



PRODUCT DATA

1221, 1225

Hydroflex[®] Super Hi Build Waterborne Flexible Primer Surfacer

DESCRIPTION:

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 feather-edge tearing.

TECHNICAL DATA:

WEIGHT PER GALLON:	10.9 #/gallon
% SOLIDS:	50% by weight, 35% by volume
V.O.C. CONTENT:	2.09 #/gallon (250g/l)
SHELF LIFE:	One Year
REDUCERS:	Not required - Ready to Spray
APPEARANCE:	Satin Black
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:	550 ft ² /gal @ 1 mil.

SALES POINTS:

- 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
- Proprietary Patented Formula - #1 selling waterborne primer in the automotive aftermarket and bumper recycler industry!

SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS

(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.)



PACKAGE SIZES:

- #1221 Hydroflex[®] Super Hi Build Waterborne Flexible Primer Surfacer (Black), Gallon (3.78 L), 4/case
- #1225 Hydroflex[®] Super Hi Build Waterborne Flexible Primer Surfacer (Black), 5 Gallon (18.90 L), 1/case

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Transtar Autobody Technologies experience and research and is believed to be reliable. As Transtar has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.

1221, 1225

Hydroflex® Super Hi Build Waterborne Flexible Primer Surfacer

SUITABLE SUBSTRATES:

Hydroflex Super High Build 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 will adhere to the following unpainted surfaces:

Hard Plastics:

SMC sheet moulding compound
 BMC bulk moulding compound
 GFK fiber glass laminate (unless gellcoat is broken)
 PC polycarbonate
 PVC

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.	polybutene terephthalate (pocan)
PPO	polyphenylene oxide polymer	PA	polyamide

Soft Plastics:

PUR Polyurethane

SURFACE PREPARATION:

Using Bond-Tec® Prep Wash #1004:

1. Wearing protective gloves, apply Prep Wash 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 Bond-Tec® Plasto-Mend TPO Adhesion Promoter #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:

1. Stir Hydroflex® Super Hi Build thoroughly before using. Reduce up to 10% with distilled water.
2. Spray 1 - 3 medium wet coats.
3. Flash about 5 minutes between coats.
4. Let air dry 1-2 hours before sanding.
5. Force dry 40 minutes @ 140°F or 5 - 10 minutes under infrared lights before sanding.

Spray Gun Set Up:	Gun Type	Fluid Tip	Cap Pressure	Pot Pressure
Set Up	Siphon HVLP	1.4 - 1.8 mm	10 psi max	
	Gravity HVLP	1.4 - 1.8 mm	10 psi max	
	Pressure Pot	1.1 - 1.6 mm	10 psi HVLP (30 - 40 conventional)	18 - 22 psi

DRY TO SAND:

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

* DO NOT apply below 60°F

COMPETITION:

ASI - Aqua Flex
 Dominion Sure Seal - BFXWB-916103
 SEM - 3924
 Urethane Supply Company - 3010-1
 Morton - 228-1/229-1

TEMPERATURE SENSITIVE - DO NOT FREEZE!