



Commercial Performance Coatings

HBA-4035

CPC 56

High Build Alkyd Primer - Gray

PRODUCT DESCRIPTION

HBA-4035 **HIGH BUILD ALKYD PRIMER**

TYPE: Alkyd

RECOMMENDED USE

HBA - 4035 is a 3.5 VOC fast drying, chrome free alkyd primer. This primer exhibits good filling and corrosion resistance properties when applied over properly prepared steel and aluminum substrates. A wide variety of LIC topcoats may be applied over HBA – 4035.

COLOR: Gray

PHYSICAL CONSTANTS

WEIGHT PER U.S. GALLON:

11.6 - 11.9 LBS/GAL

PERCENT SOLIDS BY WEIGHT:

70.0% - 72.0%

PERCENT SOLIDS BY VOLUME:

50.0% - 52.0%

FLASH POINT

HBA-4035 Pensky-Martens 63°F (17°C)

VOC

3.5 lbs/gal

READY TO SPRAY VISCOSITY (varies by color) #3 Zahn 10-25 seconds #2 Zahn N/A

PERFORMANCE FEATURES

96 HOUR HUMIDITY RESISTANCE

Excellent

ADHESION

Excellent

IN SERVICE TEMPERATURE LIMITATIONS

200°F

CHEMICAL/SOLVENT RESISTANCE

10% SULFURIC ACID	Excellent	10%HYDROCHLORIC ACID	Excellent
10%AMMONIA	Excellent	10%SODIUM HYDROXIDE	Excellent
XYLENE	Fair	ISOPROPYL ALCOHOL	Excellent
OIL	Excellent	GASOLINE	Good
500 HOURS SALT SPRAY	VERY GOOD		

WATER RESISTANCE: Resistant to intermittent exposure. **Not recommended for immersion**



SURFACE PREPARATION

The surface to be coated must be 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 total coating system.

Metal	Recommended Topcoat	Direct To Properly Treated Substrate
Cold Rolled Steel	ALK-200, ALK-200/201, ALK-300E, ALK-300ELG, AUE-100, AUE-300	Very Good
Hot Rolled Steel	ALK-200, ALK-200/201, ALK-300E, ALK-300ELG, AUE-100, AUE-300	Very Good
Galvanized		Not Recommended
Galvaneal		Not Recommended
Aluminum	ALK-200, ALK-200/201, ALK-300E, ALK-300ELG, AUE-100, AUE-300	Fair
Plastic/Fiberglass	The 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

Stir thoroughly before and occasionally during use.

THINNING

Not recommended where 3.5 lb./gal. VOC compliance is required.

POT LIFE

N/A

RECOMMENDED WET FILM BUILD (1 Coat)

Spray Application: 3.6- 4.8 mils

RECOMMENDED DRY FILM BUILD (1 Coat)

1.8 - 2.4 mils

Note: Application of film thickness in excess or below those recommended for this product will substantially extend dry time and may cause problems such as, adhesion failure and solvent popping.

APPLICATION EQUIPMENT

Conventional Spray: 50-60 psi at the gun

DRYING TIME

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

To Touch:	10 minutes
To Handle:	60 minutes
Dry:	24 hours
To Topcoat:	After 1 hour to 4 days
Recoat:	Before 1 or after 36 hours to 4 days

Note: After 4 days primer should be mechanically abraded before topcoating or recoating.

Force Dry:	Allow 10 minutes air dry
Bake:	20 minutes @ 160°F

Note: Paint film is not fully cured for 7 days
Drying time listed may vary, depending upon film build, and temperature.

RECOMMENDED SPREADING RATE

802-834 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 or losses due to surface irregularities or porosity.

CLEAN UP

Ketone or Lacquer Thinner

APPLICATION PRECAUTIONS AND LIMITATIONS

Apply only when air, product or surface temperature is above 60°F (16°C) and when surface temperature is at least 5°F (3°C) above the dew point.

Brush and roller application is not 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 PPG 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 Distributor.

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

PPG Industries
Commercial Coatings

We're Everywhere You Look