



## GENERAL INFORMATION

HS35 Multi-Use 2K urethane surfacer/sealer is a High Solids primer formulated to provide the ultimate in performance, productivity, versatility, adhesion, durability, moisture and corrosion resistance, and superior sanding and sealing characteristics.



## 1. COMPONENTS

- HS35 2K Multi-Use Surfacer/Sealer
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- 173 Slow Uni-Solvent 85°-95°F (29°-35°C)
- 174 Very Slow Uni-Solvent 95°F (35°C) and over
- X01 Fast Uni-Solvent LV Reducer
- X02 Medium Uni-Solvent LV Reducer
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Very Fast Activator



## 2. MIXING RATIO

### RFU as Surfacer - 4:1:1

- Mix four (4) parts HS35 to one (1) part HPC0, HPC1, HPC2, or HPC3 Activator and reduce with one (1) part Uni-Solvent 171-174, or Uni-Solvent LV X01 or X02. (4:1:1 by volume)

### RFU as Sealer - 4:1:2

- Mix four (4) parts HS35 to one (1) part HPC0, HPC1, HPC2, or HPC3 Activator and reduce with one (2) parts Uni-Solvent 171-174, or Uni-Solvent LV X01 or X02. (4:1:2 by volume)



## 3. POT LIFE @ 77°F (25°C)

	HPC0	HPC1	HPC2	HPC3
As Surfacer	40 min.	40 min.	30 min.	20 min.
As Sealer	45 min.	45 min.	35 min.	25 min.



## 4. CLEAN UP

Uni-Solvent 171-174 or Uni-Solvent LV X01, X02 (check local regulations).



## 5. SURFACE PREPARATION

- Surfaces should be prepared using the proper undercoat system following recommended procedures.
- Sanding grits coarser than 220P grit should be finish sanded with finer grit prior to application.
- Clean surface with Aqua Clean 170.



## 6. SUBSTRATES

- Properly prepared previously painted surfaces
- Properly prepared OEM finishes
- VP50 Epoxy Primer
- DTM2004 Primer
- Self-Etch 88G016
- CPS Series Primers and Sealers



## 7. APPLICATION

- Spray one to three medium wet coats or until desired build is achieved. **Do not exceed 6 mils.**
- Allow each coat 5-10 minutes flash or until flash is dull.
- Surface temperature should be 10 - 38°C with less than 80% ambient humidity preferred.



## 8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

	As Surfacer	As Sealer
Flash between coats	5-10 min.	4-8 min.
To Sand	60 min.	Nib Sand 20 min.
To Topcoat	60 min.	20 min.

## 9. INFRARED CURE

See Infrared Curing Information.



## 10. GUN SET UP

### CONVENTIONAL GUN

	As Primer	As Sealer
Gravity Feed	1.4 mm - 1.8 mm	1.3 mm - 1.5 mm
Siphon Feed	1.4 mm - 1.8 mm	1.3 mm - 1.5 mm



### HVLP

Gravity Feed	1.4 mm - 1.6 mm	1.3 mm - 1.4 mm
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### AIR PRESSURES

#### Conventional @ Gun

Gravity Feed	30-45 psi
Siphon Feed	30-45 psi

#### HVLP @ Cap

8-10 psi



## 11. PHYSICAL DATA

Reduced with Uni-Solvent 171-174

	As Surfacer	As Sealer
VOC (PKG) per U.S. Gal.	2.95	2.95
VOC (RTS) per U.S. Gal.	3.7	4.2
Total Solids by Weight (RTS)	65.3%	58.8%
Total Solids by Volume (RTS)	46%	39.4%
Sq. Ft. Coverage/US Gal. (RTS)	738	632
Flash Point (RFS)	45°F	45°F
Total HAPS (lb HAPS/gal solid)	1.07	1.51

Reduced with Uni-Solvent LV X01 or X02

	As Surfacer	As Sealer
VOC (RTS) per U.S. Gal.	3	3
Flash Point (RFS)	-4°F	-4°F
Total HAPS (lb HAPS/gal solid)	0.629	0.629