENTS</b> 435-06 Ful-Base 2K Enamel Binder VS5310 Enamel Activator VS5160, VS5170, VS5180, VS5190 Reducers</p>	<p><b>APPLICATION</b> 2 - 3 coats 5 - 10 minute flash between coats</p>
<p><b>MIX RATIO</b> 4 : 1 : 1</p>	<p><b>DRY TIME</b> Bake 20 - 30 minutes at 120 - 140°F (49-60°C)</p>
<p><b>VISCOSITY</b> Zahn #2 18 - 21 seconds</p>	<p><b>VOC</b> 588 grams / liter 4.9 lbs / gallon</p>



## 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)




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**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 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:	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)

**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):	4.9 lbs/gal (588 g/L)
Max. VOC (AP):	4.5 lbs/gal (540 g/L)
Avg. Gal. Wt.:	8.3 lbs./gal (996 g/L)
Avg. Wt.% Volatiles:	60.5%
Avg. Wt.% Exempt Solvent:	6.9%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	8.6%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	463 ft <sup>2</sup> (43.2 m <sup>2</sup> ) at 1 mil
Recommended Dry Film Thickness:	2.0 mil
Flash Point:	See SDS

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## 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.

**Revised: January 2023**