

Hydroflex® Waterborne Primer

1235

Hydroflex® is a flexible, low V.O.C. primer-surfacer, designed for professional refinishing of thermoplastic and thermoset substrates. It provides excellent hold-out and adhesion. Hydroflex® provides fast filling characteristics, and sands easily without clogging. Hydroflex® can be directly topcoated with alkyd enamels, acrylic enamels, lacquer and urethane enamel systems (Basecoat/Clearcoat).



Mix Ratio

Ready to use. If desired, can be reduced up to 1 oz per quart 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® thoroughly before using. No reduction is necessary, but if desired, a small amount of waterborne thinner can be added at a rate of 1 oz per quart. Spray 2 - 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

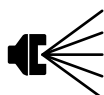
To sand

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 (1235)..... 5 Gallon
Shelf life.....3 years	RTS solids by weight..... 49%
Approx. coverage.....570 ft ² /gal @ 1 mil	Weight per gallon..... 10.72 #/gal
Physical Performance Properties:	
Substrate adhesion	Excellent rated 5B (ASTM D3359)
Tpcoat adhesion	Excellent rated 5A (ASTM D3359)
Water immersion	Passes 240 hrs. @ 100°F with no defects (GM 4466P)
Flexibility test.....	Rated 10 @ 23°C, and -30°C with no cracking (GM 9503P)

Regulatory

Category	Primer	Wt % of volatiles.....	51.22
VOC actual	0.54#/gal (65 g/l)	Wt % of water	46.20
VOC regulatory	1.34#/gal (160 g/l)	Wt % of exempt compound	0
Density	10.75 #/gal	Vol % of exempt compound	0

**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.
