



# Nason<sup>®</sup>XL 438-40 2K Overall Clearcoat




**COMPONENTS** 438-40 2K Overall Clearcoat  
445-10, 445-11, 445-12 or  
445-13 Activator



**APPLICATION** 2 - 3 coats  
5-10 minute flash to hand  
slick between coats




**MIX RATIO** 2 : 1



**DRY TIME** Air dry:  
Hand slick – 30 minutes @ 77°F  
  
Bake: 30 Minutes @ 140°F



**VISCOSITY** Zahn #2  
17-18 seconds



**VOC** 503 grams / liter  
4.2 lbs / gallon



## GENERAL



### DESCRIPTION

This two-component high build VOC-compliant clearcoat is designed to provide excellent gloss and flow characteristics. Nason<sup>®</sup>XL 438-40 2K Overall Clearcoat ensures a proper film build after application of only two full coats. Specifically designed for complete resprays and panel repairs over NasonXL Basecoat.

### 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 438-40 Clearcoat to 1 part NasonXL Activator.

Component	Volume
NasonXL 438-40 Clearcoat	2
NasonXL Activator (445-10 Super Fast, 445-11 Fast, 445-12 Medium, 445-13 Slow)	1

### Package Sizes

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

### INITIAL APPLICATION VISCOSITY

Zahn #2 - 17-18 seconds

**POT LIFE**

When mixed, 3 hours @ 77°F/25°C

**ADDITIVE**

438-40 Overall Clearcoat may be used with Axalta VS6200 Matte Base Additive to achieve matte, eggshell, and sheen gloss levels. See VS6200 Matte Base Additive TDS for complete mixing instructions.



**APPLICATION**



**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 -1.4 mm	2.0 - 2.5 (Bar)	8-10 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	2.0 - 2.5 (Bar)	27-32 PSI	At gauge

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

**SURFACE PREPARATION**

Apply basecoat as needed and allow to flash 15 to 20 minutes @ 77°F/25°C.

**APPLICATION**

Apply 2 to 3 single coats allowing flash to hand slick (5-10 min.) between coats.

Notes:

- Cooler temperatures and thicker films may require longer flash times.
- Do not expose to rain or excessive moisture for 24 hours.
- Applying decals best after 7 days or full cure to avoid decal blistering. Applying more than 3 coats is not recommended.
- 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)**

Hand Slick	30 Minutes
Dust Free	45 Minutes
Hard Dry	24 Hours
To Light Polish	8 Hours
To Heavy Compound	24 Hours
Force Dry Time	30 Minutes @ 140°F (60°C)



**PHYSICAL PROPERTIES**

Recommended Film Thickness	25-30 micron / 1.0-1.5 mils per coat, dry film
Mixed Volume Solids	41.8% (Average)
Theoretical Coverage	N/A
Recommended Coats	2 (x1)
DFT per Coat	Approximately 1.0-1.5+ mil

**STORAGE CONDITIONS**

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

**PERFORMANCE PROPERTIES**

Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6 hrs. Base (NaOH) – No effect, 6 hrs.
Film Hardness	2H
Impact Resistance	Forward – 80 in/lbs Reverse – 40 in/lbs
Flexibility	Pass Conical Mandrel
Crosslinking	All crosslinking stop at 60°F/15°C

**VOC REGULATED AREAS**

All Values Ready To Spray

	<b>Standard Reduction (2:1)</b>
Max. VOC (LE)	502 g/L (4.2 lbs./gal)
Max. VOC (AP)	395 g/L (3.3 lbs./gal)
Avg. Gal. Wt.:	945 g/L (7.88 lbs./gal)
Avg. Wt.% Volatiles:	59.6%
Avg. Wt.% Exempt Solvent:	18.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	21.4%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	548 ft <sup>2</sup> (51.0 m <sup>2</sup> ) at 1 mil
Recommended Dry Film Thickness:	0.8 to 1.2 mil in 1 coat
Flash Point:	See SDS

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**

