

# FastDry™ 1K Acrylic Enamel (IE Quality)



## GENERAL

### DESCRIPTION

A 600 g/L, VOC compliant, acrylic enamel single-stage topcoat designed for easy refinishing of machinery and equipment.

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



## MIXING

### COMPONENTS

Ful-Base® 430-XX System Tints  
 FastDry™ 435-96™ 1K Acrylic Enamel Binder  
 Ful-Base® 441-20™ Reducer Fast  
 Ful-Base® 441-21™ Reducer Medium  
 Ful-Base® 441-22™ Reducer Slow  
 Ful-Base® 441-29™ Reducer Super Flow

### MIX RATIO

Combine the components by volume (8:2). Mix thoroughly.

Component	Volume
FastDry™ 1K Acrylic Enamel (IE Quality)	8
Ful-Base® 441-xx Reducer	2

### POT LIFE

Not applicable for non-catalyzed material.

### SPRAY VISCOSITY

14-16 seconds in a FORD #4 Cup @20°C



## APPLICATION

### SURFACE PREPARATION

- Before sanding, wash with soap and water and remove wax and grease with an Axalta Coating Systems approved silicone and wax remover using clean rags.
- Sand finishes according to primer or substrate recommendations and chemically treat large bare metal areas.

### COMPATIBLE PRODUCTS

Compatible with all Nason® primers, primer-surfacers and sealers.

### SPRAY PRESSURE

#### Conventional

Siphon Feed:	2.8-4.8 bar at the gun
Gravity Feed	2.8-4.8 bar at the gun
Pressure Feed:	0.55-0.7 barl at the air cap (fluid flow 240-350 mL/minute)

### GUN SETUP

#### Conventional

Siphon Feed:	1.6-1.8 mm
Gravity Feed:	1.4-1.6 mm
Pressure Feed:	0.8-1.2 mm

#### HVLP

Siphon Feed:	1.5-1.8 mm
Gravity Feed:	1.3-1.6 mm

### APPLICATION

Solid Colors: Apply 1 medium wet coat. Allow to tack. Apply 1 full wet coat.

Metallic Colors: Apply 2 medium wet coats. Flash 5-10 minutes between coats. A third and final "mist" coat may be applied if necessary to even the metallic.

### CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with Duxone® Gun Wash Solvent.



### DRY TIMES

#### AIR DRY

Dust free:	30 minutes
Tack Free:	45-60 minutes
Hard:	Overnight

#### FORCE DRY

30 minutes at 60°C

All dry times are at normal temperatures, lower temperatures will require longer dry times.



### PHYSICAL PROPERTIES

#### All Values Ready To Spray

Max. VOC (LE):	600 g/L
Max. VOC (AP):	588 g/L
Avg. SG:	0.96 g/mL
Avg. Wt.% Volatiles:	63.2%
Avg. Wt.% Exempt Solvent:	1.6%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	1.9%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	5.5 m <sup>2</sup> /L at 50 µm
Recommended Dry Film Thickness:	50 µm
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.

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## 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.