



Preparation and Application guide for HCF Acrylic Hard Coat

HCF is a water based product that MUST be stored above Freezing and applied at room temperature ideally above 16°C.

Mix well before use for best results use an electric paddle mixer, especially before spraying.

All surfaces to be coated, must be free of oils, dirt, wax and loose paint or rust. A sandblasted or rough surface improves adhesion. Use PLASTI DIP PRIMER for best results on smooth or non-absorbent surfaces. For a professional fine finish HCF should be filtered first, especially when spraying.

SPRAYING; Pressure pot/conventional sprayer may be used. Gently mix before spraying.

Apply wet, overlapping coats, holding gun 6"–12" from surface, using a 4"–6" pattern. Allow to completely dry before applying additional coats to desired thickness.

For spray application of HCF, add up to 10% distilled water ONLY for dilution.

DIPPING; Gently mix before each use. Do not introduce air bubbles. Allow the paint to stand for 2-3 hours for trapped air to disperse.

Insert item 1" every 5 seconds. Remove at the same rate. Allow to completely dry before applying additional coats to desired thickness.

BRUSH ROLLER; Gently mix before each use. Apply wet overlapping coats using a foam brush, pad or roller. Allow to completely dry before applying additional coats to desired thickness.

Hints.

For storage or dip tank containers, use only poly or galvanised steel.

A dry film thickness of 6-8 *mls is recommended for best results. Allow overnight drying whenever possible.

For speed drying, mild heat (95°F–110°F/35°C–43°C) and air flow may be used. Do not stack or store parts in contact with each other if not fully cured. Avoid excessive air movement, heat or dampness. Being water-based please avoid applying in cold, damp or humid conditions, otherwise allow longer drying times and protect from the elements.

Always use proper ventilation and use proper protection. Do not allow it to freeze in storage.

* 1 mls = 0.001 inch or 0.0254 millimeters