

Ful-Base® Enamel (IC Quality)



GENERAL

DESCRIPTION

A 600 g/L VOC compliant, solventborne single-stage topcoat that is easy to apply and provides a wide range of colors.

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



MIXING

COMPONENTS

Ful-Base® 430-XX Tint
 Ful-Base® 435-90™ Enamel Binder
 Kwik-Kure 483-08™ Activator
 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-Base® Enamel (IC Quality)	8
Kwik-Kure™ 483-08™ Hardener	1
Ful-Base® 441-20™ / 441-21™ / 441-22™ / 441-29™ Reducer	2

Ful-Base® Enamel must be activated with Kwik-Kure™ 483-08™ Activator.

POT LIFE

4 hours at 20°C

SPRAY VISCOSITY

15-17 seconds in a FORD #4 Cup @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 treat large bare metal areas.

COMPATIBLE PRODUCTS

All Nason® primers, primer-surfacers and sealers.

SPRAY PRESSURE

Conventional

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

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.

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.

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.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	600 g/L
Max. VOC (AP):	488 g/L
Avg. SG:	0.95 g/mL
Avg. Wt.% Volatiles:	64.4%
Avg. Wt.% Exempt Solvent:	1.7%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	2.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	8.0 m ² /L at 50 µm
Recommended Dry Film Thickness:	50 µm
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 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.