

Technical Data Sheet

Hydroflex® Super Hi Build is a ready to spray Waterborne Acrylic Urethane primer surfacer designed for professional refinishing of both thermoset and thermoplastic substrates. This product has superior fill and build properties and provides outstanding adhesion and topcoat holdout. Specifically designed for use by the Bumper Recycler Industry, this low odor, easy-to-apply formula can be topcoated with most basecoat/clearcoat products (water and solvent) and Single Stage (enamels, urethane and polyurethane). Follow paint company topcoat recommendations when using this product. Hydroflex Super High Build covers in 1 - 3 coats, sands easily wet or dry in 1 - 2 hours without featheredge tearing.

SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Bare Steel		Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching	
Bare Galvanized		Raw Plastic - Flexible (ABD, PPO) +	✓	Primer - 1K	
Bare Aluminum		Raw Plastic - Soft (PUR) +	✓	Primer - 2K	
OEM E-Coat**		Plastic Part - Primed ++	✓	OEM Finish & Old Paint Work - Reversible	
Fiberglass/SMC Gel Coat	✓	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible	

** Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

MIXING



By Volume: Ready to Spray
 Optional: Reduce up to 10% with Waterborne Thinner 50-0081.
 Pot Life Unreduced: unlimited in a sealed container

FLASH TIMES/DRY TIMES



Flash time Between Coats: 10-15 minutes
 To sand:
 Relative Humidity *60°F, (15°C) 70°F, (20°C) 85°F, (30°C) 140°F, (60°C)(force dry)
 50% 3.5 hours 2.5 hours 2.0 hours 30 min.
 75% 4.0 hours 3.0 hours 2.5 hours 45 min.

* DO NOT apply below 60°F. Recoat without sanding for up to 8 hours air dry, must be sanded after baking.

SURFACE PREPARATION



Clean with Aqua SCAT 2 1391/1394. Depending on surface, apply Plasto- Mend TPO Adhesion Promoter 1021.
 * For more information on surface prep and application refer to next page.

SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Conventional
Fluid Tip	1.7 - 2.0	1.4 - 1.8
Air Pressure	10 PSI @ aircap	35 - 50 PSI @ gun
Mil Thickness:	1.5-2.0 mils per coat (dry film thickness)	

LIMITATIONS & PRECAUTIONS

- Hydroflex® is temperature sensitive. DO NOT FREEZE. Product must be stored above 41°F (5°C). Do not apply material when temperature is below 60°F (15°C). Exposure to excessively cold temperatures may cause material to thicken.
- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

Visit www.tat-co.com to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

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SURFACE PREPARATION

Cleaning: Clean with Aqua SCAT 2 1391/1394 and wipe dry with lint free cloth.

Sanding: DA (Dry) #220, finish #400; Hand (Wet) #400, finish #600. When sanded wet, wipe sanded primer dry and allow 30 minutes at 70°F (20°C) dry time before topcoat application. Use of infra-red lights will reduce dry times.

For TPO Plastic (PE & PP) Use Plasto-Mend TPO Adhesion Promoter 1021: Apply a thin even coat of Plasto-Mend TPO Adhesion Promoter 1021 to surface to be primed. Allow 20 minutes flash time for material to prepare the surface. DO NOT shortcut this step. Failure to wait the required time may prevent full primer adhesion.

TINTING & ADDITIVES

Tinting: Not recommended.

Additives: Fisheye Remover (6737) - Do not use.
Kicker (6417) - Do not use.

Universal Urethane Flex Additive (9194) - Do not use.

APPLICATION & FILM BUILD

Stir Hydroflex® Super Hi Build thoroughly before using. No reduction needed, but if desired, reduce up to 10% with Waterborne Thinner 50-0081. Spray 1 - 3 medium wet coats. Flash about 5 minutes between coats. Let air dry according to time/temperature chart on page one before sanding. Force dry 30-45 minutes @ 140°F (60°C) or 5 - 10 minutes under infrared lights before sanding.

Film Build: 1.5-2.0 mils per coat (dry film thickness)

PRODUCT SPECIFICATIONS

Color: Satin Black	Shelf Life: 3 years
RTS Solids by Weight: 50%	Weight per gallon: 11.01 #/gal
Size: Gallon (1221), 5 Gallon (1225)	Approximate Coverage: 570 ft ² /gal @ 1 mil

REGULATORY

Category: Primer			
VOC Actual	0.57#/gal (69 g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	1.37#/gal (164 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	49.14	Density of Material #/gal	10.98
Weight % of Water	43.90		