

FLEETTHANE™ ACRYLIC URETHANE

FleetThane™ is a hard working, easy to apply single-stage fleet finish from the Ful-Base® Multi-Leg color system. It provides superior acrylic urethane appearance, protection and durability for trucks and commercial vehicles at a VOC 3.5 lbs/gal.

COMPONENTS:

ColorNet® Code "II"
Ful-Base® 430-XX System Toners
FleetThane™ 435-98™ Binder
483-52™ Catalyst/Activator
483-54™ High Solids Accelerator
Ful-Base® 441-20™, 441-21™ or 441-22™
Reducers
Super-Flo™ 441-29™

MIXING & REDUCING:

3-1

Mix:

3 parts FleetThane™
1 part 483-52™ Catalyst/Activator
Add 483-54™ High Solids Accelerator, 4 ounces per gallon.

Example: To 3 quarts of FleetThane™ Acrylic Urethane (96 oz.) add 1 quart (32 oz.) 483-52™ Catalyst and 4 ounces of 483-54™ Accelerator. Mix thoroughly.

POT LIFE:

1-2 Hours at 70°F.

SURFACE PREPARATION:

Before sanding, remove all traces of oil, wax and grease with 441-05™ Silicone and Wax Remover (use locally permitted cleaner in regulated areas) using clean rags. Sand old finish and chemically treat bare metal areas.

PRIMER:

Ful-Poxy® 491-16™ Epoxy Primer
491-17™ Etch Primer
491-30™ Chrome Free Etch Primer
Corlar® 934S™
URO® 1220S™
Tufcote™

SPRAY VISCOSITY:

18"-21" #4 Ford Cup

SPRAY PRESSURE:

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

Pressure Pot: 60-80 PSI at the gun.
12-15 PSI on the pot.

HVLP: 8-10 PSI.

APPLICATION:

Solid Colors: Spray medium wet coat, allow to tack, follow with full wet coat. Allow sufficient flash time (10-20 mins.) between coats.

Metallic Colors: Apply a medium wet first coat followed by a medium second coat evening the metallic as you go. A very light third coat may be applied if needed for metallic control. Allow sufficient flash time (10-20 minutes) between first and second coat.

RECOATING:

Anytime.

COVERAGE:

Approx. 820 sq. ft/gal. at 1 mil (average depending on color).

FISHEYES:

Nason® 495-01™ as needed.

DRYING TIME:

Air Dry: 2-4 hours tack free.

Hard Dry: Overnight.

Force Dry: 20-30 minutes at 120-140°F after a flash time of 15 minutes.

Tape Free: Overnight or when hard.

Proper accelerator use is required for these dry times.

CLEANING OF PAINT EQUIPMENT:

Use Nason® 481-06™ Lacquer Thinner or Nason® SelectThinner 481-16™. Refer to appropriate Air Quality District requirements for proper use of equipment and solvent.

RECOMMENDED FILM THICKNESS:

1.8-2.2 Mil. Dry Film

FLASH POINT: CLOSED CUP

Below 80°F

PHYSICAL PROPERTIES:*

Appearance	Excellent
Adhesion	Excellent
Mek Rubs	100+
Direct Impact	80+ inch/lb
Chip	Very Good
Humidity	Excellent
Salt Spray	Excellent

CHEMICAL RESISTANCE:

5% Sodium Hydroxide	No Effect
10% Sulfuric Acid	No Effect
Methyl Ethyl Ketone	No Effect
Gasoline	No Effect
Toluene/Naphtha (50/50)	No Effect

*Using Ful-Poxy® Epoxy Primer.

MAX. VOC READY-TO-SPRAY:

3.5 lbs/gal.

IMPORTANT NOTES:

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

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