

Ful-Thane® HS Urethane (IG Quality)



GENERAL

DESCRIPTION

A 600 g/L, VOC compliant, urethane single-stage topcoat that is easy to use and delivers very good appearance, high performance and 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® HS 435-95™ Urethane Binder
 Ful-Thane® 483-52™ Activator
 Ful-Thane® 483-54™ Accelerator (Required)

MIX RATIO

Combine the components by volume (3:1). Mix thoroughly prior to activation.

Component	Volume
Ful-Thane® HS Urethane (IG Quality)	3
Ful-Thane® 483-52™ Activator	1
Ful-Thane® 483-54™ Accelerator	30 ml per litre

POT LIFE

1-2 hours at 20°C

SPRAY VISCOSITY

23-26 seconds in a Zahn #2



APPLICATION

SURFACE PREPARATION

- Before sanding, wash with soap and water and remove wax and grease with an Axalta Coating Systems approved wax and grease remover using clean rags.
- Sand finishes according to primer or substrate recommendations and chemically treat large bare metal areas.

COMPATIBLE PRODUCTS

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

SPRAY PRESSURE

Siphon Gun	4.1-5.5 bar at the gun
Pressure Pot	4.1-5.5 bar at the gun
Fluid Delivery	300-350 mL per minute
HVLP	0.55-0.7 bar at the cap

GUN SETUP

Pressure pot recommended

APPLICATION

Solid Colors

Apply 1 medium wet coat. Allow to tack. Apply 1 full wet coat. Flash 10-20 minutes between coats.

Metallic Colors

Apply 1 medium wet coat. Flash 10-20 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

Tack free:	2-4 hours
Hard:	Overnight
Tape Free:	Overnight or when hard

FORCE DRY

30 minutes at 60°C after a flash time of 15 minutes

Proper accelerator use is required for these dry times.

RECOATING

Anytime



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	420 g/L
Max. VOC (AP):	420 g/L
Avg. SG:	1.03 g/mL
Avg. Wt.% Volatiles:	41.2%
Avg. Wt.% Exempt Solvent:	0.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	0.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	9.4 m ² at 50 µm
Recommended Dry Film Thickness:	50 µm
Flash Point:	See SDS

PROPERTIES*

Appearance:	Excellent
Adhesion:	Excellent
MEK Rubs:	100+
Direct Impact:	80+ inch/lb.
Chip:	Very Good
Humidity:	Excellent
Salt Spray:	Excellent

CHEMICAL RESISTANCE*

5% Sodium Hydroxide:	No Effect
10% Sulfuric Acid:	No Effect
MEK:	No Effect
Gasoline:	No Effect
Toluene/Naphtha:	No Effect

*Using Ful-Poxy® epoxy primer

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.