Ful-Base® Enamel Topcoat (IC Quality)

GENERAL

DESCRIPTION
A 5.0 lb./gal (600 g/l) VOC compliant, solvent-borne 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® Enamel topcoat (IC Quality)
Ful-Base® 430-XX Tint
Ful-Base® 435-90™ Enamel Binder
Kwik-Kure 483-08™ Activator
Ful-Base® 441-20™ Reducer (Low-Temp)
Ful-Base® 441-21™ Reducer (Mid-Temp)
Ful-Base® 441-22™ Reducer (High-Temp)

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

Component	Volume
Ful-Base® Enamel topcoat (IC Quality)	8
Kwik-Kure™ 483-08™ Hardener	1
Ful-Base® 441-20™ / 441-21™ / 441-22™ Reducer	2

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

POT LIFE
4 hours at 70°F (21°C)

SPRAY VISCOSITY
20-21 seconds in a Zahn #2

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 Nason® 441-05™ Silicone and Wax Remover or 481-75™ Surface Cleaner (use locally permitted cleaner in regulated areas) 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:	40-70 PSI at the gun
Pressure Feed:	40-70 PSI at the gun 8-12 PSI Fluid Flow on the pot
HVLP:	8-10 PSI 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.

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 lacquer thinner or low VOC cleaner in VOC regulated markets.

DRY TIMES

AIR DRY

Out of dust:	30 minutes
Tack Free:	45-60 minutes
Hard:	Overnight

FORCE DRY

20-30 minutes at 120-140°F (49-60°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):	5.0 lbs./gal (600 g/L)
Max. VOC (AP):	4.9 lbs./gal (593 g/L)
Avg. Gal. Wt.:	7.89 lbs./gal (946 g/L)
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:	464 ft^2 (43.1 m^2) at 1 Mil
Recommended Dry Film Thickness:	2.0 mil
Flash Point:	See SDS/MSDS

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.

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In the United States:
1.855.6.AXALTA
nasonfinishes.com

In Canada:
1.800.668.6945
nasonfinishes.ca