

## FUL-CRYL® II ACRYLIC ENAMEL

Ful-Cryl® II, one of the distinct paint qualities in the versatile Ful-Base® Multi-Leg Color system, is an acrylic enamel with outstanding performance characteristics. Ful-Cryl® II Acrylic Enamel offers excellent gloss, superior flow, chip resistance, durability and

### SYSTEM COMPONENTS:

ColorNet® code "ID"  
Ful-Base® 430-XX™ System Toners  
Ful-Cryl® II 435-94™ Acrylic Enamel Binder  
Ful-Cryl® 483-11™ Cat II Catalyst  
Ful-Base® 441-XX™ Reducers

### MIXING & REDUCING:

#### 8-1-2

#### Mix:

8 Parts Ful-Cryl® II  
1 Part Ful-Cryl® 483-11 Cat II Catalyst  
2 Parts (25%) Ful-Base® Reducer,  
Ful-Base® 441-20™ Fast (50-65°F)  
Ful-Base® 441-21™ Medium (65-85°F)  
Ful-Base® 441-22™ Slow (85°F +)

**Example:** To 1 gallon Ful-Cryl® II add 1 pint 483-11™ Cat II Catalyst. Reduce 25% with 441-XX™ Reducer.

**IMPORTANT: Ful-Cryl® II must be catalyzed with 483-11™.**

### POT LIFE:

4 Hours at 70°F.

### SURFACE PREPARATION:

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

### PRIMER:

Ful-Poxy® 491-16™ Epoxy  
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™ 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. Must be topcoated within 1 hour.)

Ful-Seal® Select™ 422-23™

See Product Data Sheets for use of these products.

### SPRAY PRESSURES:

HVLP: 8-10 PSI at the air cap.  
Siphon Feed: 40-70 PSI at the gun.

### SPRAY VISCOSITY:

14"-16" #4 Ford Cup  
20"-21" #2 Zahn

## APPLICATION:

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

**Metallic Colors:** Apply 2 medium wet 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 8-1-3. **DO NOT USE 401-20™ AS A TOPCOAT CLEAR.**

## CLEARCOAT:

Nason® SelectClear™ 460-00™ 2.1 VOC  
Nason® SelectClear™ 467-00™ 3.5 VOC  
Nason® Overcoat™ 486-00™ Clear  
Nason® SelectClear™ 496-00™ Clearcoat  
Nason® SelectClear™ 497-00™ Panel&Overall

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

## DRYING TIME:

30 minutes out of dust; 45-60 minutes tack free. Hard—overnight. To tape—overnight. Allow to flash before applying heat. Force dry 20-30 minutes at 120-140°F.

## Polishing:

Allow overnight dry. Use 3M Perfect-it II or similar fine compound with soft polishing pad. Remove dust with soft dampened cloth.

**Solid Colors:** Lightly sand with 1200 grit or finer.

**Metallic Colors:** Lightly "Nib" sand only small defects with 1500 grit or finer. Operate machine at 1700-2000 RPM.

## ADDITIVES:

4 fluid oz. of Ful-thane® 483-18™ Accelerator per gallon of Ful-Cryl® II can be added to cut tape time in half.

## FISHEYES

Nason® 495-01™ Urethane Fisheye Eliminator 2-4 oz./gallon if needed.

## 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

## IMPORTANT NOTES:

Caution: Ful-Cryl® II Acrylic Enamel must be catalyzed with 483-11™. Paint will not dry without catalyst.

## READY TO SPRAY VOC

4.7-4.9 Lb./gal.