Ful-Thane® 2K Urethane Binder (IB Quality)

GENERAL

DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, urethane single-stage topcoat that is easy-to-apply and provides outstanding durability for a variety of applications.

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

MIXING

COMPONENTS

Ful-Thane® 2K Urethane Binder (IB Quality)
Ful-Base® 430-XX Tints
Ful-Thane® 435-91™ 2K Urethane Binder
Ful-Thane® 483-15™ 2K Urethane Activator
Ful-Base® 441-20™ Reducer (Low-Temp)
Ful-Base® 441-21™ Reducer (Mid-Temp)
Ful-Base® 441-22™ Reducer (High-Temp)

MIX RATIO

Combine the components by volume (8:1:2). Mix thoroughly prior to activation.

Component	Volume
Ful-Thane® 2K Urethane Binder (IB Quality)	8
Ful-Thane® 483-15™ 2K Urethane Activator	1
Ful-Base® 441-20™ / 441-21™ / 441-22™ Reducer	2

ADDITIVES

Fisheye Eliminator

- Add 2-4 oz (60-120 ml) Nason® 495-01™ Fisheye Eliminator per RTS gallon as required.

Accelerator

- In cool temperatures or to decrease tape time, add 2-4 oz (60-120 ml) of Ful-Thane® 483-18™ Accelerator per RTS gallon.

POT LIFE

4 hours at 70°F

APPLICATION

SUBSTRATES

All OEM finishes, as well as properly prepared metal, fiberglass, plastic and fully cured previously painted surfaces.

SURFACE PREPARATION

Before sanding, wash with soap and water and remove wax and grease with Nason® 441-05™ Silicone and Wax Remover or 481-75™ Surface Cleaner (use locally permitted cleaner in regulated areas) using clean rags. Sand finishes according to primer or substrate recommendations and chemically treats large bare metal areas.

COMPATIBLE PRODUCTS

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

SPRAY VISCOSITY

19-21 seconds Zahn #2

SPRAY PRESSURE

Conventional

Siphon Feed:	40-70 PSI at the gun
Pressure Feed:	40-70 PSI at the gun 8-12 PSI Fluid Flow on the pot
HVLP	8-10 PSI at the air cap

GUN SETUP

Conventional

Siphon Feed:	1.6-1.8 mm
Gravity Feed:	1.4-1.6 mm
Pressure:	0.8-1.2 mm

HVLP

Siphon Feed:	1.5-1.8 mm
Gravity Feed:	1.3-1.6 mm
Pressure:	0.8-1.1 mm

APPLICATION

Solid Colors: Spray medium wet coat. Allow to tack. Follow with a full wet coat. Do not apply Ful-Thane® below 50°F (10°C).

Metallic Colors

Apply 2 medium wet coats. Flash 5-10 minutes 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™ 2K Integrated Clear may be used. Mix one quart of catalyzed and reduced Ful-Thane® 401-20™ 2K Integrated Clear with one quart of catalyzed and reduced color. Both are mixed 8:1:2.

Do not use Ful-Thane® 401-20™ 2K Integrated Clear as a topcoat clear.

CLEANING OF PAINT EQUIPMENT

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

DRY TIMES

AIR DRY

Out of dust:	30 minutes
Tack Free:	45-60 minutes
Hard:	Overnight

FORCE DRY

20-30 minutes at 120-140°F (49-60°C)

All dry times are at normal temperatures, lower temperatures will require longer dry times.

POLISHING

Allow overnight dry. Remove dust with soft, dampened cloth. Use fine compound with soft polishing pad. Operate machine at 1700-2000 RPM

- Solid Colors: Lightly sand with 1200 grit or finer.
- Metallic Colors: Lightly “nib” sand small imperfections only.

Note: Best for solid colors. Metallic colors will be damaged if polished excessively.

PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	5.0 lbs./gal (595 g/L)
Max. VOC (AP):	4.9 lbs./gal (586 g/L)
Avg. Gal. Wt.:	8.10 lbs./gal (971 g/L)
Avg. Wt.% Volatiles:	55.5%
Avg. Wt.% Exempt Solvent:	1.4%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	1.8%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	551 ft^2 (51.5 m^2) at 1 mil
Recommended Dry Film Thickness:	2.0 mil
Flash Point:	See SDS/MSDS

CHEMICAL RESISTANCE

1 Hour Chemical Resistance (Air dried for 8 days):

- 10% Ammonium Hydroxide-No spot
- 10% Sodium Hydroxide-No spot
- 10% Phosphoric Acid-No spot
- 10% Hydrochloric Acid-No spot

3 Hour Chemical Resistance (Air dried for 12 days):

- 10% Ammonium Hydroxide-No spot
- 10% Sodium Hydroxide-No spot
- 10% Phosphoric Acid-No spot
- 10% Hydrochloric Acid-No spot

Solvent Resistance-100 Double Rubs (after 8 days):

- MEK-Slight to moderate dulling.
- Xylene-Slight dulling.

DIRECT IMPACT

Direct Impact (Panels primed with Epoxy Primer and aged 25 days): Passes 40 inch/lb.

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:
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In Canada:
1.800.668.6945
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