

NASCO™/ASTRON® ALKYD ENAMEL

Nasco™/Astron® Alkyd Enamel is a modified polyester polymer enamel with superior durability and gloss. It is specifically made for overall finishing of automobiles, trucks and other commercial vehicles. The scientific blending of polymers makes Nasco™ and Astron® the easiest enamel to spray, which minimizes orange peel and sagging.

SYSTEMS COMPONENTS:

ColorNet® code "IA"

Nason® Nasco™ 419-XX™ Packaged Colors

Astron® 412-XX™ System Toners

Nason® Kwik-Kure™ 483-08™

Nason® Gloss-E™ 483-13™

Nason® Gloss-E™ 483-14™ Fast

Nason® 441-XX™ Enamel Reducers

MIXING & REDUCING:

8-1-2 or 4-1

Mix: 8-1-2

8 Parts Nasco™/Astron®

1 Part Kwik-Kure™ 483-08™

2 Parts (25-30%) Enamel Reducer,

Nason® 441-02™ Zephyr Fast (40-60°F)

Nason® 441-00™ Multi-Weather Med (60-85°F)

Nason® 441-01™ Hi-Temp Slow (75-100°F)

Example:

To 1 gallon Nasco™/Astron® add

1 pint Kwik-Kure™ 483-08™

Reduce 25-30% with 441-XX™ Reducer.

OR

Mix: 4-1

4 parts Nasco™/Astron®

1 part Gloss-E™ 483-13™ or

Gloss-E™ 483-14 Fast

Example: To 1 gallon Nasco™/Astron® add

1 quart 483-13™ or 483-14™ Catalyst.

Note: Nasco™/Astron® may be used without

catalyst. Reduce 20-30% with 441-00™ Reducer.

POT LIFE:

4 Hours at 70°F.

SURFACE PREPARATION:

Before sanding, remove all traces of oil, wax and grease with Nason® 441-05™ Silicone and Wax Remover (use locally permitted cleaner in regulated areas) using clean rags. Sand old finish and chemically treat bare metal areas.

PRIMER:

Ful-Poxy® 491-16™ Epoxy Primer

Nason® 491-17™ Etch-Primer

Nason® 491-30™ Chrome-Free Etch Primer

PRIMER-SURFACER

Nason® 421-05™ Universal

Ful-Fil® 421-08™, 421-09™ Acrylic

Ful-Thane® Sentry™ 421-15™ Catalyzed

Nason® SelectPrime™ 421-17™ 2K Urethane

Nason® SelectPrime™ 421-20™

Nason® 470-04™ Water Borne Primer-Surfacer

SEALER: (Required)

Nason® Bond-Seal™ 422-XX™ (Must use

Enamel Reducer. Must be topcoated within 8 hrs.)

Ful-Seal® Select™ 422-23™

See Product Data Sheets for use of these products.

AIR PRESSURE:

60-80 PSI

HVLP: 8-10 PSI

APPLICATION:

Spray material reduced as recommended.

Solid Colors: Spray medium wet coat, allow to tack, follow with full wet coat.

Metallic Colors: Spray a full wet coat, allow to tack, follow with a medium coat. A third coat may be applied to even the metallic. You may use cross coat application or slightly over-reduced last coat.

Integrated Clear: For added gloss and durability use Nason® Astro-Clear™ 419-00™ as an integrated clear. Mix 1 quart of catalyzed and reduced clear with 1 quart catalyzed and reduced color and apply as a last coat.

Clear Coat: Astro-Clear™ 419-00™ Only.

Allow color to flash 20-30 minutes before applying clear. Metallics may require longer flash time to avoid metallic movement.

FISHEYES:

Use Smoothie.

SPRAY VISCOSITY:

14"-16" #4 Ford Cup

DRYING TIME:

30 minutes out of dust; 45 to 60 minutes tack free. Hard Overnight.

Force dry: Allow 10-15 minute flash before placing in oven.

Force dry: 20-30 minutes at 120-140°F.

CLEANING OF PAINT EQUIPMENT:

Use Nason® 481-06™ Lacquer Thinner OR Nason® SelectThinner™ 481-16™. Refer to appropriate Air Quality District requirements for proper use of equipment and solvent.

RECOMMENDED FILM THICKNESS:

1.8-2.2 Mil. Dry Film

FLASH POINT: CLOSED CUP

Below 80°F

IMPORTANT NOTES:

Nasco™/Astron® may be applied with or without hardener. The addition of catalyst will produce a harder, more durable and chemically resistant film. It will also minimize any recoat problems.

Astron® toners do not contain drier. If extra toner is added, drier should be added in amounts equal to 10% of the extra toner by volume.