

FUL-THANE® HIGH SOLIDS THREE POINT FIVE URETHANE

Ful-Thane® High Solids Three Point Five Urethane is a high performance, easy to apply single-stage low VOC urethane leg of the versatile Ful-Base® Multi-Leg color system. It provides outstanding appearance, protection and durability for automobiles, trucks and commercial vehicles at a VOC 3.5 lbs/gal.

COMPONENTS:

ColorNet® code "IG"
Ful-Base® 430-XX™ System Toners
Ful-Thane® 435-95™ 3.5 Urethane Binder
Nason® 483-52™ 3.5 Urethane Catalyst
Nason® 483-54™ High Solids Accelerator
Ful-Base® 441-20™, 441-21™ or 441-22™
Reducers
Nason® Super-Flo™ 441-29™

MIXING & REDUCING:

3-1

Mix:

3 parts Three Point Five Urethane
1 part 483-52™ Three Point Five Catalyst
483-54™ High Solids Accelerator, 4 oz/gallon.

Example:

To 3 quarts Three Point Five 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 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
Nason® 491-17™ Etch Primer
Nason® 491-30™ Chrom-Free Etch Primer

PRIMER-SURFACER:

Nason® 421-05™ Universal
Nason® Ful-Fil™ 421-08™, 421-09™ Acrylic
Ful-Thane® Sentry™ 421-15™ Catalyzed
Nason® SelectPrime™ 421-17™ 2K Urethane
Nason® SelectPrime™ 421-20™
Nason® 470-04™ High-Build Waterborne

SEALER: (RECOMMENDED)

Nason® Bond-Seal™ 422-XX™ (Must use Ful-Base® Reducer.)
Ful-Base® 422-33™ Three Point Five Sealer
Ful-Seal® Select™ 422-23™
Nason® 422-28™ 2.8 VOC Sealer
See Product Data Sheets for use of these products.

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[™] Urethane Fisheye Eliminator 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.