Nason®XL 438-11 2.1 VOC Panel Clearcoat

COMPONENTS	438-11 Panel Clearcoat 435-14, 435-15 Low VOC Activators
APPLICATION	2 single wet coats 10 minute flash off between coats
MIX RATIO	3 : 1
DRY TIME	Air dry: Dust-free: 30 minutes @ 77°F Bake: 30 Minutes @140°F
VISCOSITY	Zahn #2 14-15 seconds
VOC	214 grams / liter 1.8 lbs / gallon

GENERAL

DESCRIPTION

NasonXL 438-11 2.1 VOC Panel Clearcoat is a two-component high build, medium solids clearcoat formulated for the NasonXL basecoat system. This clearcoat is designed to deliver a proper film build after application of two coats.

COMPATIBLE COATINGS

Compatible with NasonXL basecoat.

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

MIXING

COMPONENTS

Mix 3 parts NasonXL 438-11 2.1 VOC Panel Clearcoat to 1 part NasonXL Low VOC Activator.

Component	Volume
NasonXL 438-11 2.1 VOC Panel Clearcoat	3
NasonXL Low VOC Activator (435-14 Medium, 435-15 Slow)	1

Package Sizes

- 1 gallon (3.75 liters)
- 1 quart (0.94 liters)

INITIAL APPLICATION VISCOSITY

Zahn #2 Viscosity 14-15 seconds

POT LIFE
3 hours @ 77°F (25°C)

APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 -1.4 mm	8-10 PSI	at the cap
High Efficiency	1.3 -1.4 mm	27-32 PSI	at the gauge

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

SURFACE PREPARATION
Apply basecoat as needed and allow to flash 20 to 30 minutes @ 77°F (25°C).

APPLICATION
Apply 2 single wet coats with 10 minute flash off between coats.

Notes:
- Do not expose to rain or excessive moisture for 24 hours.
- Cooler temperatures and thicker films may require longer flash times.
- Applying graphics best after 7 days or a full cure.
- When baking, no flash time needed. Go straight to bake.

RECOAT
Can be recoated after 24 hours. Best after full cure: 7 days @ 77°F (25°C).

DRY TIMES

AIR DRY
77°F (25°C)

Dust Free	30 Minutes
Hard Dry	24 Hours
To Light Polish	4-6 Hours
To Heavy Compound	10 Hours
Force Dry Time	30 minutes @140°F (60°C)
Infrared Short Wave	15-20 Minutes full power @ 36''

PHYSICAL PROPERTIES

Theoretical Coverage:at 1 mil	596 ft^2 /RTS Gal (14.6 m^2 /RTS L)
Recommended Dry Film Thickness:	0.8 to 1.2 mil in 1 coat
Flash Point:	See SDS

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

All Values Ready To Spray

	Standard Reduction (3:1)
Max. VOC (LE)	214 g/L (1.8 lbs./gal)
Max. VOC (AP)	106 g/L (0.9 lbs./gal)
Avg. Gal. Wt.:	1111 g/L (9.27 lbs./gal)
Avg. Wt.% Volatiles:	62.6%
Avg. Wt.% Exempt Solvent:	53.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	50.5%
Avg. Vol.% Water:	0.0%

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:
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