





# Metacryl FN – 5.0 VOC Single Stage




**COMPONENTS**  
 FN – 5.0 VOC Single Stage  
 7360, 7361, 7362 or 7363 Hardener  
 7370, 7371, 7372 or 7368 Reducer



**APPLICATION**  
 2 medium wet coats  
 5-10 minute flash time  
 between coats




**MIX RATIO**  
 4 : 1 : 1



**DRY TIME**  
 Hand Slick: 5 – 10 Minutes  
 Dust Free: 30 Minutes  
 Dry to Clearcoat: 30 Minutes  
 Dry to Handle: Overnight



**VISCOSITY**  
 ZAHN #3  
 20 – 22 Seconds



**VOC**  
 5.0 lbs/gal  
 599 g/L



## GENERAL

### DESCRIPTION

Metacryl FN 5.0 VOC Single Stage is a conventional solids, single stage designed to meet all of your manufacturing and refinish needs. Metacryl FN has excellent durability to complement its high gloss and leveling properties. With fast dry times and good color coverage, Metacryl FN can add to your bottom line by increasing productivity.

### COMPATIBLE SUBSTRATES

- All Metacryl 2K Primers and Sealers
- Properly prepared OEM or aged finishes

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



## MIXING

### COMPONENTS

Mix 4 parts FN 5.0 VOC Single Stage to 1 part 7360, 7361, 7362 or 7363 Hardener to 1 part 7370, 7371, 7372 or 7368 Reducer.

Component	Volume
Metacryl FN 5.0 VOC Single Stage	4
Metacryl 7360, 7361, 7362 or 7363 Hardener	1
Metacryl 7370, 7371, 7372 or 7368 Reducer	1

### HARDENER SELECTION

- 7360 Fast 65 – 75°F/18 – 24°C
- 7361 Medium 75 – 85°F/24 – 29°C
- 7362 Slow 85 – 95°F/29 – 35°C
- 7363 Extra Slow 85°F+/29°C+



**SPECIALTY COMPONENTS**

7377 Accelerator: 1 – 3%  
 7376 Fisheye Eliminator: Max 2%  
 7349 Matting Base

**POT LIFE**

4 Hours at 77°F/24°C / 50% R.H.



**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 - 1.5 mm	6 - 10 PSI	*At the cap
High Efficiency	1.3 - 1.5 mm	30 PSI	At gauge
Pressure Pot	1.0 – 1.1 mm	6 - 10 PSI	*At the pot

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

**APPLICATION**

Spray 2 medium wet coats. Allow 5-10 minutes flash time between coats.

**CLEAN-UP**

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner. Dispose of all paint and paint related materials in accordance with state and local regulations.

**DRY TIMES**



**AIR DRY  
 @ 75°F/23°C**

Hand Slick	5 – 10 Minutes
Dust Free	30 Minutes
Tape Free	8 – 12 Hours
To Clearcoat	30 Minutes
To Handle	Overnight
Force Dry Time	30 Minutes at 140°F/60°C
To Sand/Buf	After Cool Down (1 – 2 Hours)



**PHYSICAL PROPERTIES**

RTS VOC	5.0 lbs/gallon
RTS Volume Solids	37.0 – 40.0% (Average)
ZAHN #3 Viscosity	20-22 Seconds
DFT per Coat	Approximately 1.0 mil
Theoretical Coverage	Approx. 616 SqFt at 1 Mil DFT/mixed gallon
Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6hr Base (NaOH) – No effect, 6hr Skydrol – No effect, 6hr
Flexibility	Pass Conical Mandrel
Film Hardness	2H
Direct Impact	100 in/lbs
Reverse Impact	80 in/lbs
Product Class	2K Single Stage



### STORAGE CONDITIONS

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

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### VOC REGULATED AREAS

VOC as Applied

599 grams/liter | 5.0 lbs/gallon

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.

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In the United States and Canada:  
**1.855.6.AXALTA**  
**metacryl.us**

