



# HI-GLO® 3.5 VOC Synthetic Enamel

## PRODUCT DESCRIPTION

HI-GLO® 3.5 is an extremely durable synthetic enamel system which is offered in both intermix and Factory Packaged Colors. HI-GLO® 3.5 offers an exceptional wet gloss finish, is easy to apply, and dries quickly.

## TECHNICAL DATA

• Viscosity (sprayable) - #4 Ford Cup	13-16 sec.
• Coverage/sprayable gal @ 1 mil (dry) (White)	630 sq ft
• Recommended dry film thickness (2 coats)	2.0-3.0 mils
• Gloss 60°	95
20°	85
• DOI	80
• Dielectric strength over steel (off-whites)	1780 volts/mil
• VOC as applied	3.5 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 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.

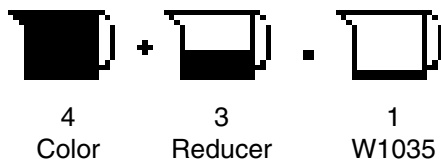
### Prepainted Substrates:

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® 3.5 Color thoroughly before mixing.
2. Mix 4 parts Color to 3 parts HI-GLO® 3.5 Reducer WC-6590 or WC-85100 to 1 part Hardener W1035. Potlife @ 75°F - 2 hours.



## 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® 3.5.
4. Clean spray gun immediately after use with lacquer thinner.

## GUN RECOMMENDATIONS

<b>Spray Gun Type</b>	<b>Manufacturer</b>	<b>Spray Gun Model</b>	<b>Nozzle</b>	<b>Orifice Size</b>	<b>Air Cap</b>
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

(\*Use one supplied)

## DRYING SCHEDULE

Dry times are based on 4:3:1 mixing ratio with W1035 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
  - Temperature
  - 120°F 40 minutes
  - 140°F 30 minutes
  - 160°F 20 minutes

# PRODUCT QUICK REFERENCE CHART

## PRODUCT USE

## HI-GLO® 3.5 VOC Synthetic Enamel

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

## SUITABLE SUBSTRATES

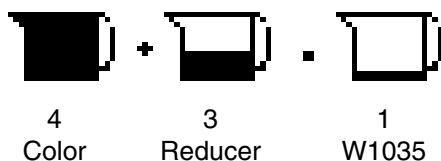
- OEM Enamels
- Refinish Enamels
- 2K Waterborne Epoxy Primer-Sealer
- 1K Waterborne Primer-Surfacer
- 2K Waterborne Primer-Surfacer
- 2K HS Urethane Primer-Sealer

## 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 WP230/232, WP240 or WP250.

## MIXING

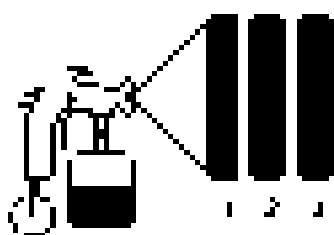
- Stir or shake HI-GLO® color thoroughly before mixing.
- Mix 4 parts Color to 3 parts HI-GLO® Gloss Reducer WC-6590 or WC-85100 to 1 part Hardener W1035. Potlife @ 75°F - 2 hours.



## APPLICATION

### Siphon feed

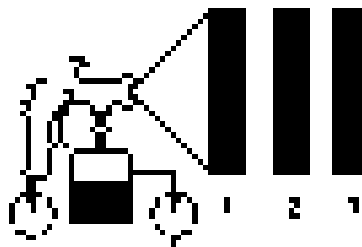
Apply 1 light tack coat. Allow 10 minutes flash time, then apply 2 full wet coats allowing 10 minutes flash time between coats.



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 3-6 drops of SILAWAY® Fisheye Eliminator W20 per sprayable gallon of HI-GLO® 3.5.
- Recommended dry film thickness is 2.0-3.0 mils.

## PAINT-SAFE®

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- 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.

