



HBEF High Build Etching Filler

74780SP/01

Matthews 74780SP/01 HBEF is a quality, two-component, high build self-etching metal primer. It is designed for use on raw aluminum and steel.

74780SP/01 HBEF etches the properly prepared metal surface to provide outstanding paint adhesion and corrosion resistance.

This fast drying etching primer is light-yellow/beige in color and will fill a 100g DA sand scratch with a two-coat application.



Features:

Topcoat with any Matthews Acrylic Polyurethane finishes	Versatile, multi-purpose
Easy mix ratio	Less time mixing
Anti-corrosion properties	Provides excellent corrosion protection
Etching properties	Great adhesion to properly prepared aluminum or steel
14 day pot life	Mix once and use for two weeks

Benefits:

Compatible Surfaces:

74780SP/01 High Build Etching Filler may be applied over properly prepared:

Aluminum
Steel

Associated Products:

74781SP/01 HBEF Activator

74780SP/01

Directions for Use

Surface Preparation: Substrate should be prepared according to Matthews Substrate Preparation Guide prior to primer application.

Mix Ratio:



Mix Ratio for Spraying (by volume)

74780SP/01 74781SP/01

1 part 1 part

- All components should be mixed thoroughly before using
- Strain material after mixing
- Store mixed materials in an acid resistant plastic container



Pot Life: 14 days

Pot-life is the amount of time before spray viscosity doubles. These are estimates based on lab results at 50% relative humidity, 70°F/21°C—results will vary based on application conditions. Note: mix no more product than can be used within the pot life.

Additives:



None

Spray Set Up:



Air Pressure: Conventional: 40 - 50 psi at the gun*
HVLV: 10 psi at the cap*

* Refer to spray gun manufacturer recommendations for inlet pressure.



Pressure Pot Fluid Delivery: 8 - 12 Fluid Ounces per Minute



Gun Set Up: Siphon Feed: 1.3 - 1.5 mm 0.051 - 0.059 fluid tip
HVLV: 1.3 - 1.5 mm 0.051 - 0.059 fluid tip
Pressure Pot: 1.1 mm 0.043 fluid tip

Application:



Apply: Apply two full wet coats, allowing proper flash time* between coats. Apply additional coats as necessary to achieve total dry film thickness.

*Flash times will vary dependent upon film thickness, temperature, spray gun set-up, application, etc.

		Per Coat	Total
Recommended Film Thickness:	Wet Film Thickness (WFT)	2.6 - 4.3 mils	5.2 - 8.6 mils
	Dry Film Thickness (DFT)	0.3 - 0.5 mils	0.6 - 1.0 mils

Caution: All 2-component crosslinking slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or loss of gloss, decreased durability and improper curing can occur.

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Directions for Use

Estimated Drying Times:



Air-Dry @ 50% Relative Humidity, 70°F/21°C
Dust Free 15 - 25 minutes
Dry to Touch 30 minutes*
Dry to Topcoat 30 minutes - 24 hours (max)**

*If necessary to remove dust nibs, 74780SP/01 High Build Etching Filler may be sanded with 220 - 320g after 2 - 4 hours (do not wet sand etch primers).

**After 24 hours, sand with a 220-400 grit dry, or equivalent sanding pad. Do not sand below minimum dry film thickness, otherwise reprime before topcoating.

Note: Etch primers should never be wet sanded or exposed to moisture or weather before topcoating.

Equipment Cleaning:

Clean equipment promptly with lacquer thinner or equivalent cleaning solvent.

Note: Do not leave mixed material in equipment.

Technical Data:

VOC Information

VOC Actual RTS	6.02 lbs/gal
VOC Actual RTS	721 g/L
VOC Regulatory (less water less exempt) RTS	6.1 lbs/gal
VOC Regulatory (less water less exempt) RTS	731 g/L

For complete VOC information, visit MatthewsPaint.com > Quick Links > VOC Data

Performance Characteristics

Volume solids (RTS)	11.45%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	183 sq.ft./RTS gal
Application Conditions - Temperature	60°F (16°C) Minimum 100°F (38°C) Maximum
Application Conditions - Relative Humidity	85% maximum 5° above dew point

Important: The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION - US (412) 434-4515; CANADA (514) 645-1320; Mexico 01-800-00-21-400
Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Matthews Paint. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Matthews Paint warrant freedom from patent infringement in the use of any formula or process set forth herein. If you require technical assistance, please call us toll-free 800/323-6593.

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