Product Data

HI-GLO® Synthetic Enamel

PRODUCT DESCRIPTION

HI-GLO® is an easy to apply, high gloss and extremely durable synthetic enamel system which is offered in both intermix and Factory Packaged Colors. HI-GLO® is ideal for economical refinishing of passenger cars and trucks, local fleets and light manufacturing.

HI-GLO® has four options for matching it to customer's needs:

- Uncatalyzed - use for economical jobs where performance is not as critical
- Catalyzed - use for higher performance where gloss and DOI are important
- Integrated - use for optimum appearance and gloss in a single stage application especially when doing high metallic colors
- Urethane Clearcoat - offers the maximum appearance, gloss and durability of a two stage urethane clearcoat

TECHNICAL DATA

• Viscosity (sprayable) - #4 Ford Cup (With or without hardener)	15-18 sec.
• Flash point - TCC	56°F
• Coverage/sprayable gal @ 1 mil (dry) (White)	430 sq ft
• Recommended dry film thickness (2 coats)	2.0-3.0 mils

		Uncatalyzed	Catalyzed	Integrated &C/C
• Gloss	60°	88	90	95
	20°	60	65	80
• DOI		55	60	75

• Dielectric strength over steel (off-whites)	1780 volts/mil
• VOC as applied (4:1 uncatalyzed)	4.7-5.1 lbs/gal
(8:2:1 catalyzed)	4.4-5.1 lbs/gal
(8:4:1 with integrating reducers)	4.4-4.9 lbs/gal
• Performance after one week air dry	
- Flexibility (1/8" con. mandrel)	Excellent
- Solvent resistance (Gasoline/Diesel/Oil)	Excellent
- 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 Grease and Wax Remover WS1018 or Low VOC Surface Cleaner WS1019 and wipe dry with a clean, dry cloth.
2. Treat bare steel areas with appropriate metal conditioner.
3. For maximum protection, a premium pretreatment primer is recommended. Follow with Low VOC 2k Waterborne Epoxy Primer-Sealer WP230/232, HI-GLO® Primer Sealer W711/712/713, or Low VOC Sealer WP240.

Prepainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth.
2. Solvent clean enamel surfaces with Grease and Wax Remover WS1018 or 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. Treat bare steel areas with appropriate metal conditioner.
6. Surface with E-PRIME® Acrylic Primer-Surfacer WP215, or WP67, WP100, WP150 Primer-Surfacers, or Low VOC 1k Waterborne Primer-Surfacer WP220 or Low VOC 2k Waterborne Primer-Surfacer WP230/WP234 . Block sand with 180 to 280 grit.
7. Finish sand repair area with 320 grit treated sandpaper on a random orbital sander.
8. Seal with HI-GLO® Primer Sealer W711/712/713/750, Low VOC 2k Primer-Sealer WP230/232 or Low VOC Sealer WP240.

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

MIXING

1. Stir or shake HI-GLO® Color thoroughly before mixing.
2. Reducer selection:

Reducer	Temperature
WS4575/WS59	45-75°F
WS6590/WS60	65-90°F
WS85100/WS61	85-100°F

3. **Uncatalyzed**: mix 4 parts Color to 1 part HI-GLO® Reducer (WS4575/WS59 Cool Weather, WS6590/WS60 Normal, WS85100/WS61 Hot Weather)

4 Color + 1 Reducer

Catalyzed: mix 8 parts Color to 2 parts HI-GLO® Reducer (WS4575/WS59 Cool Weather, WS6590/WS60 Normal, WS85100/WS61 Hot Weather) to 1 part HI-GLO® Hardener W1001, W1010, W1016, or W1020.

8 Color + 2 Reducer + 1 Hardener

Catalyzed: with GLASPAK® Premixed Catalyst. Mix 4 parts Color to 1 part GLASPAK® Catalyst (W1029 Normal, W1030 Hot Weather)

4 Color + 1 Catalyst

Integrated Reducers: mix 8 parts Color to 4 parts Western Urethane Integrating Reducer (WV4575 Cool Weather, WV6590 Normal, WV85100 Hot Weather) to 1 part Western Urethane Hardener W1001, W1016, W1020, or W1025.

8 Color + 4 Integrating* Reducer + 1 Hardener

**For added application control, flow, and leveling, up to 2 additional parts of WS4575/WS59, WS6590/WS60, WS85100/WS61 can be added.*

4. Potlife @75°F - with integrated WV reducers is 2 hours; with hardener is 6-8 hours; without hardener is unlimited.

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). 10 psi at the tip for HVLP.
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 while last coat is still wet 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 6 drops of SILAWAY™ Fisheye Eliminator W20 per sprayable gallon of HI-GLO® Color.
4. Clean spray gun immediately after use with a quality lacquer thinner.

CLEARCOATING/INTEGRATING CLEARS

Urethane Clearcoat: HI-GLO® Urethane Clearcoat W159. Mix 8 parts W159 Clear to 2 parts HI-GLO® Reducer (WS4575/WS59 Cool Weather, WS6590/WS60 Normal, WS85100/WS61 Hot Weather) to 1 part Hardener W1001 GLOSS ONE® or W1010 MAXI-GLOSS® or W1016 HI-GLO® High Solids or W1020 INTERLOCK®.

8	2	1
W159 Clear	Reducer	Hardener

Urethane Clearcoat: for use with GLASPAK® Premixed Catalyst. Mix 4 parts W159 Clear to 1 part GLASPAK® Catalyst (W1029 Normal, W1030 Hot Weather*)

4	1
W159 Clear	GLASPAK® Catalyst

*For proper results, GLASPAK® Catalyst must also be used in Color

Urethane Clearcoat:
Note*: *Must use W1016 Hardener in color coat when using with W160 Clearcoat.
HI-GLO® High Performance Urethane Clearcoat W160. Mix 4 parts W160 Clear to 1 part HI-GLO® Reducer (WS4575/WS59 Cool Weather, WS6590/WS60 Normal, WS85100/WS61 Hot Weather) to 1 part Hardener W1016 HI-GLO® High Solids Hardener.

4	1	1
W160 Clear	Reducer	Hardener

APPLICATION

Adjust the air pressure at the gun to:
- 50-60 psi for siphon feed gun
- 50-60 psi for pressure-feed gun with 5-10 psi at the pot
- 10 psi max at the tip for HVLP gun

- Using as an Integrating Clear:
  1. Before the last color coat, mix equal parts of ready-to-spray color with ready-to-spray clear.
  2. Apply 1-2 full coats

- Using as a Clearcoat:
  1. Allow HI-GLO® topcoat to dry for 20-60 minutes before clearcoating.
  2. Apply 2 full coats.

Potlife: W159, W160 - 4 hours

TOPCOAT CLEARCOAT

High Solids Urethane Clearcoat:

Note*: *Must use W1016 Hardener in color coat when using with W1000 Clearcoat.

Mix 4 parts W1000 Clear to 2 parts HI-GLO® Reducer (WS4575/WS59 Cool Weather, WS6590/WS60 Normal, WS85100/WS61 Hot Weather) to 1 part Hardener W1016 HI-GLO® High Solids Hardener.

4 W1000 Clear + 2 Reducer + 1 W1016 Hardener

Potlife: W1000 - 4 hours

APPLICATION

Adjust the air pressure at the gun to:

50-60 psi for siphon feed gun
50-60 psi for pressure-feed gun with 5-10 psi at the pot
10 psi max at the tip for HVLP gun

1. Allow HI-GLO® topcoat to dry for 20-60 minutes before clearcoating.
2. Apply 2 full coats.

GUN RECOMMENDATIONS

Spray Gun Type	*Manufacturer*	*Spray Gun Model*	*Nozzle*	*Orifice Size*	*Air Cap*
Siphon Feed	DeVilbiss	JGA502	EX	.070”	80
Siphon Feed	Sharpe	975/971	1-975-04-70N1	.070”	1-71-02MO
Gravity Feed	SATA	SATA Jet 90	1.4 mm	.055”	Nozzle Set
Gravity Feed	SATA	SATA Jet B	1.4 mm	.055”	Nozzle Set
HVLP	Binks	Mach I	92	.046”	97P
HVLP	DeVilbiss	JGHV560	FX	.042”	28
HVLP	SATA	Jet/B-NR95	1.5 mm	.067”	Nozzle Set

DRYING SCHEDULE

Dry times are based on the recommended dry film thickness of **2.0-3.0** mils; thicker films will extend drying times.

	Uncatalyzed/Catalyzed/Integrated /W159/W160	W1000
• **Air dry times** @ 70°F and 50% R.H.:		
Dust free	2 hours	30-60 minutes
Tack free	3-4 hours	2-3 hours
Tape free	24 hours	24 hours
• **Heated forced air dry times**		
Temperature		
120°F	1 hour	40 minutes
140°F	45 minutes	30 minutes

PRODUCT QUICK REFERENCE CHART

PRODUCT HI-GLO® Synthetic Enamel

USE

- Durable, wet-look finish for passenger cars, trucks, local fleets and light manufacturing.
- Available in intermix and factory package color.

SUITABLE SUBSTRATES

- OEM Enamels
- Refinish Enamels
- E-PRIME® Primer Surfacer
- 1k Waterborne Primer-Surfacer
- 2k Waterborne Primer-Surfacer
- HI-GLO® Primer-Sealer
- 2K HS Urethane Primer-Sealer
- 2K Waterborne Epoxy Primer-Sealer

SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with the appropriate solvent cleaner, and wipe dry with a clean cloth.
- **Grind** repair area to remove paint and all rust as needed.
- **Apply body filler** to clean bare metal as needed.
- **Sand** all areas to be refinished and feather edge all broken film areas.
- **Treat** bare metal with an appropriate metal conditioner or etching primer.
- **Surface** with appropriate primer-surfacer. Finish sand with 320 grit sandpaper.
- **Seal** with HI-GLO® Primer-Sealer W710, W711, W712, W713, W750.

MIXING

- Stir or shake HI-GLO® color thoroughly before mixing.

Uncatalyzed

4 Color : 1 Reducer

Catalyzed

8 Color : 2 Reducer : 1 Hardener

With Premixed Catalyst

4 Color : 1 Hardener

With Integrated Reducers

8 Color : 4* Integrating Reducer : 1** Hardener

CLEARCOATING/INTEGRATING CLEARS

Urethane Clearcoat

8 W159 Clear : 2 Reducer : 1 Hardener

Urethane Clearcoat

4 W160 Clear : 1 Reducer : 1 W1016

Note: Must use W1016 in color coat when using with W160 Clearcoat

TOPCOAT CLEARCOAT W1000

4 W1000 Clear : 2 Reducer : 1 W1016

Note: Must use W1016 in color coat when using with W1000 Clearcoat

- Potlife @ 75° - Uncatalyzed - unlimited; Catalyzed - 6 hours; Integrated - 2 hours. W159, W160, W1000 - 4 hours

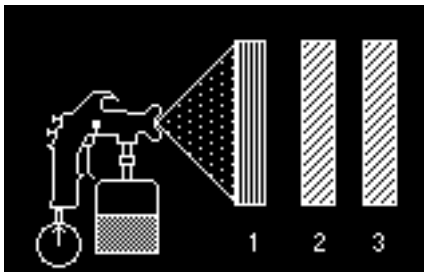
*For added application control, flow, and leveling, up to 2 additional parts of WS6575/WS59, WS6590/WS60 or WS85100/WS61 can be added.

**W1029 and W1030 CANNOT be used with integrating reducers

APPLICATION

Siphon feed

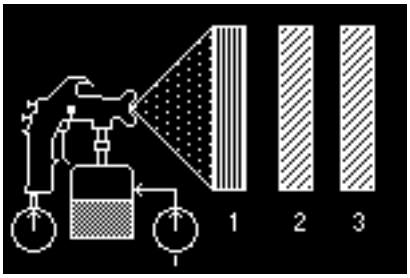
Apply **1** light tack coat. Allow 10 minutes flash time, then apply **2** full wet coats allowing 10 minutes flash time between coats.



45-65 psi
HVLP - 10 psi at the tip

Pressure feed

Apply **1** light tack coat. Allow 10 minutes flash time, then apply **2** full wet coats allowing 10 minutes flash time between coats.



45-65 psi
pot pressure **10-12**

NOTES

- If fisheyes are a problem, add 6 drops of SILAWAY® Fisheye Eliminator W20 per sprayable gallon of HI-GLO®.
- Recommended dry film thickness is 2.0-3.0 mils.

PAINT-SAFE® K

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a positive air respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and rubber gloves when using product.