



TECHNICAL DATA SHEET

B04 MATTE FINISH LOW VOC ACRYLIC POLYURETHANE

07202021



As a high performance topcoat over properly prepared primed or sealed substrates and sanded stable coatings, including: Hot and Cold roll steel, Galvanized Steel, Aluminum, fiberglass, plastics and wood where high gloss and color retention is desired.



COMPONENTS

- B04
- R60/70/85
- H40

Topcoat
Fast/Medium/Slow National Rule Reducers
National Rule Hardener



MIXING RATIO

Four (4) parts color to one (1) part selected hardener. Reduce 10%-20% with selected Reducer.



POT LIFE

1 1/2 hours at 68°F



CLEAN UP

Use Lacquer Thinner or zero VOC solvents. (Check local regulations)



PHYSICAL DATA

Solids wt. 31.6%
Volume wt. 24.6%

VOC

Coating: 1.88 lbs/gal - 255.9 g/l
Material: 2.62 lbs/gal - 314.4 g/l



DRY / FLASH TIMES

Dust Free: 30 minutes @ 68°F/20°C
Dry to Touch 1 hours @ 68°F/20°C
Total Hardness 24 hours @ 68°F/20°C
Force Dry 40 minutes @ 140°F/60°C



GUN SETUPS

HLVP Gravity Feed 1.4 mm – 1.6 mm
Pressure Pot HLVP 1.0 mm – 1.1 mm
Air Assist Airless 1.0 mm - 1.1 mm
Conventional 1.4 mm - 1.7mm
Airless Not Recommended



SURFACE PREPARATION

Use HyMax Clean Wipe (S01) to clean substrate free of grease, dirt, and foreign contaminants.

Best:
SA2 sandblast Blow all dust and contaminates off and apply Hystar primer within 12 hours followed by topcoat as directed.

Better:
Hot Phosphate wash system, blow dry and apply Hystar primer within 8 hours followed by topcoat as directed

Good:
Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal solvent, making sure all residue is removed. Apply suitable Hystar primer, followed by topcoat as directed.

Aluminum: Clean surface with clean drying wax and grease remover. Apply Hystar Epoxy Primer or P10, followed by topcoat as directed.

Galvanized Steel: Clean all dust, oil residue, and contaminates from surface using a Clean drying wax and grease remover. Light Sanding (320P grit) Clean again with clean drying wax and grease remover ensuring that all residue is removed. Apply Hystar P10 followed by topcoat as directed.



APPLICATION AT 77° F/25°C

- Two medium wet coats, allow 10-20 minutes flash between coats



SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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