

# FleetThane™ HS Urethane Topcoat (II Quality)



## GENERAL

### DESCRIPTION

A 5.0 lb/gal (600 g/l) VOC compliant, acrylic urethane single-stage topcoat that is easy-to-apply and provides excellent appearance, protection 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

- FleetThane™ HS Urethane Topcoat (II Quality)
- Ful-Base® 430-XX Tints
- FleetThane™ 435-98™ HS Urethane Binder
- FleetThane™ 483-52™ HS Activator
- FleetThane™ 483-54™ Accelerator

### MIX RATIO

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

Component	Volume
FleetThane™ HS Urethane Topcoat (II Quality)	3
FleetThane™ 483-52™ HS Activator	1
FleetThane™ 483-54™ Accelerator	4 oz. (120 ml) per gallon

### POT LIFE:

1-2 hours at 70°F (21°C)

### VISCOSITY

23-26 seconds in a Zahn #2



## APPLICATION

### 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 treats large bare metal areas.

### COMPATIBLE PRODUCTS

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

### SPRAY PRESSURE

Siphon Gun:	60-80 PSI
Pressure Pot:	60-80 PSI at the gun
Fluid Delivery:	10-12 oz. per minute
HVLP:	8-10 PSI 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 second coat evening the metallic as you go. A very light third coat may be applied if need for metallic control.

**Tips for success**

Do not apply if below 50°F (10°C) or above 110°F (43°C).

**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**

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

**FORCE DRY**

20-30 minutes at 120-140°F (49-60°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):	3.9 lbs./gal (467 g/L)
Max. VOC (AP):	3.9 lbs./gal (467 g/L)
Avg. Gal. Wt.:	8.56 lbs./gal (1026 g/L)
Avg. Wt.% Volatiles:	41.7%
Avg. Wt.% Exempt Solvent:	0.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	0.0%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	815 ft <sup>2</sup> (70.6 m <sup>2</sup> ) at 1 mil
Recommended Dry Film Thickness:	2.0 mils
Flash Point:	see SDS/MSDS

**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

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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/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.

**Revised: August 2015**

In the United States:  
**1.855.6.AXALTA**  
**nasonfinishes.com**

In Canada:  
**1.800.668.6945**  
**nasonfinishes.ca**

