

# Astro Clear 419-00™ Integrated Clear



## GENERAL

### DESCRIPTION

Designed for use with Nasco™ and Ful-Base® Enamels, Astro Clear 419-00 Integrated Clear adds depth of gloss and durability to color coats and can be used both as a topcoat or integrated clear.

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



## MIXING

### COMPONENTS

- Astro Clear 419-00 Integrated Clear
- Kwik-Kure 483-08 Enamel Activator
- Ful-Base 441-XX Reducer
- Nasco Gloss-E™ 483-13 Gloss Additive (Mid-Temp)
- Nasco Gloss-E 483-14 Gloss Additive (Low-Temp)

### MIX RATIO

Combine the components by volume. Mix thoroughly prior to activation.

#### Step 1 Activate Astro Clear 419-00

##### Option 1.

Component	Volume
Astro Clear 419-00 Integrated Clear	4
Kwik-Kure 483-08 Enamel Activator	1
Ful-Base 441-XX Reducer	1

##### Option 2.

Component	Volume
Astro Clear 419-00 Integrated Clear	2
Nason® Gloss-E 483-13 or 483-14	1

#### Step 2 Adding into Color

Component	Volume
Activated Nasco topcoat mixed color	1
Activated Astro Clear 419-00 Integrated Clear	1

### SPRAY VISCOSITY

12-13 seconds in a #2 Zahn Cup

### POT LIFE

4 hours 70°F (21°C)



## APPLICATION

### SPRAY PRESSURE

#### Conventional

Gravity Feed: 30-35 PSI at the gun  
 HVLP: 8-10 PSI at the cap

### TYPICAL GUN SET-UPS

Conventional & HVLP: 1.3-1.6 mm

### APPLICATION

Allow the final coat of color coat to flash 10 minutes. Apply 1 full coat.

### BUFFING

Allow to dry overnight. Use fine grit (1200 or finer). Follow Polish Manufacturer's recommendations.

### CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with lacquer thinner or low VOC cleaner in VOC regulated markets.

### IMPORTANT NOTES

When integrating Astro-Clear 419-00 Integrated Clear, use the appropriate Nason hardener in the proper ratios in both the color and the clear.



## DRY TIMES

### AIR DRY

Out of dust: 30 minutes  
 Tack Free: 45-60 minutes  
 Hard: Overnight  
 To Tape: Overnight

### FORCE DRY

20-30 minutes at 120-140°F (49-60°C)



## PHYSICAL PROPERTIES

### All Values Ready To Spray

#### 419-00 Clearcoat

Max. VOC (LE)  
 Max. VOC (AP)  
 Avg. Gal. Wt.  
 Avg. Wt.% Volatiles  
 Avg. Wt.% Exempt Solvent  
 Avg. Wt.% Water  
 Avg. Vol.% Exempt Solvent  
 Avg. Vol.% Water

#### Mix Ratio 4:1:1

4.7 lbs./gal (563 g/L)  
 4.6 lbs./gal (552 g/L)  
 7.72 lbs./gal (925 g/L)  
 60.8%  
 1.2%  
 0.0%  
 1.2%  
 0.0%

#### Mix Ratio 2:1

4.9 lbs./gal (583 g/L)  
 4.8 lbs./gal (575 g/L)  
 7.65 lbs./gal (917 g/L)  
 63.9%  
 1.1%  
 0.0%  
 1.2%  
 0.0%

Theoretical Coverage: 471 ft<sup>2</sup> (43.8 m<sup>2</sup>) at 1 mil  
 Recommended Dry Film Thickness: 2.0 mils in 2 coats  
 Flash Point: See SDS/MSDS

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## 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/MSDS 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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**1.855.6.AXALTA**  
**nasonfinishes.com**

