



Nason[®]XL National Rule Basecoat




COMPONENTS
NasonXL Basecoat Color
447-65, 447-75, 447-85
Reducers



APPLICATION
2 - 3 coats
4 - 8 minute flash
between coats




MIX RATIO
2 : 1



DRY TIME
15 - 20 Minutes



VISCOSITY
Ford #4
16 seconds



VOC
779 grams / liter
6.5 lbs / gallon



GENERAL



DESCRIPTION

A 6.5 lbs/gal | 779 grams/liter VOC basecoat system designed for use on cars, commercial vehicles and equipment; as well as for repairs to existing OEM two and three stage systems and design work. The basecoat has been formulated with a high-quality range of light fast pigments to meet the OEM color standards. Good coverage and ease of application provide the refinisher with a quality product.

NOT RECOMMENDED FOR

Use over 1K substrates

COMPATIBLE COATINGS

Compatible with NasonXL primer, sealer, and clearcoat products

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



MIXING

COMPONENTS

Mix 2 parts NasonXL Basecoat Color to 1 part NasonXL Reducer. Thin to spray viscosity of 16 secs with #4 Ford @ 77°F/25°C for spraying.

Option for longer re-coating: Add 5% hardener to premixed basecoat

Component

| Component | Volume |
|---|--------|
| NasonXL Basecoat Color | 2 |
| NasonXL Reducers (447-65 Fast, 447-75 Medium, 447-85 Slow) | 1 |

Package Sizes

- 1 Gallon (3.75 Liters)
- 1.057 Quart (1 Liter)
- 1.057 Pint (0.5 Liter)

INITIAL APPLICATION VISCOSITY

Ford #4 Viscosity 16 seconds



APPLICATION

APPLICATION EQUIPMENT

| | | | | |
|-----------------|--------------|-----------------|-----------|-------------|
| HVLP Gravity | 1.3 -1.4 mm | 1.0 - 1.5 (Bar) | 6-8 PSI | *At the cap |
| High Efficiency | 1.3 - 1.4 mm | 1.0 - 1.5 (Bar) | 17-19 PSI | At gauge |

Note: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

APPLICATION

Apply 2 to 3 single coats with 4 - 8 minute flash time between coats. An additional coat may be required with colors difficult to cover. Not recommended over 1K substrates.

Option for metallics and blending basecoat: After the final coat of color, adjust the air pressure and apply a final medium-wet drop coat. (**Do not** dry spray color.) Flash off for 15 - 20 minutes before applying clear.

NOTE: Underhood and jambs.

METHOD 1: As an underhood color, the basecoat can be sprayed by adding 5% activator to the mix without the need of clear coating. This matches many of the OEM hood colors.

METHOD 2: Integrate 20 - 50% activated clear NasonXL 438-20 Clearcoat or NasonXL 438-40 Clearcoat into your already properly thinned basecoat. This provides more durability than Method 1M and is ideal when spraying jambs.

****IMPORTANT TECHNICAL NOTES:** To prevent white peeling when un-tapping, the best practice recommendation is when two-toning with white; slightly over-reduce, using a slower solvent AND 5% NasonXL 445-11 Fast Activator. Allow a 10-minute flash between coats, then a 20-minute minimum wait to unmask two-toned color and clear. When pulling the tape away **AFTER** the 20-minute minimum wait, pull the tape at a 45° angle using extreme care. Always spray white over P400-P500 grit sandpaper scratch. Do **not** apply NasonXL White basecoat over adhesion promoter, as peeling does occur when using either on all panels that have been tested.

BLENDING

Apply a single coat of NasonXL Blending Additive 442-56 over the entire repair area. Allow the coat of blending additive to flash 4 – 8 minutes before applying the first coat of color. Apply the first color coat beyond the repaired area. Apply the second coat just beyond the first color coat. Each subsequent color coat should be applied just beyond the previous coat. Stay within the area in which the NasonXL Blending Additive 442-56 was applied. Flash 15 – 20 minutes, then apply clearcoat over the entire panel.

Add 5% NasonXL Effect Additive 442-00 when blending difficult colors to the translucent blending step, NasonXL Blending Additive 442-56.

RECOAT

Must be recoated with clear after 15 minutes and before 12 hours or 24 hours when activator is added to the basecoat. Allow basecoat to properly flash before applying clearcoat. Cooler temperatures may require longer flash times.



DRY TIMES

AIR DRY

75°F (23°C) & 50% RH at recommended film thickness

| | |
|------------------------|-------------------------|
| Hand Slick | 5 Minutes |
| Dust Free | 5 Minutes |
| Tape Free | 20 Minutes |
| To Clearcoat | 15 - 20 Minutes |
| Dry to Handle | Overnight (after clear) |
| Flash Before Force Dry | N/A |
| To Sand/Buff | N/A |



PHYSICAL PROPERTIES

| | |
|----------------------------|--|
| Recommended Film Thickness | ± 10 Micron / .mils |
| Mixed Volume Solids | 11-13% (Average) |
| Theoretical Coverage | 200.432 Sq. Ft. @ 1 Mil DFT/mixed gallon |
| Recommended Coats | 2-3 (x1) |
| DFT per Coat | Approximately 0.5 mil |

MAXIMUM SERVICE TEMPERATURE

200°F (93°C)

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C)

VOC REGULATED AREAS

VOC as Applied 779 grams/liter | 6.5 lbs/gallon (RFU)

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 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
nasonXL.us

In Canada:
1.800.668.6945

