

FUL-THANE[®] 2K URETHANE

Ful-Thane[®] Urethane, one of the distinct paint qualities in the versatile Ful-Base[®] Multi-Leg Color System, provides an easy-to-apply, single-stage finish. Ful-Thane[®] offers outstanding durability for automobiles, trucks and commercial vehicles. Ful-Thane[®] 2K urethane is also available in Ful-Thane[®] 400-XX High Volume Factory Packages.

COMPONENTS:

ColorNet[®] Code "1B"
Ful-Base[®] 430-XX System Toners
Ful-Thane[®] 435-91[™] Urethane Binder
Ful-Thane[®] 483-15[™] Urethane Catalyst
Ful-Base[®] 441-XX Reducers

MIXING AND REDUCING:

8:1:2
Mix:
8 parts Ful-Thane[®] 2K Urethane
1 part Ful-Thane[®] 483-15[™] Urethane Catalyst
2 parts Ful-Base[®] Reducer
 Ful-Base[®] 441-20[™] Fast (50-65°F)
 Ful-Base[®] 441-21[™] Medium (65-85°F)
 Ful-Base[®] 441-22[™] Slow (85°F+)

Example:
To 1 gallon of Ful-Thane[®] 2K Urethane, add 1 pint of 483-15[™] Catalyst. Reduce with 1 quart Ful-Base[®] 441-XX Reducer.

POT LIFE:

4 hours @ 70°F / 50% Relative Humidity

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[™] Aerosol 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.

PRIMER:

Compatible with all Nason[®] Primers as locally permitted.

PRIMER-SURFACER:

Compatible with all Nason[®] Primer-Surfacers as locally permitted.

SEALER:

Compatible with all Nason[®] Sealers as locally permitted.

SPRAY VISCOSITY:

19" – 21" #2 Zahn

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.

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TYPICAL GUN SET-UPS:

Conventional

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

HVLP

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

APPLICATION:

Solid Colors: Spray medium wet coat, allow to tack, then follow with a full wet coat.

Metallic Colors: Apply 2 medium wet coats with 5–10 minutes flash time 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[™] Integrated 2K Urethane clear may be used. Mix one quart of catalyzed and reduced 401-20[™] with one quart of catalyzed and reduced color. Both are mixed 8:1:2.

DO NOT USE 401-20[™] AS A TOPCOAT CLEAR.

DRYING TIME:

Out of dust: 30 minutes
Tack Free: 45 – 60 minutes
Hard: Overnight
Force Dry: 20 – 30 minutes at 120 – 140 °F
All dry times are at normal temperatures, lower temperatures will require longer dry times.

Accelerator: In cool temperatures or to decrease tape time, add 2–4 oz of Ful-Thane[®] 483-18[™] Accelerator per RTS gallon of Ful-Thane[®] color.

POLISHING:

Allow overnight dry.
Remove dust with soft, dampened cloth.
Use fine compound with soft polishing pad.
Solid Colors: Lightly sand with 1200 grit or finer.
Metallic Colors: Lightly “nib” sand small imperfections only.

Operate machine at 1700 – 2000 RPM.

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

FISHEYES:

As needed, 2-4 oz Nason[®] 495-01[™] Urethane Fisheye Eliminator per RTS gallon

CLEANING OF PAINT EQUIPMENT:

Use Nason[®] 481-16[™], Nason[®] 481-21[™] Low VOC Gun & Equipment Cleaning Solvent, or any other DuPont equipment cleaner as permitted by local regulations.

PHYSICAL PROPERTIES:

VOC LE: 5.0 lbs/gal maximum, ready-to-spray
Theoretical Coverage: 554 sq ft @ 1 mil
Weight Solids: 41.7% average
Volume Solids: 34.6% average
Recommended Dry Film Thickness: 2.0 mil
Flash Point: See 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

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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.

IMPORTANT NOTES:

- Caution: Ful-Thane[®] Urethane must be catalyzed with Ful-Thane[®] 483-15[™] 2K Catalyst.
- Do not apply Ful-Thane[®] below 50 °F.

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 and usage 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 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.

Please visit: www.nason.dupont.com to view or print an additional copy of this technical "Product Data Sheet."



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