

## PROTEGACRYL HBC-W & HBC20-W

### DESCRIPTION

Low VOC, water-borne anticorrosive primer/finish.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Suitable for structural and modular steelwork, agricultural and earth moving equipment.
- ◆ Quick air drying properties.
- ◆ Good corrosion resistance.
- ◆ Suitable for application by conventional and airless spray.
- ◆ Excellent adhesion to thoroughly degreased mild steel, blast cleaned steel or phosphated steel (preferred).
- ◆ Suitable for use on some plastics.
- ◆ Low VOC's – formerly 'EPA Compliant' as a primer (below 250 gm/lit minus water) to PG6/23 (97).

### TECHNICAL DATA

**Volume solids** 42 ± 3% (ISO 3233) depending on colour.

**Weight solids** 52 ± 3% depending on colour.

**Viscosity** 1.8 - 2.0 poise @ 25°C depending on colour.

**Specific gravity** 1.14 – 1.24 depending on colour.

**Product code** Existing colours: 3448 series (HBC-W & HBC20-W)  
New colours : 3451 series (HBC20-W)

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
25 µm	59 µm	16.8 m <sup>2</sup> /l
45 µm	107 µm	9.3 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

### Drying time

DFT 30 µm, RH 50%	23°C
Flash off	10 - 15 min
Air dry	Touch 1- 2 h. Hard overnight
Force dry	20 - 30 min @ 60 - 80°C
Overcoating	Wet-on-wet after 20 – 30 min.

Drying times quoted are dependent on good air movement, temperature and humidity. For best results, good ventilation, a minimum temperature of 15°C and a relative humidity below 70% are recommended.

### Finish

Low gloss

### Colours

Black and a full range of colours to customer specifications.

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### APPLICATION DETAILS

<b>Surface preparation</b>	<p>Preliminary cleaning: remove oil grease with a suitable detergent. Remove salt and other contaminants by fresh water cleaning and allow to dry (ISO 12944-4). Pre-treatment improves adhesion and reduces corrosion under the paint film. The type of pre-treatment depends on the requirements for corrosion protection e.g.</p> <ol style="list-style-type: none"><li>1. Zinc phosphate with Cr-VI passivation.</li><li>2. Iron phosphate with demineralised water rinsing (insufficient rinsing can lead to the osmotic formation of bubbles).</li><li>3. Alkaline or neutral degreasing.</li><li>4. Clean steel.</li><li>5. Blast clean to BS EN ISO 8501-1:2001 Sa 2½ , maximum profile 75 microns. All sharp edges should be ground and weld spatter removed.</li></ol>
<b>Application conditions</b>	<p>Only apply in conditions of good ventilation which must be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the ambient temperature should be above 10°C and the Relative Humidity should not exceed 80%.</p>
<b>Application</b>	<p>Airless spray application, typical tip sizes employed are 11 – 13 thou. Suitable for spraying by conventional air spray as supplied.</p>
<b>Thinner</b>	<p>Potable water.</p>
<b>Cleaning of equipment</b>	<p>Remove remaining paint from equipment, flush thoroughly with water, or cleaning solution ProtegaClean 1921 or Fonteclean 1921, until solution appears uncontaminated.</p>
<b>FLASH POINT</b>	<p>Above 56°C</p>
<b>STORAGE</b>	<p>Store in dry, cool conditions and protect from frost.</p>
<b>VOC</b>	<p>Volatile Organic Compound content: 128 ± 20 gm/lit (inc. water), varies with colour.</p>
<b>HEALTH AND SAFETY</b>	<p>Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Protega Coatings Ltd.</p>