

Ful-Thane® 2K Urethane (IB Quality)



GENERAL

DESCRIPTION

A 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-Base® 430-XX Tints
 Ful-Thane® 435-91™ 2K Urethane Binder
 Ful-Thane® 483-15™ 2K Urethane Catalyst
 Ful-Base® 441-20™ Reducer Fast
 Ful-Base® 441-21™ Reducer Medium
 Ful-Base® 441-22™ Reducer Slow
 Ful-Base® 441-29™ Reducer Super Flow

MIX RATIO

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

Component	Volume
Ful-Thane® 2K Urethane (IB Quality)	8
Ful-Thane® 483-15™ 2K Urethane Catalyst	1
Ful-Base® 441-20™ / 441-21™ / 441-22™ 441-29™ Reducer	2

Accelerator

- In cool temperatures or to decrease tape time, add 15-30 mL of Ful-Thane® 483-18™ Accelerator per RTS litre.

POT LIFE

4 hours at 20°C



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 an Axalta Coating Systems approved silicone and wax remover 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

14-16 seconds FORD #4 Cup @20°C

SPRAY PRESSURE

Conventional

Siphon Feed:	2.8-4.8 bar at the gun
Pressure Feed:	2.8-4.8 bar at the gun (fluid flow 240-350 mL/minute)
HVLP	0.55-0.7 bar 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 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.

CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible with Duxone® Gun Wash Solvent.



DRY TIMES

AIR DRY

Dust free:	30 minutes
Tack Free:	45-60 minutes
Hard:	Overnight

FORCE DRY

30 minutes at 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 P1200 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):	552 g/L
Max. VOC (AP):	540 g/L
Avg. SG:	0.97 g/mL
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:	6.8 m ² /L at 50 µm
Recommended Dry Film Thickness:	50 µm
Flash Point:	See SDS

CHEMICAL RESISTANCE

1 Hour Chemical Resistance (After air drying 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 (After air drying 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 air drying for 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.