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## **FUL-CRYL<sup>®</sup> LOW VOC ACRYLIC ENAMEL 3.5 VOC COLORS**

Ful-Cryl<sup>®</sup> Acrylic Enamel superior quality and performance compliant at 3.5 VOC lbs./gal.

### **COMPONENTS:**

ColorNet<sup>®</sup> code "IN"  
Ful-Base<sup>®</sup> 430-XX<sup>™</sup> System Toners  
Ful-Cryl<sup>®</sup> 435-84<sup>™</sup> 3.5 VOC Binder  
Nason<sup>®</sup> 483-56<sup>™</sup> Catalyst  
Nason<sup>®</sup> 441-60<sup>™</sup> VOC Exempt Reducer

### **MIXING & REDUCING:**

#### **6-1-1**

#### **Mix:**

6 Parts Ful-Cryl<sup>®</sup> Acrylic Enamel 3.5 VOC  
Color  
1 Part 483-56<sup>™</sup> Catalyst  
1 Part 441-60<sup>™</sup> Reducer

#### **Example:**

To 3 quarts 3.5 VOC Color add one pint of 483-56<sup>™</sup> Catalyst and one pint of 441-60<sup>™</sup> Reducer. 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 Sili-cone and Wax Remover (use locally permitted cleaner in regulated areas). Sand old finish and chemically treat bare metal areas.

### **PRIMER-SURFACER:**

Any Nason<sup>®</sup> Primer-Surfacer.

### **SEALER:**

Any Nason<sup>®</sup> 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.



# Technical Manual

## **DRYING TIME:**

40 minutes out of Dust.  
60-80 minutes Tack Free  
Hard Overnight.  
Force Dry 20-30 minutes at 140°F.

## **FISHEYES:**

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.