



Nason[®]XL Low VOC Basecoat




COMPONENTS
NasonXL Low VOC BC Color
437-65, 437-75, 437-85, or
437-95 Reducer




APPLICATION
2 - 3 coats
5 - 8 minute flash
between coats



MIX RATIO
1 : 1



DRY TIME
30 Minutes



VOC
420 grams / liter
3.5 lbs / gallon



GENERAL

DESCRIPTION

A 3.5 lbs/gal | 420 grams/liter VOC basecoat system designed for use on automotive vehicles for overall paint projects and repairs to existing OEM two- and three-stage systems. 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 Low VOC primer, sealer, and clearcoat products.

- 431-10 2.1 DTM Primer
- 431-30 2.1 VOC Primer Surfacer
- 431-70 2.1 VOC Urethane Sealer

- 438-30 2.1 VOC Overall Clearcoat
- 438-10 2.1 VOC Spot & Panel Clearcoat

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



MIXING

COMPONENTS

Mix 1 part NasonXL Low VOC Basecoat Color to 1 part of the appropriate NasonXL Low VOC Reducer

Component	Volume
NasonXL Low VOC Basecoat Color	1
NasonXL Low VOC Reducer (437-65, 437-75, 437-85, or 437-95)	1

Package Sizes

- 1 Gallon (3.785 Liters)
- 1 Quart (0.946 Liter)
- 1 Pint (0.473 Liters)

SURFACE PREPARATION

Prepare all surfaces to be repainted using the recommended undercoat systems, following proper recommended procedures.

SANDING

	Sanding without sealer	Sanding with Sealer
Dry Mechanical	P600	P500 or finer
Dry Hand	P600	P500 or finer
Wet	P600 or finer	P500 or finer



APPLICATION



APPLICATION EQUIPMENT

HVLP Gravity	1.3 -1.4 mm	20-24 PSI	At gauge
High Efficiency	1.3 - 1.4 mm	20-24 PSI	At gauge

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

APPLICATION

Apply 2 to 3 single coats with 5 - 8 minute flash off 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.



DRY TIMES

AIR DRY

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

Dust Free	10 Minutes
Tape Free	30 Minutes
To Clearcoat	30 minutes



PHYSICAL PROPERTIES

Recommended Film Thickness	10-25 Micron / 0.4 – 1.0 mils
Mixed Volume Solids	13% (Average)
Theoretical Coverage	Approx. 208 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 420 grams/liter | 3.5 lbs/gallon (RFU)

GH Ready to Spray	
Max VOC (AP) grams / liter (pounds / gallon)	417 (3.5)
Max VOC (LE) grams / liter (pounds / gallon)	101 (0.84)
Average Gallon Weight grams / liter (pounds / gallon)	1170 (9.76)
Weight % Volatiles	84.8%
Weight % Water	0.5%
Weight % Exempt Solvents	77.7%
Volume % Water	0.5%
Volume % Exempt Solvents	77.5%

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

