



NEW

Nason® Ful-Cryl® 2K Acrylic Single Stage (NID Quality)




COMPONENTS
435-03 Ful-Cryl Binder
VS5320 Acrylic Activator
VS5160, VS5170, VS5180,
VS5190 Reducers



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




MIX RATIO
4 : 1 : 1



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



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 enamel single-stage topcoat that provides very good gloss, chip resistance and durability for excellent performance characteristics.

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



MIXING

COMPONENTS

Nason Ful-Cryl 2K Acrylic Single Stage "NID" Quality Color
Axalta VS5000 Series Toners
Nason 435-03 Ful-Cryl Acrylic Binder
Axalta VS5320 Acrylic 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
Ful-Cryl 2K Urethane Single Stage Color (NID Quality)	4
Axalta VS5320 Acrylic Activator	1
Axalta VS5160 / VS5170 / VS5180 / VS5190 Reducer	1

MATTE GLOSS

FulCryl 2K Acrylic Single Stage (NID 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®.

ADDITIVES

Fisheye Eliminator

Add 1 oz (30 ml or 30 grams) Axalta VS6500 Fisheye Eliminator per RTS gallon as required.

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

418-05 Black
418-06 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 Ful-Cryl 2K 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.

Integrated Clear:

To enhance depth of color and provide a custom look, refer to the 2K Urethane Integrated Clear, VS4500, technical data sheet.

Do not use 2K Urethane Integrated Clear, VS4500, as a topcoat clear.

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.



POLISHING

Allow 16 hours to dry. Remove dust with soft, dampened cloth. Use fine compound with soft polishing pad. Operate machine at 1700-2000 RPM.

- Solid Colors: Lightly sand with 1500 grit or finer.
- Metallic Colors: Lightly “nib” sand small imperfections only.

Note: Best for solid colors. Metallic colors will be damaged if polished excessively.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	4.9 lbs/gal (588 g/L)
Max. VOC (AP):	4.7 lbs/gal (564 g/L)
Avg. Gal. Wt.:	8.5 lbs./gal (1020 g/L)
Avg. Wt.% Volatiles:	58.0%
Avg. Wt.% Exempt Solvent:	3.5%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	4.4%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	500 ft ² (46.7 m ²) 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