# Ful-Base® Basecoat (IR Quality)

## GENERAL

### DESCRIPTION

A 3.5 lb/gal (420 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 IR Quality
Ful-Base® 430-XX Tints
Ful-Base® 435-83™ Basecoat Binder
Ful-Base® 483-56™ Low VOC Activator
Ful-Base® 441-66™ Low VOC Reducer (Mid-Temp)
Ful-Base® 441-68™ Low VOC Reducer (High-Temp)
Ful-Base® 441-83™ Low VOC Flow Additive

### MIX RATIO

Combine the components by volume. Mix thoroughly prior to activation.

| Component | Volume |
|---|---|
| Ful-Base® Basecoat IR Quality Color | 1 |
| Ful-Base® 441-66™ / 441-68™ Low VOC Reducer | 1 |

For metallic colors reduce an additional 25% with 441-68™ Low VOC Reducer.

**Optional Activation**
System performance is optimized when activated with 483-56™ Low VOC Activator. Add 1 oz. (30 ml) 483-56™ per RTS quart.

### POT LIFE

4 hours at 70°F (21°C)

**Tips for Success**
For high temperatures and overall passenger vehicles:

- Reduce an additional 25% with 441-68™ Low VOC Reducer
- Per RTS quart, add 1 oz (30 ml) 441-83™ Low VOC Flow Additive.

## APPLICATION

### SURFACE PREPARATION

Before sanding, remove all traces of oil, wax and grease 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 P320-P400 grit paper (dry or wet).

### COMPATIBLE PRODUCTS

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

### SPRAY PRESSURE

| | |
|---|---|
| HVLP: | 8-10 PSI at the air cap |

**Conventional**

| | |
|---|---|
| Gravity Feed: | 40-45 PSI at the gun |
| Siphon Feed: | 35-45 PSI at the gun |

### GUN SETUP

HVLP

| | |
|---|---|
| Gravity Feed: | 1.3-1.6mm |
| Siphon Feed: | 1.3-1.6mm |

Conventional

| | |
|---|---|
| Gravity Feed: | 1.3-1.6mm |
| Siphon Feed: | 1.3-1.6mm |

### APPLICATION

Apply 2 medium wet coats or to hiding. Allow each coat to flash dull/dry.

### CLEARCOAT

Compatible with all Nason® clearcoats as locally permitted.

### CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with a VOC compliant lacquer thinner or cleaner.

## DRY TIMES

Allow base coat 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.

## PHYSICAL PROPERTIES

**All Values Ready To Spray**

| | |
|---|---|
| Max VOC (LE): | 393 g/L (3.3 lbs./gal) |
| Max VOC (AP): | 87 g/L (.7 lbs./gal) |
| Avg. Gal. Wt.: | 1079 g/L (9.00 lbs./gal) |
| Avg. Wt.% Volatiles: | 84.5% |
| Avg. Wt.% Exempt Solvent: | 77.8% |
| Avg. Wt.% Water: | 0% |
| Avg. Vol.% Exempt Solvent: | 80.0% |
| Avg. Vol.% Water: | 0% |
| Recommended Dry Film Thickness: | 0.5-2.0 mils |
| Flash Point: | See SDS/MSDS |
| Theoretical Coverage: | 182 $ft^2$ (20.2 $m^2$) 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.

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**In the United States:**
**1.855.6.AXALTA**
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**In Canada:**
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