

PRODUCT HIGHLIGHTS

1215

Hydroflex® Plus Waterborne Primer Special Gray

DESCRIPTION:

Hydroflex® Plus 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 Plus covers in 1 - 3 coats, sands easily wet or dry in 1 - 2 hours without featheredge tearing.

PRODUCTS:

1215 Hydroflex® Plus Waterborne Primer (Special Gray), 5 Gallon (18.90 L), 1/case



SURFACE PREP:

Clean with Aqua SCAT 2 1391/1394. Depending on surface, apply Bond-Tec® Plasto-Mend TPO Adhesion Promoter 1021/1023-F.



MIX RATIO:

Ready to Spray



REDUCER:

Not required



HVLP/LVLP:

1.8 - 2.0 mm
 1 - 3 medium wet coats



5 minute flash
 1.5-2.0 mil film build

Please refer to gun manufacturer for proper spray pressure recommendations



DRY TO SAND TIMES:

Relative Humidity	*60°F, (15°C)	70°F, (20°C)	85°F, (30°C)	140°F, (60°C)(force dry)
50%	2.5 hours	1.5 hours	1.0 hours	30 min.
75%	3.0 hours	2.5 hours	2.0 hours	30 min.

* DO NOT apply below 60°F

Recoat without sanding for up to 8 hours air, must be sanded after baking.



SANDING:

DA (Dry) #220, finish #400 Hand (Wet) #400, finish #600

See next page for more detailed product application. See website for this document in other languages.
 Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
 Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

1215

Hydroflex® Plus Waterborne Primer Special Gray



SUITABLE SUBSTRATES:

Hydroflex® Plus can be applied on any existing plastic body part used on the outside of a vehicle such as grills, bumpers, spoilers and body panels. Hydroflex® Plus will adhere to the following unpainted surfaces:

Hard Plastics:

SMC sheet moulding compound
BMC bulk moulding compound
GFK fiber glass laminate (unless gelcoat is broken)
PC polycarbonate
PVC polyvinylchloride/polypropylene

Soft Plastics:

PUR Polyurethane

Flexible Plastics:

PP/EPDM	ethylene propylene diene modified	HP-Alloy	Honda polymer alloy
PP/EPM	ethylene propylene modified	PUR	polyurethane
ABS	acrylonitrile butadiene styrene	P.D.T.	polybutylene terephthalate (pocan)
PPO	polyphenylene oxide polymer	PA	polyamide

SURFACE PREPARATION:

1. Wearing protective gloves, apply Aqua SCAT 2 1391/1394 full strength to surface to be primed using a general purpose scuff pad to remove road film and dirt.
2. Allow surface to remain wet for two minutes.
3. Rinse thoroughly with water, then dry with a clean, lint free towel.

For TPO Plastic (PE & PP) Use Plasto-Mend TPO Adhesion Promoter 1021/1023-F:

1. Apply a thin even coat to surface to be primed.
2. Allow 20 minutes flash time for material to prepare the surface. DO NOT shortcut this step.
3. Failure to wait the required time may prevent full primer adhesion.

APPLICATION & MIXING:

1. Stir Hydroflex® Plus thoroughly before using. Reduce up to 10% with distilled water. Do not shake.
2. Spray 1 - 3 medium wet coats.
3. Flash about 5 minutes between coats*.
4. Let air dry according to time/temperature chart on first page before sanding.
5. Force dry 40 minutes @ 140°F or 5 - 10 minutes under infrared lights before sanding.

*Note: Allow longer flash times under high humidity conditions.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.6 - 1.8 mm	40 - 55 PSI (at gun)	n/a
Gravity Feed	1.6 - 1.8 mm	40 - 45 PSI (at gun)	n/a
Pressure Feed	1.1 - 1.6 mm	40 - 50 PSI (at gun)	10 - 14 PSI
HVLP/LVLP	1.8 - 2.0 mm	10 PSI max. (at aircap)	n/a

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Hydroflex[®] Plus Waterborne Primer Special Gray

TECHNICAL DATA:

WEIGHT PER GALLON:	10.7 #/gallon
% SOLIDS:	51% by weight, 33% by volume
SHELF LIFE:	One Year
REDUCERS:	Not required - Ready to Spray
APPEARANCE:	Medium/Dark Gary
FILM BUILD:	1.5 - 2.0 mils per coat dry film thickness
SANDING:	Dry: Presand with #220, finish with #400 Wet: Presand with #400, finish with #600
COVERAGE:	520 ft ² /gal @ 1 mil.

REGULATORY:

Category: Primer	Individual Component
VOC Actual	0.51 #/gal (61 g/l)
VOC Regulatory	1.16#/gal (139 g/l)
Weight % of Volatiles	48.3
Weight % of Water	43.4
Weight % of Exempt Compounds	0
Volume % of Exempt Compounds	0
Density of Material (#/gal)	10.7

TECHNICAL TIPS:

TEMPERATURE SENSITIVE - DO NOT FREEZE!

PERFORMANCE ADDITIVES

6417 Kicker – Do not use.

6737 Fisheye Remover – Do not use.

9194 Universal Urethane Flex Additive – Do not use.

ADVANTAGES:

- Excellent fill & build - uses less material for bigger material savings
- Improved Sag Resistance - more build per coat means less coats to fill imperfections and less sanding
- Uses Fewer Coats - saves money, increases productivity
- Higher Solids - less material required to achieve desired film build

COMPETITION:

Sherwin Williams AquaFill W7A2266