

FUL-THANE® 2K URETHANE

Ful-Thane® Urethane, one of the distinct paint qualities in the versatile Ful-Base® Multi-Leg Color System, provides an easy-to-apply, single-stage finish unmatched by any other urethane system on the market. Ful-Thane® offers outstanding durability for automobiles, trucks and commercial vehicles. Ful-Thane® 2K Urethane is also available in Ful-Thane® 400-XX™ High Volume Factory Packages.

SYSTEM COMPONENTS:

ColorNet® code "IB"
Ful-Base® 430-XX™ Sytem Toners
Ful-Thane® 435-91™ Urethane Binder
Ful-Thane® 483-15™ Urethane Catalyst
Ful-Base® 441-XX™ Reducers

MIXING & REDUCING:

8-1-2

Mix:

8 parts Ful-Thane® 2K Urethane
1 part Ful-Thane® 483-15™ Catalyst
2 parts Ful-Base® Reducer

Example: To 1 gallon of unreduced Ful-Thane® 2K Urethane add 1 pint of 483-15™ Catalyst. Mix thoroughly. Reduce 25-35% with:

Ful-Base® 441-20™ Fast (50-65°F)
Ful-Base® 441-21™ Medium (65-85°F)
Ful-Base® 441-22™ Slow (85°F +)

POT LIFE:

4 Hours at 70°F.

SURFACE PREPARATION:

Before sanding, remove all traces of oil, wax and grease with Nason® 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
Nason® 491-17™ Etch-Primer
Nason® 491-30™ Chrome Free Etch Primer

PRIMER-SURFACER:

Nason® 421-05™ Universal
Nason® Ful-Fil™ 421-08™/421-09™ Acrylic
Ful-Thane® Sentry™ 421-15™ 2K Catalyzed
Nason® SelectPrime™ 421-17™ 2K Urethane
Nason® SelectPrime™ 421-20™
Nason® 470-04™ Water Borne

SEALER: (Required)

Nason® Bond-Seal™ 422-XX™ (Must use Ful-Base® Reducer.)
Ful-Seal® Select™ 422-23™

See Product Data Sheets for use of these products.

SPRAY VISCOSITY:

14"-16" #4 Ford Cup
19"-21" #2 Zahn

SPRAY PRESSURE:

HVLP: 8-10 PSI at the air cap.
Siphon Feed: 40-70 PSI at the gun.
Pressure Feed: 40-70 PSI at the gun.
(8-12 PSI Fluid Flow on the pot).

APPLICATION:

Solid Colors: Spray medium wet coat, allow to tack, follow with full wet coat.

Metallic Colors: Apply 2 medium light coats with 5-10 minutes flash time between coats. A third and final "mist coat" may be applied if necessary to even the metallic.

Integrated Clear: To enhance depth of color and provide a custom look, Ful-Thane® 401-20™ Integrated 2K Urethane Clear may be used. Mix one quart of catalyzed and reduced 401-20™ with one quart of catalyzed and reduced color. Both are mixed 8:1:2.

DO NOT USE 401-20™ AS TOPCOAT-CLEAR

CLEARCOAT:

Nason® SelectClear™ 460-00™ 2.1 VOC

Nason® SelectClear™ 467-00™ 3.5 VOC

Nason® Overcoat™ 486-00™ Fast Dry Urethane

Nason® SelectClear™ 496-00™ Clearcoat

Nason® SelectClear™ 497-00™ Panel & Overall

Apply clear over Ful-Thane® Urethane after color has completely tacked. Metallics may require longer flash time to avoid metallic movement.

DRYING TIME:

30 minutes out of dust; 45 to 60 minutes tack free. Hard—overnight. Force dry 20-30 minutes at 120-140°F. Ful-Thane® can be recoated at anytime. All dry times are at normal temperatures, lower temperatures will require longer dry times.

Accelerator: To decrease tape time by 50%, use 2-4 ounces of Ful-Thane® 483-18™ Accelerator per gallon of Ful-Thane® color.

POLISHING:

Allow overnight dry.

Remove dust with soft dampened cloth.

Use 3M Perfect-it II or similar fine compound with soft polishing pad.

Solid Colors: Lightly sand with 1200 grit or finer.

Metallic Colors: Lightly "Nib" sand small imperfections only.

Operate machine at 1700-2000 RPM.

FISHEYES:

Add 2-4 oz Nason® 495-01™ Urethane Fisheye Eliminator per RTS gallon.

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

CHEMICAL RESISTANCE:

1 hour Chemical Resistance (Air dried for 8 days):

10% Ammonium Hydroxide—No Spot

10% Sodium Hydroxide—No Spot

10% Phosphoric Acid—No Spot

10% Hydrochloric Acid—No Spot

3 hour Chemical Resistance (Air dried for 12 days):

10% Ammonium Hydroxide—No Spot

10% Sodium Hydroxide—No Spot

10% Phosphoric Acid—No Spot

10% Hydrochloric Acid—No Spot

Solvent Resistance - 100 Double Rubs (After 8 Days):

Methyl Ethyl Ketone (MEK)—Slight to moderate dulling.

Xylene—Slight dulling.

DIRECT IMPACT:

Direct Impact (Panels primed with Epoxy Primer and aged 25 days):

Passes 40 inch/lb.

Max. VOC Ready-To-Spray:

5.0 lbs/gal. less exempt.

IMPORTANT NOTES:

Caution: Ful-Thane® Urethane must be catalyzed with Ful-Thane® 483-15™ 2K Catalyst. Do not apply Ful-Thane® below 50°F.