

Nason® FulThane® 2K

Topcoat (IB quality)

Type

Two-component, 5.0 VOC, urethane topcoat.

Description

An easy-to-use topcoat that delivers good color retention, gloss and chemical resistance.

Compatibility With Other Coatings

Compatible with all DuPont OEM / Commercial Finishes primers

System Components

Nason® FulThane® 400-XX™ Fac/pac Colors
Nason® FulBase® 430-XX™ Tints
Nason® 435-91™ Binder
Nason® 483-15™ Activator
Nason® FulBase® 441-20™ Fast Reducer (50 – 65°F)
Nason® FulBase® 441-21™ Medium Reducer (65 – 85°F)
Nason® FulBase® 441-22™ Slow Reducer (85°F+)

Physical Properties

Direct Impact 40 inch/lb

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

3 hour chemical resistance (Air dried for 12 days):

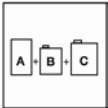
- 10% Ammonium Hydroxide No Spot
- 10% Sodium Hydroxide No Spot
- 10% Phosphoric Acid No Spot
- 10% Hydrochloric Acid No Spot

Solvent Resistance (100 Double Rubs after 8 days):

- MEK Slight to Moderate Dulling
- Xylene Slight Dulling

Mix Ratio

Combine components and mix thoroughly.



Three Component System

Parts by Volume

Nason® FulThane® 2K Topcoat (IB quality)
Nason® 483-15™ Activator
Nason™ FulBase® Reducer

8
1
2

Add 2-4 oz. of Nason® 483-18 Accelerator to activated gallon to decrease tape time by 50%.

Initial application viscosity: 14-16 seconds with #4 Ford Cup or 19-21 seconds with #3 Zahn Cup, depending on color.

Pot Life

4 hrs at 70°F



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Surface Preparation

Prior to sanding, remove all traces of wax, grease and oil with Nason® 441-05™ Silicone and Wax Remover using clean rags only. In regulated areas, use only permitted silicone and wax remover. Sand old finish and chemically treat bare metal areas.

Additional Comments

Do not apply Nason® FulThane® below 50°F. Refer to local VOC product charts or rules for proper use of all products.

Application

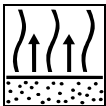
Solid colors: spray medium-wet coat. Allow to tack. Follow with a full wet coat.

Metallic colors: Apply two medium-wet coats with 5-10 min flash time between coats. A third and final "mist coat" may be applied to even the metallic if necessary.



Gun Setup

- 40 – 70 PSI
- HVLP: 8 – 10 psi
- Pressure Pot: 40 – 70 psi at the gun, 8-12 psi on the pot.



Dry Time

Out of Dust:	30 min
Tack Free:	45-60 hrs
Hard Dry:	Overnight
Recoating:	Any time once dry

Topcoat can be force dried at 20 – 30 minutes at 120 – 140°F.

Polishing

Allow to dry overnight. Remove dust with soft dampened cloth. Use fine compound with soft polishing pad. Operate machine at 1700 – 2000 rpm.

Solid Color: Lightly sand with 1200 grit or finer
Metallic Colors: Lightly "nib" sand small imperfections only

Suggested Dry Film Thickness

1.8 – 2.2 mils DFT

Flash Point (Closed Cup)

Below 80°F (27°C)



Cleanup Solvents

Clean immediately with Nason® 481-06™ or 481-16 Thinners. Always refer to appropriate Air Quality District requirements for proper use of cleaning equipment and Nason® products.

Environmental

5.0 lbs/gal ready-to-spray maximum

For VOC Regulated Areas

These directions refer to the use of products that may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

Safety And Handling

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling and using. These products are for industrial use by trained professional painters only.

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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