

FUL-THANE[®] LOW VOC URETHANE 3.5 VOC COLORS

Ful-Thane[®] Urethane Superior quality and performance compliant at 3.5 VOC lbs./gal.

COMPONENTS:

ColorNet[®] code "IM"
Ful-Base[®] 430-XX[™] Systems Toners
Nason[®] 435-99[™] Urethane 3.5 VOC Binder
Nason[®] 483-56[™] Catalyst
Nason[®] 441-60[™] VOC Exempt Reducer

MIXING & REDUCING:

6-1-1

Mix:

6 Parts Ful-Thane[®] Urethane 3.5 VOC Color
1 Part Nason[®] 483-56[™]
1 Part Nason[®] 441-60[™]

Example:

To 3 quarts 3.5 VOC Color add one pint of 483-56[™] and one pint of 441-60[™]. 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:

Nason[®] 470-04[™] High-Build Water Borne
Any Nason[®] Surfacer

SEALER: (RECOMMENDED)

Ful-Base[®] 422-33[™] Three Point Five Sealer.
Nason[®] 422-28[™] 2.8 VOC Sealer
Any Nason[®] Sealer

See Product Data Sheets for use of these products.

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.

FISHEYE:

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.