



## SURFACE PREPARATION

The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat. For abrasive blasting, blast to white metal SSP#10, with a blast profile not exceeding 25% of total DFT.

Metal	Direct To Properly Treated Substrate
Cold Rolled Steel	Excellent
Hot Rolled Steel	Excellent
Galvanized	Fair-Good
Galvaneal	Fair-Good
Aluminum	Good
Plastic/Fiberglass	Surface should be free of all contamination. Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic/fiberglass substrate being used.

## APPLICATION DATA

### MIXING DIRECTIONS

Mix 1 part component A (HBE-400 / HBE-402) to 1 part component B (HBE-401 / HBE-403); Refer to the "HBE-series mixing guide" for the resultant color mixtures. Mix thoroughly before and occasionally during use. Apply material in one wet coat overlapping each pass 50%.

### THINNING

Up to 10% with MEK

### POT LIFE

8 Hours after mixing 77°F (25°C)

### RECOMMENDED WET FILM BUILD

3.8 – 7.5 mils

### RECOMMENDED DRY FILM BUILD

1.5 – 3.0 mils

\*\*Film in excess or below these recommended film builds may cause problems such as adhesion failure, solvent popping and slow cure.\*\*

### APPLICATION EQUIPMENT

Conventional Spray: 45 - 60 psi at the gun.

Airless: Pressure 1400-2000 psi, tip: 0.013" – 0.017"

AA Airless: Pressure 850 psi, tip: 0.011" – 0.015"

Brush: Polyester or nylon Roll

Roll : Short nap

### DRYING TIME

5 mils wet at 77°F (25°C) and 50% relative humidity.

To Touch: 45 minutes

To Handle: 3 hours

To Sand 16 hours

Dry to topcoat: 1 hour

Recoat: after 30 minutes and before 7 days

Force Dry: allow a 10 minute flash then 30 minutes @ 160°F (70°C)

Drying time listed may vary, depending upon film build, temperature, humidity and degree of air movement

Application of film thickness in excess of that recommended for this product will substantially extend dry time.

### RECOMMENDED SPREADING RATE

632 sq. ft. at 1.0 mil dry film per U.S. gallon. Coverage figures do not include losses due to mixing, transfer or application of coating nor losses due to surface irregularities or porosity

### CLEAN UP

MEK, Acetone or Lacquer thinner.

### APPLICATION PRECAUTIONS AND LIMITATIONS

Not recommended for Immersion service. Apply only when air, product or surface temperature is above 50°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point. Apply in dry weather when relative humidity is less than 85%.

Brush (use polyester/nylon brush) and roller (use solvent resistant core) application is recommended.

To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your Light Industrial Distributor for the most up-to-date information

## SAFETY

These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

### PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

### MEDICAL RESPONSE

Emergency Medical or Spill Control Information (304) 843-1300. CANADA (514) 645 - 1320 Have label information available.

### MATERIAL SAFETY DATA SHEET

Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Light Industrial Distributor.

FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.

**PPG Industries**  
Commercial Coatings

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