



# TECHNICAL DATA SHEET

## HFP-Series Polyester Basecoat

HFP-Series Polyester Basecoat is a quick dry, good hiding, factory pack line of many popular colors. Various OEM colors are available. Ideal for overalls, large blend area repairs, or for ground-coat material. For a complete and current list of colors offered, please visit [www.highteck.com](http://www.highteck.com).

### Application

#### Surface Preparation

For dry sanding, a final sanding step of P500-P600 grit is recommended using a maximum 100 grit step difference or less throughout the taken sanding steps. For wet sanding, a final sanding step of P800-P1000 grit is recommended using a maximum of 200 grit step difference or less throughout the sanding steps. Clean area with a good grade wax and grease remover and wipe dry with a clean cloth. Wipe area with tack cloth to remove any dust or dirt particles.

#### Mixing Directions

1 Part HFP-Series  
1 Part Reducer  
<10% Hardener

High Teck Basecoat  
Urethane-grade Universal Reducer  
Basecoat Hardener (optional)

#### Spray Gun Set-up

##### Spray Gun:

Gravity feed  
Gravity feed HVLP  
Siphon feed

##### Fluid Tip:

1.3-1.5mm  
1.3-1.5mm  
1.6-1.8mm

##### Application pressure:

30 PSI at the spray gun air inlet  
10 PSI max at air cap  
40-50 PSI

#### Application

Apply 2 - 4 single coats or until full coverage is achieved.

#### Drying Schedule

Allow each coat to flash off for approximately 5 to 10 minutes at 70°F. Prior to clearcoat application, allow a minimum of 20 minutes flash time at 70°F and a maximum of 24 hours flash time at 70°F. Should this maximum time be exceeded, scuff surface and apply another coat.

#### Catalyst (Optional)

Can be catalyzed up to 10% of unreduced color portion with appropriate isocyanate hardener.

#### Cleaning of Equipment

Clean equipment with lacquer thinner.

### Technical Data

Mixing Ratio	1:1 by vol. w/reducer
Pot life	Indefinite, if not catalyzed
Viscosity @ Gun	13 - 15 sec #4 Zahn
Recommended Film Thickness	Appox. 0.4 - 0.8 mil
Flash Point	53°F TCC
Air Pressure @ Gun	30 PSI gravity feed, 10 PSI max at cap HVLP, 40-50 PSI siphon feed
Coverage @ 0.6 mil	286 sq ft/g
VOC @ Gun	Maximum of 6.8 lb/gal in ready to spray form



# TECHNICAL DATA SHEET

## HFP-VOC Series Polyester Basecoat

HFP-VOC Series Polyester Basecoat is a quick dry, good hiding, factory pack line of many popular colors. Various OEM colors are available. Ideal for overalls, large blend area repairs, or for ground-coat material. For a complete and current list of colors offered, please visit [www.highteck.com](http://www.highteck.com).

### Application

#### Surface Preparation

For dry sanding, a final sanding step of P500-P600 grit is recommended using a maximum 100 grit step difference or less throughout the taken sanding steps. For wet sanding, a final sanding step of P800-P1000 grit is recommended using a maximum of 200 grit step difference or less throughout the sanding steps. Clean area with a good grade wax and grease remover and wipe dry with a clean cloth. Wipe area with tack cloth to remove any dust or dirt particles.

#### Mixing Directions

1 Part HFP-Series	High Teck Basecoat
1 Part Reducer	VOC-grade Universal Reducer
<10% Hardener	Basecoat Hardener (optional)

#### Spray Gun Set-up

<u>Spray Gun:</u>	<u>Fluid Tip:</u>	<u>Application pressure:</u>
Gravity feed	1.3-1.5mm	30 PSI at the spray gun air inlet
Gravity feed HVLP	1.3-1.5mm	10 PSI max at air cap
Siphon fees	1.6-1.8mm	40-50 PSI

#### Application

Apply 2 - 4 single coats or until full coverage is achieved.

#### Drying Schedule

Allow each coat to flash off for approximately 5 to 10 minutes at 70°F. Prior to clearcoat application, allow a minimum of 20 minutes flash time at 70°F and a maximum of 24 hours flash time at 70°F. Should this maximum time be exceeded, scuff surface and apply another coat.

#### Catalyst (Optional)

Can be catalyzed up to 10% of unreduced color portion with appropriate isocyanate hardener.

#### Cleaning of Equipment

Clean equipment with lacquer thinner.

### Technical Data

Mixing Ratio	1:1 by vol. w/reducer
Pot life	Indefinite, if not catalyzed
Viscosity @ Gun	13 - 15 sec #4 Zahn
Recommended Film Thickness	Appox. 0.4 - 0.8 mil
Flash Point	53°F TCC
Air Pressure @ Gun	30 PSI gravity feed, 10 PSI max at cap HVLP, 40-50 PSI siphon feed
Coverage @ 0.6 mil	286 sq ft/g
VOC @ Gun	Maximum of 3.5 lb./gal in ready to spray form