

Ful-Base[®] Basecoat (IF Quality)



GENERAL

DESCRIPTION

A 6.1 lb/gal (740 g/l) VOC compliant, solventborne basecoat designed for overall repairs to OEM basecoat/clearcoat finishes.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

- Ful-Base[®] Basecoat IF Quality
- Ful-Base[®] 430-XX Tints
- Ful-Base[®] 435-93[™] Basecoat Binder
- Ful-Base[®] 483-30[™] Basecoat Activator
- Ful-Base[®] 441-2X[™] Reducers
- *Do not use 441-29**

MIX RATIO

Combine the components by volume (8:½:4). Mix thoroughly prior to activation.

Component	Volume
Ful-Base [®] Basecoat IF Quality Color	8
Ful-Base [®] 483-30 [™] Basecoat Activator	½
Ful-Base [®] 441-2X [™] Reducers	4
*Do not use 441-29	

POT LIFE

4 hours at 70°F (21°C)

SPRAY VISCOSITY

20-21 seconds in a Zahn #2



APPLICATION

SURFACE PREPARATION

Before sanding, remove all traces of oil, wax and grease with Nason[®] 441-05[™] Silicone and Wax Remover or Nason[®] 481-75[™] Surface Cleaner using clean rags. In regulated areas use locally permitted Silicone and Wax remover or Surface Cleaner.

Prepare all surfaces to be repainted using the recommended undercoat systems, following recommended procedures. Finish sand with P400 grit paper or finer (dry or wet).

COMPATIBLE PRODUCTS

All Nason[®] primers, primer-surfacers and sealers as locally permitted.

SPRAY PRESSURE

Conventional	
Gravity Feed:	25-45 PSI at the gun
Siphon Feed:	30-45 PSI at the gun
HVLP	8-10 PSI at the air cap

GUN SETUP

Conventional
 Siphon Feed: 1.4-1.6 mm
 Gravity Feed: 1.4-1.6 mm

HVLP
 Siphon Feed: 1.4-1.6 mm
 Gravity Feed: 1.3-1.6 mm

APPLICATION

Apply two medium wet coats or to hiding. Flash each coat to dull/dry. For metallic colors, use a mist coat in conjunction with the final coat for best flake control. Do not apply if less than 50°F (10°C).

CLEARCOAT

Ful-Base® Basecoat IF Quality must be clear coated. Compatible with all Nason® clearcoats as locally permitted; (except 419-00 & 401-20 will not be compliant below 5.0 lbs./gal).

CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with lacquer thinner or low VOC cleaner in VOC regulated markets.



DRY TIMES

Allow basecoat to set up for 15 minutes prior to clear coating. Longer dry time may be required depending on shop conditions and the number of coats applied.

RECOATING

Anytime



PHYSICAL PROPERTIES

All Values Ready To Spray

Max VOC (LE):	6.1 lbs./gal (725 g/L)
Max VOC (AP):	5.9 lbs./gal (704 g/L)
Avg. Gal. Wt.:	7.90 lbs./gal (947 g/L)
Avg. Wt.% Volatiles:	69.5%
Avg. Wt.% Exempt Solvent:	0.0%
Avg. Wt.% Water:	0.1%
Avg. Vol.% Exempt Solvent:	0.0%
Avg. Vol.% Water:	0.1%
Recommended Dry Film Thickness:	0.5-2.0 mil
Flash Point:	See SDS
Theoretical Coverage:	305 ft ² (28.3 m ²) at 1 mil

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS/MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: August 2016

In the United States:
1.855.6.AXALTA
nasonfinishes.com

In Canada:
1.800.668.6945
nasonfinishes.ca

