

Ful-Thane® 2K Urethane Topcoat (IS Quality)



GENERAL

DESCRIPTION

A 2.8 lb/gal (340 g/l) VOC compliant, urethane single-stage topcoat that provides good quality and performance and features a wide range of sparkling metallic and rich solid colors.

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



MIXING

COMPONENTS

Ful-Thane® 2K Urethane Topcoat (IS Quality)
 Ful-Base® 430-XX Tints
 Ful-Base® 441-21™ Reducer (Med-Temp)
 Ful-Thane® 435-82™ 2.8 VOC Binder
 Ful-Base® 483-56™ Low VOC Activator
 Ful-Base® 441-60™ Low VOC Reducer (Low-Temp)
 Ful-Base® 441-66™ Low VOC Reducer (Mid-Temp)
 Ful-Base® 441-68™ Low VOC Reducer (High-Temp)

MIX RATIO

Combine the components by volume (4:1:2). Mix thoroughly prior to activation.

Component	Volume
Ful-Thane® 2K Urethane Topcoat (IS Quality)	4
Ful-Base® 483-56™ Low VOC Activator	1
Ful-Base® 441-60™ / 441-66™ / 441-68™ Reducer	2

ADDITIVES

Fisheye Eliminator

Add ½ to 2 oz Nason® 495-02™ Low VOC Fisheye Eliminator per ready to spray gallon Ful-Thane® 2K Urethane Topcoat (IS Quality)

POT LIFE

4 hours at 70°F (21°C)

SPRAY VISCOSITY

14-16 seconds in a Zahn #2



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

Compatible with all Nason® primers, primer-surfacers and sealers as locally permitted.

SPRAY PRESSURE

Conventional

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

GUN SETUP

Conventional

Gravity Feed:	1.4-1.6 mm
Siphon Feed:	1.6-1.8 mm

HVLP

Gravity Feed:	1.2-1.4 mm
Siphon Feed:	1.5-1.8 mm

APPLICATION

Apply 2 wet coats or to hiding and cross coat metallics as needed. Flash 10-15 minutes between coats.
Do not apply below 50°F (10°C).

Integrated Gloss Enhancer

To enhance the depth of color and provide a custom look, add Ful-Thane® 401-22™ Low VOC Integrated Gloss Enhancer. Activate sufficient gloss enhancer to complete the finish and mix 4 parts of the activated enhancer with 1 part activated Ful-Thane® IS color. Air drying the finish will produce the best results.

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).

Longer dry time may be required depending on shop conditions and the number of coats applied.



POLISHING

Remove dust with soft, dampened cloth. Use fine compound with soft polishing pad.

Solid Colors: Lightly sand with 1200 grit or finer. Operate machine at 1700-2000 rpm

Metallic Colors: Lightly “nib” sand small imperfections only. Note: Metallic colors will be damaged if polished excessively.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	320 g/L (2.7 lbs./gal)
Max. VOC (AP):	212 g/L (1.8 lbs./gal)
Avg. Gallon Wt.:	1121 g/L (9.35 lbs./gal)
Avg. Wt.% Volatiles:	54.7%
Avg. Wt.% Exempt Solvent:	36.2%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	34.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	655 ft ² (61.1 m ²) at 1 mil
Recommended Dry Film Thickness:	2.0 mils
Flash Point:	See SDS/MSDS

Standard Reduction

Integrated Gloss Recommendation

Max. VOC (LE):	253 g/L (2.1 lbs./gal)
Max. VOC (AP):	149 g/L (1.2 lbs./gal)
Avg. Gallon Weight:	1089 g/L (9.09 lbs./gal)
Avg. Wt.% Volatiles:	56.8%
Avg. Wt.% Exempt Solvent:	43.1%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	41.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	657 ft ² (72 m ²) at 1 mil
Recommended Dry Film Thickness:	1.5 mils in 1 coat
Flash Point:	See SDS

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
nasonfinishes.com

In Canada:
1.800.668.6945
nasonfinishes.ca

