



Super Hi Build Hydroflex® Waterborne Primer 1221, 1225

Hydroflex® Super Hi Build is a ready to spray Waterborne Acrylic Urethane primer surfacer designed for refinishing of both thermoset and thermoplastic substrates. 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).



Mix Ratio

Ready to use. If desired, can be reduced up to 10% with a waterborne thinner. Pot life (unreduced): unlimited in a sealer container.



Suitable Substrates

- Raw plastic - rigid (SMC, BMC)
- Plastic part - primed
- Fiberglass/SMC gel coat
- Raw plastic - flex (ABD, PPO)
- Body filler
- Raw plastic - soft (PUR)

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

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



Surface Prep & Application

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.

Application: Stir Hydroflex® Super Hi Build thoroughly before using. No reduction needed, but if desired, reduce up to 10% with a waterborne thinner. Spray 1 - 3 medium wet coats. Film Build: 1.5-2.0 mils per coat (dry film thickness).

Tinting & Additives

Tinting	Not recommended.
Kicker (6737)	Do not use.
Fisheye Remover (6737)	Do not use.
Flex Additive (9194)	Do not use.

**Flash Times/Dry Times**

Flash time.....10 - 15 min between coats

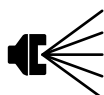
To sand

Relative Humidity	60°F (15°)*	70°F (20°C)	85°F (30°C)	140°F (60°C)
50%	3.5 hrs	2.5 hrs	2.0 hrs	30 min
75%	4.0 hrs	3.0 hrs	2.5 hrs	45 min

* DO NOT apply below 60°F (15°C). Recoat without sanding for up to 8 hours air dry, must be sanded after baking.

**Gun Set-up**

Conventional.....1.4 - 1.8 mm HVLP/LVLP 1.7 - 2.0 mm

**Air Pressure**

Conventional (@ gun)35 - 50 psi HVLP/LVLP (@ aircap)..... 10 psi

**Product Specifications**

Color.....Satin black	Size (1221).....Gallon
Shelf life.....3 years	(1225).....5 Gallon
Approx. coverage.....570 ft ² /gal @ 1 mil	RTS solids by weight.....50%Weight
per gallon.....11.01 #/gal	

Regulatory

Category.....Primer	Wt % of volatiles.....49.14
VOC actual.....0.57#/gal (69 g/l)	Wt % of water43.90
VOC regulatory.....1.37#/gal (164 g/l)	Wt % of exempt compound0
Density.....10.98 #/gal	Vol % of exempt compound0

**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.
- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.