

# Inter-Thane™ 2K Urethane



## GENERAL

### DESCRIPTION

Inter-Thane™ 2K Urethane is a two-component urethane topcoat. It provides a fast, easy to spray, single-stage urethane finish. Inter-Thane™ 2K Urethane offers outstanding durability, and chemical resistance. Gloss adjustment is possible by mixing gloss and matt binders in the required ratio – refer Table 1.

**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  
 Inter-Thane® HS 435-01™ 2K Urethane Gloss Binder  
 Inter-Thane® HS 435-02™ 2K Urethane Matt Binder  
 Ful-Thane® 2K Urethane 483-15™ 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
Inter-Thane® 2K Urethane	8
Ful-Thane® 2K Urethane 483-15™ Catalyst	1
Ful-Base® 441-xx™ Reducer	2

To decrease tape time by 50%, use 15-30 mL of 483-18 Ful-Thane™ Accelerator per RTS litre of Inter-Thane™ colour

### SPRAY VISCOSITY

14-16 seconds in a FORD #4 Cup @20°C



## APPLICATION

### SURFACE PREPARATION

- Before sanding, remove all traces of wax grease and oil with an Axalta Coating Systems approved silicone and wax remover using clean rags.

**Note:** Do not use cleaning solvents to clean porous surfaces such as wood or MDF.

### COMPATIBLE PRODUCTS

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

### SPRAY PRESSURE

Siphon Gun	2-4 bar at the gun
Gravity Feed	3-4 bar at the gun
Pressure Pot	2-4 bar at the gun
HVLP	0.7 bar at the cap

**GUN SETUP**

**Conventional**

Suction Feed: 1.6 mm - 1.8 mm  
 Gravity Feed: 1.4 mm - 1.6 mm  
 Pressure Pot: 0.8 mm - 1.2 mm

**HVLP**

Suction Feed: 1.5 mm - 1.8 mm  
 Gravity Feed: 1.3 mm - 1.6 mm

**APPLICATION**

**Solid Colors**

Apply 1 medium wet coat. Allow to tack. Apply 1 full wet coat.

**Metallic Colors**

Apply 1 medium wet coat. Flash 5-10 minutes. Apply 1 medium coat to even out the metallic. A very light third coat may be applied, if need for metallic control.

**Tip for success**

Do not apply if below 10°C or above 45°C

**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 after a flash time of 15 minutes

**RECOATING**

Anytime, after properly dried.

**POLISHING**

- Allow overnight dry. Remove dust with soft dampened cloth. Use fine compound with soft polishing pad.
- Solid colours: Lightly sand with P1200 grit (or finer) sandpaper.
- Metallic colours: Lightly “nib” sand small imperfections only.
- Operate machine at 1700 - 2000 RPM.

Note: Do not polish matt/semi-matt finishes.



**PHYSICAL PROPERTIES**

	<b>435-01 Gloss</b>	<b>435-02 Matt</b>
VOC:	560 g/L	589g/L
Specific Gravity:	0.97 g/mL	0.99 g/L
Weight Solids:	42.5%	40.3%
Volume Solids:	35.4%	32.4%
Flash Point:	8°C	12°C
Recommended Dry Film Thickness:	45-55 µm	
Theoretical Coverage (average):	6.8 m <sup>2</sup> /L at 50 µm	
Pot life:	4 hours @20°C	

**CHEMICAL RESISTANCE\***

- **1 hour (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 (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
  - IPA: Slight Dulling
- **Resistant to the following household chemicals:**  
Windex, Dishwashing Detergent, Hand Lotion, Salt Solution, Cooking Oil  
Tea, Coffee, Tomato Sauce

**RECOMMENDED BINDER RATIOS:**

435-01™ Inter-Thane™ 2K Urethane Gloss and 435-02™ Inter-Thane™ 2K Urethane Matt Binders may be mixed in any ratio in order to achieve the required gloss level. Please refer to the Table 1, below:

**TABLE 1:**

Gloss @60°	Recommended Binder Ratio 435-01 Gloss : 435-02 Matt		
Required Gloss Level	White	Pastel Colours	Other Colours
>95 %	100 : 0	100 : 0	100 : 0
90–95 %	80 : 20	80 : 20	80 : 20
80–90 %	65 : 35	65 : 35	55 : 45
60–80 %	55 : 45	55 : 45	40 : 60
40–60 %	50 : 50	50 : 50	30 : 70
20–40 %	40 : 60	40 : 60	20 : 80
10–20 %	30 : 70	25 : 75	10 : 90
5–10%	20 : 80	15 : 85	5 : 95
<5 %	0 : 100	0 : 100	0 : 100

**Note:**The above recommendations are indicative only. Actual gloss levels may depend on various factors, such as topcoat colour, catalyst / reducer used, spraying technique, ambient conditions during application and drying of the coating etc.

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## 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.

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## 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 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.