



Product Data

HI-GLO® 4.0/4.3 VOC

Synthetic Enamel

PRODUCT DESCRIPTION

HI-GLO® 4.0/4.3 is an extremely durable synthetic enamel system which is offered in both intermix and Factory Packaged Colors. HI-GLO® 4.0/4.3 offers an exceptional wet gloss finish, is easy to apply and dries quickly.

TECHNICAL DATA

• Viscosity (sprayable) - #4 Ford Cup	15-18 sec.	• Dielectric strength over steel (off-whites)	1780 volts/mil
• Coverage/sprayable gal @ 1 mil (dry) (White)	610 sq ft	• VOC as applied - solids - metallics	4.0 lbs/gal 4.3 lbs/gal
• Recommended dry film thickness(2 coats)	2.0-3.0 mils	• Performance after one week air dry	
• Gloss 60°	95	- Flexibility (1/8" con. mandrel)	Excellent
20°	80	- Solvent resistance (Gasoline/Diesel/Oil)	Excellent
• DOI	75	- Salt spray resistance - 250 hrs	Excellent
		- Humidity resistance - 96 hrs	Excellent

SURFACE PREPARATION

Bare Substrates: Steel, properly treated Galvanized Steel*, Aluminum, or Fiberglass

**Note: With the inconsistencies of galvanized steel, consult your local Sales Representative for system recommendations and substrate testing.*

1. Solvent clean with Low VOC Surface Cleaner WS1019 and wipe dry with a clean, dry cloth.
2. Apply appropriate pretreatment primer.
3. For maximum protection, a premium pretreatment primer is recommended. Follow with Low VOC Epoxy Primer-Sealer WP230/232, 2K HS Urethane Sealer WP-240, or 1K Waterborne Sealer WP-250.

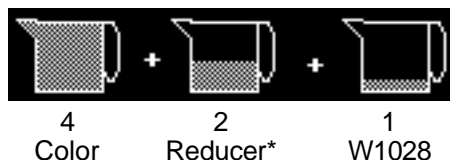
Prepainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth.
2. Solvent clean surfaces with Low VOC Surface Cleaner WS1019. Wipe dry with clean cloth.
3. Grind off paint and remove all rust. Fill as needed using an appropriate body filler. Allow body filler to tack up and shape as needed. Body filler must be cured before coating.
4. Sand repair area and featheredge using 80, 180, 280, and finally 320 grit treated sandpaper on a random orbital sander.
5. Apply appropriate pretreatment primer.
6. Surface with 1K Waterborne Primer-Surfacer WP-220 or Low VOC Primer-Surfacer WP230/234 as needed. Block sand with 180 to 280 grit treated sandpaper.
7. Finish sand repair area with 320 grit treated sandpaper on a random orbital sander.
8. Seal with Low VOC Primer-Sealer WP230/232, 2K HS Urethane Sealer WP-240, or 1K Waterborne Sealer WP-250.

(For the above products refer to the appropriate product label or data page for complete information.)

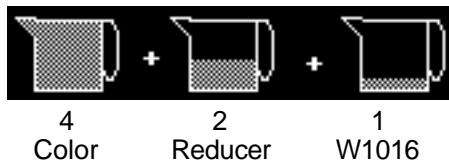
MIXING

1. Stir or shake HI-GLO® 4.0/4.3 Color thoroughly before mixing.
2. Mix 4 parts Color to 2 parts HI-GLO® Gloss Reducer WG-6590 or WG-85100 to 1 part Hardener W1028. Potlife @ 75°F - 2 hours.



*Use extra 10% reduction with WS- reducers for metallic colors (ie, 3 ounces per sprayable quart).

3. Optional Mixing Ratio for metallic colors*:
 Mix 4 parts HI-GLO® 4.3 Metallic Color to 2 parts WG6590 or WG-85100 to 1 part W1016.



*Note: The use of W1016 allows quicker metal-set and film dry rate. Use of W1016 is only recommended when the VOC of the unreduced paint is 4.92 lbs/gal or less. This ensures a ready-to-spray VOC at 4.3 lbs/gal or less. Use of additional reducer (WS4575, WS6590, WS85100, WS59, or WS60) is allowed based on the following table:

VOC of Unreduced Paint	Additional WS Reducer allowed to be added to 32 ounces of <u>Ready-to-Spray</u> paint for 4.3 VOC Maximum
4.92 or higher	0.0
4.85	1.0
4.80	1.3
4.75	1.7
4.70	2.0
4.65	2.3
4.60	2.7
4.55	3.0
4.50	3.3
4.45	3.6
4.40	3.9
4.35	4.5
4.30	4.8
4.25	5.1
4.20	5.4
4.15	5.7
4.10	6.0
4.05	6.3
4.00	6.6

APPLICATION

1. Adjust air pressure at the gun to **45-65** psi for siphon feed or pressure feed (adjust pot pressure to 10-12 psi).
2. Apply **1** light tack coat at a gun distance of **8-10** inches allowing 10 minutes flash time, then apply 2 full wet coats allowing at least 10 minutes flash time between coats. To uniform metallic colors apply a mist coat immediately by increasing the gun distance to **12-14** inches.
Note: Recommended dry film thickness is **2.0-3.0** mils.
3. If fisheyes are a problem, add 3-6 drops of SILAWAY® Fisheye Eliminator W20 per sprayable gallon of HI-GLO® 4.0/4.3.
5. Clean spray gun immediately after use with lacquer thinner.

DRYING SCHEDULE

Dry times are based on 4:2:1 mixing ratio with W1028 hardener at the recommended dry film thickness of **2.0-3.0** mils; thicker films will extend drying times.

- **Air dry times @ 70°F and 50% R.H.:**

Dust free	2 hours
Tack free	3 hours
Tape free	24 hours
- **Force dry times**

<u>Temperature</u>	
120°F	30-40 minutes
140°F	20-30 minutes
160°F	20 minutes