
FUL-CRYL[®] LOW VOC ACRYLIC ENAMEL **3.5 VOC FACTORY PACKAGE COLORS**

Ful-Cryl[®] Acrylic Enamel superior quality and performance compliant at 3.5 VOC lbs./gal.

COMPONENTS:

Ful-Cryl[®] Low VOC Factory Package Colors
409-XXXXX[™]
Nason[®] 483-56[™] Catalyst
Nason[®] 441-60[™] VOC Exempt Reducer

SEALER:

Any Nason[®] Sealer

See Product Data Sheets for use of these products.

MIXING & REDUCING:

6-1-1

Mix:

6 Parts Ful-Cryl[®] Low VOC Acrylic Enamel
1 Part 483-56[™] Catalyst
1 Part 441-60[™] Reducer

Example:

To 3 quarts Ful-Cryl[®] Low VOC Acrylic Enamel add one pint of 483-56[™] Catalyst and one pint of 441-60[™] Reducer. Mix thoroughly.

POT LIFE:

4 Hours at 70°F.

SURFACE PREPARATION:

Before sanding: Using clean rags, remove all traces of oil, wax and grease, with Silicone and Wax Remover (use locally permitted cleaner in regulated areas). Sand old finish and chemically treat bare metal areas.

PRIMER-SURFACER:

Any Nason[®] Primer-Surfacer.

SPRAY VISCOSITY:

12"-14" #4 Ford Cup

SPRAY PRESSURE:

Siphon Gun; Spray material reduced as recommended at 60-80 PSI

Pressure Pot: 60-80 PSI at the gun
10-15 PSI on the pot.

HVLP: 8-10 PSI.

APPLICATION:

Solid Colors: Apply a medium wet coat and allow to tack. Follow with a wet second coat.

Metallic Colors: Apply a medium wet coat and allow to tack. Follow with a wet second coat evening the metallic as you go. A very light third coat can be applied if needed for metallic control.

NOTE: Allow sufficient flash time between coats for both solid and metallic colors.

DRYING TIME:

40 minutes out of Dust.
 60-80 minutes Tack Free
 Hard Overnight.
 Force Dry 20-30 minutes at 140°F.

FISHEYES:

DuPont V-459S™ Anti-Cratering Additive.

CLEANING OF PAINT EQUIPMENT:

Refer to appropriate Air Quality District requirements for proper use of equipment and solvent.

RECOMMENDED FILM THICKNESS:

1.8-2.2 Mil. Dry Film.

RECOATING:

Anytime.

FLASH POINT: CLOSED CUP

Below 20°F.

IMPORTANT NOTES:

Do not apply below 50°F or above 110°F.

Mixing and reducing instructions must be followed to remain VOC compliant.

Must be catalyzed with Nason® 483-56™ Catalyst.

Excessive, high pressure mist coating is not necessary and should be avoided to prevent Solvent loss during atomization.

Refer to local VOC product chart or Rules for Required Undercoat System

VOC - READY TO SPRAY:

Max. 3.5 Lbs./Gal.

FACTORY PACKAGE SALES CODES

Packaging - 3/4 filled gallon

Code	Color Description
409-49001	Black
409-49003	Silver Frost Effect
409-49020	Candy Red
409-49038	Starburst Silver Effect
409-49040	Starburst Blue Effect
409-49041	Brilliant Teal Effect
409-49044	Snow White
409-49046	Electric Blue Effect
409-49047	Holly Red
490-49050	GM-12 White
409-49051	Starburst Ruby Red
409-49058	Royal Blue Effect
409-49059	Champagne Gold Effect
409-49063	Black Effect
409-49064	Gunmetal Effect
409-B8424	Oxford White
409-B8713	Medium Garnet Effect
409-B9247	Rojo Viper
409-B9872	Cashmere Taupe Effect
409-M0413	Millennium Yellow
409-P4365	Azure Blue