

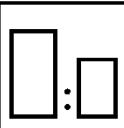



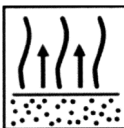
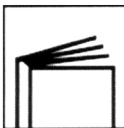


**Description**

HB Series solvent borne basecoat provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. HB Series must be used in conjunction with a HB AUTOCLEAR clearcoat in order to provide protection from the environment.

	<p><b>Safety Considerations</b> Use suitable personal protection. HydraBond products recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.</p>	
	<p>Agitate by shaking HB Series base-coat prior to use.</p>	
	<p>100 50-80</p>	<p>HB SERIES BASE-COAT HB SERIES Reducer  Stir color thoroughly prior to adding HB SERIES reducer</p>
	<p>Use hb series Base-Coat measuring stick #1 (black)</p>	
	<p><b>HVLP or Compliant Spray-Gun Set-Up:</b>  1.3-1.5 mm</p>	<p><b>Application Air Pressure:</b>  Consult spray gun manufacturers' specifications. HVLP – 10 psi at the air cap maximum.</p>
	<p><b>Application-Metallic Colors</b> 3 x 1 Coats</p>	<p><b>Application – Solid Colors</b> 2-3 x 1 coats</p>
	<p><b>Flash Between Coats at 70°F (20°C)</b>  3-5 minutes</p>	<p><b>Flash Before Force Drying at 75°F (24°C)</b>  Not Recommended</p>
	<p><b>Re-Coatable With:</b></p> <ul style="list-style-type: none"> <li>• HB SERIES Clearcoats</li> </ul>	

Read complete TDS/SDS for detailed product information.



UNIVERSAL BASE-COAT

FOR PROFESSIONAL USE ONLY

Description

HB SERIES solvent borne basecoat provides excellent coverage, good control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. HB series must be used in conjunction with a HB AUTOCLEAR clearcoat in order to provide protection from the environment.

Suitable Substrates

SUITABLE SURFACES

- All existing OEM finishes
- HydraBOND preparatory products

CANNOT BE APPLIED OVER

- Acid containing wash primers
- Airbag covers
- Thermoplastic acrylic laquers
- AutoPrep Pretreatment wipes

Products and Additives COMPATIBLE WITH HB UNIVERSAL BASE-COAT

BASE-COATS BINDERS

HB SERIES BASE COAT & BINDER ITEM# HB6612

HB SERIES AUTOCLEAR CLEARCOAT, 2.1 VOC AUTOMOTIVE CLEARCOAT

HB SERIES AUTOCLEAR CLEARCOAT, F-STYLE CAN	ITEM# HBC21
HB SERIES AUTOCLEAR CLEARCOAT, ACTIVATOR CONE-TOP CAN, 32OZ. (.95L) FAST	ITEM# HBH065
HB SERIES AUTOCLEAR CLEARCOAT, ACTIVATOR CONE-TOP CAN, 32OZ. (.95L) MEDIUM	ITEM# HBH075
HB SERIES AUTOCLEAR CLEARCOAT, ACTIVATOR CONE-TOP CAN, 32OZ. (.95L) SLOW	ITEM# HBH085

24 SERIES  
ADITTIVES

MULTI-PURPOSE UNIVERSAL FISH-EYE ELIMINATOR	ITEM# HB6353
MULTI-PURPOSE UNIVERSAL ACCELERATOR	ITEM# HB6353

REDUCERS




HB High Performance Reducer Fast	Item #HBS065
-Spot and panel repairs, temperature range 60°F – 75°F (16°C – 24°C)	
HB High Performance Reducer Medium	Item #HBS075
-Spot and panel repairs and large areas temperature range 70°F – 85°F (20°C – 30°C)	
HB High Performance Reducer Slow	Item #HBS085
-Larger areas and complete jobs temperature range 80°F – 95°F (27°C – 35°C)	

\*Item numbers are provided for 1 gallon containers. Additional container sizes are available.



Basic Raw Materials

- Autobase Plus – Physically drying binders
- Sikkens High Performance Reducers – Special solvent blends
- Hardeners – Polyisocyanate resin

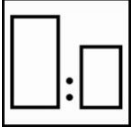
**Substrate Preparation**

	<p>Dry sanding</p> <ul style="list-style-type: none"> <li>o Initial sanding steps may be executed with a coarser sanding grit; for example, #P360 - #P400</li> <li>o Final sanding step #P500 to #P600</li> </ul> <p>Note: Respect a maximum 100 sanding grit step difference or less throughout the taken sanding steps.</p>
	<p>Wet sanding</p> <ul style="list-style-type: none"> <li>o Initial sanding steps may be executed with a coarser sanding grit #P500</li> <li>o Final sanding step #P600 to #P800</li> </ul> <p>Note: Respect a maximum 200 sanding grit step difference or less throughout the sanding steps.</p>
	<p>Surface Cleaning</p> <ul style="list-style-type: none"> <li>o SQ1S Solvent based pre-prep ZERO VOC CLEANERS</li> <li>o SQ1 Water based pre-prep cleaners</li> </ul>

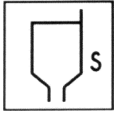
**Product Agitation**

	<p>HB UNIVERSAL BASE-COAT must be stirred on a mixing machine for 15 minutes prior to use or agitated for 10 minutes a shaker.</p>
	<p>HB UNIVERSAL BASE-COAT must be stirred thoroughly before and after reduction.</p>

**Autobase Plus Reduction**

	<p>Add SQ Reducer to all HB UNIVERSAL BASE-COAT prior to application using the following guidelines.</p> <ul style="list-style-type: none"> <li>• 50-80 parts reducer by volume</li> </ul>
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**Viscosity When Mixed**

	<p>DIN Cup #4 70°F (20°C)</p>	<p>100:50 ratio – 16-17 seconds 100:80 ratio – 13-14 seconds</p>
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**Pot-Life When Mixed**

Autobase Plus Mixed Colors	70°F (20°C)
HB UNIVERSAL BASE-COAT solid, metallic and pearl mixed colors	6 months
HB UNIVERSAL BASE-COAT 3 stage pearl colors	24 hours

**Spray Gun Set-Up**

	<p><b>Consult spray gun manufactures instructions for specific spray gun pressure specifications.</b></p>		
<p><b>HVLP Gravity</b> <b>Compliant Gravity</b></p>	<p>1.3-1.5 mm 1.2-1.4 mm</p>	<p>Max 10 psi at cap Per manufacturer</p>	

**Application Process**

	<p><b>Solid colors</b></p> <ul style="list-style-type: none"> <li>o Apply 2 single coats or until opacity is achieved.</li> <li>o Flash off 3-5 minutes between coats</li> </ul>
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**Metallic / pearl colors**

1. HB UNIVERSAL BASE-COAT Solid Foundation Color: Spray 2 single coats, allowing approximately 5-7 minutes flash-off between each coat. Over primed areas and areas where extra coverage is required, apply first a single thin coat. Allow the foundation coat to dry for 15–20 minutes.
2. HB UNIVERSAL BASE-COAT Mid Coat: Spray three to four thin coats, allowing 3–5 minutes flash-off between coats at 70°F (20°C). Do not lower the air pressure for pearl coats.
3. HB UNIVERSAL BASE-COAT Transparent Solid Color Mid Coat: Spray three to four even, wet coats, allowing 5-10 minutes flash-off between coats at 70°F (20°C).

Note: To meet National Rule VOC levels for three-stage colors. The addition of 10% Sikkens PC Hardener or Sikkens Autoclear HS+ 2 Pack Hardener must be added to the “foundation color.” Use the # 14 (Blue) measuring stick for this, stir this mixture and continue to add High Performance Reducer at a ratio of 100:50 or 100:80.

**Spot repairs**

- When making spot repairs apply thin coats until opacity is achieved. Dry until matt between each coat before fading out beyond the coverage coats.
- Metallic colors may need lower air pressure may be needed for color control. Extend each coat until coverage is obtained. Finally apply an orientation coats fading out beyond the coverage coats.

**Film Thickness – Using Suitable Application**

HB UNIVERSAL BASE-COAT solid, metallic and pearl colors: 0.3-0.4 mils

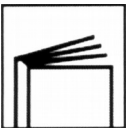
**Drying / Curing**

Drying times are stated a recommended application method, film thickness and object temperature.



Allow Autobase Plus to dry for 15 to 20 minutes at 70°F (20°C) before applying the clearcoat. The maximum time Autobase Plus may be left before clear:  
 –Autobase Plus Metallic Color: 2 days  
 –Autobase Plus Solid Color: 4 days

**Recoating**



**HB SERIES AUTOCLEAR CLEARCOAT, 2.1 VOC AUTOMOTIVE CLEARCOAT**

- |  |              |
|--|--------------|
| HB SERIES AUTOCLEAR CLEARCOAT, F-STYLE CAN                   | ITEM# HBC21  |
| HB SERIES AUTOCLEAR CLEARCOAT, ACTIVATOR CONE-TOP CAN FAST   | ITEM# HBH065 |
| HB SERIES AUTOCLEAR CLEARCOAT, ACTIVATOR CONE-TOP CAN MEDIUM | ITEM# HBH075 |
| HB SERIES AUTOCLEAR CLEARCOAT, ACTIVATOR CONE-TOP CAN SLOW   | ITEM# HBH085 |

**Two Tone Application**

HB UNIVERSAL BASE-COAT Solid, Metallic and Pearl colors can be taped off with fine line masking tape after 20 minutes flash-off at 70°F (20°C) and a second color of HB UNIVERSAL BASE-COAT can then be applied.

**Second Repair**

If during the application of HB UNIVERSAL BASE-COAT Solid or Metallic color, some damage occurs such as dust impregnation or perspiration spots, allow the HB UNIVERSAL BASE-COAT to flash off for 20 minutes at 70°F (20°C). Lightly sand the damaged area with #P600 to #P800 grit paper wet. As there is no clearcoat to protect the base coat at this stage, care must be taken to clean up all sanding residue.

**Cleaning of Equipment**

Clean and rinse the spray gun thoroughly after use.

**Theoretical Coverage**

Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.

- 143 m<sup>2</sup>/liter ready to spray at 1 mil dry Filmbuild and 100% transfer efficiency

**VOC / Regulatory Information**

Ready to spray VOC:

HB UNIVERSAL BASE-COAT 100:50 with High Performance Reducers: 6.28 lb/gal. 754 g/liter  
HB UNIVERSAL BASE-COAT 100:80 with High Performance Reducers: 6.44 lb/gal. 773 g/liter

Notice: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

**Product Storage**

Product shelf-life is determined when products are stored unopened at 70°F (20°C). Please reference the Sikkens Shelf Life TDS for the shelf life limits for each HB UNIVERSAL BASE-COAT