TECHNICAL DATA SHEET

HYDROSAND 490

WATERBASE PRIMER

DESCRIPTION

Hydrosand 490 white Primer is a high solids primer designed for use on interior softwoods and hardwoods products. This HAPS free and extremely low VOC primer is easy to apply and has good adhesion and good sandability with minimal grain raise.

PRODUCT DATA

Color	White	**VOC less exempts**	50.63 g/L	0.42 lb/gal
Solids % by Vol	47%± 2%	**VOC actual**	76.01 g/L	0.63 lb/gal
Solids %by Wt	56% ± 2%	**Photochemical reactive**	No	
Density	1.35 ± 0.02	**Flash Point (PM/CC)**	N/A	
Viscosity 23°C/73°F (cps)	1500-2500	**Shelf life**	12 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	Flat	**Theo-coverage @1 mil dry**	725-750 Sq.Ft/gal	15 m^2/L

PREPARATION/APPLICATION

Working Temp >18°C/65°F surface, coating and air

Catalyzation Optional for optimal mechanical and chemical resistance: 5 % by volume using Catalyst CW 7500 or CW 7800

Pot life N/A

Reducer If reduction is needed to optimize application, reduce 5-10% by volume with distilled water, or HRX L (medium reducer), or HRX SL (slow reducer) and HRX Retarder can be used to slow

Application

- Prime- Apply Hydrosand 490 white primer at 4 – 6 wet mils.
- Air dry thoroughly. Sand with 240 grit sandpaper. A second coat of primer may be applied for improved holdout. Sand between primer coats and before topcoat. Topcoat within 8 hours of sanding
- Topcoat – apply one of recommended LORCHEM finishes.at 3 - 5 mils wet.

Surface Preparation Wood surface must be dry, and finish sanded with 180 grit sandpaper Substrate should be clean and free of grease and oil to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.

Use Directions For interior use only. Catalyze(if needed), adjust viscosity and stir thoroughly before application to avoid variations application. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.

App equip. Conventional & HVLP Siphon Feed, Pressure Pot Systems and Airless/Air Assist Equipment.

Tinting Can be tinted up to 5% maximum with AquaTint colorants

Cleanup Clean tools/equipment immediately after use with HRX Kleaner or warm water.

DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	**Dust free time**	15 minutes	**Dry to sand**	4 hours
		Dry to touch		**Dry to recoat**	6-8 hours
		Dry to Handle	45 minutes	**Dry to stack**	12 hours
Force dry	45 °C/110°F	30 minutes			

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

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APPLICATION RECOMMENDATIONS

APPLICATION EQUIPMENT SETTINGS

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Dilution %	Thickness Film (Mils)
Conventional spray	40-60	-	2-2.5/0,078-0.098	10-20	3-5
Airmix Spray	-	1100-1600	9-11/0,35-0.43	-	3-5

The use of pre-atomizers and pre-heaters, to bring the temperature to 30 – 40 °C, ensures a correct application regardless the room temperature. The drying process should be carried out in environments with adequate air ventilation (the recycle of air in the drying room should be carried out every 15-20 minutes).

Note: All measurements and application equipment settings are based on application at a temperature of 77°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

SPECIFICATIONS

- For interior use only.
- Must be agitated before and during using. Avoid vigorous agitation which may cause foaming.
- Use stainless steel spray equipment. Tank, piping, and containers should be lined steel or plastic.
- Excessive wet film thickness of more than 4.0 mils wet may sag on vertical applications.
- Reducing more than 10% with water will lessen performance as a barrier coat to tannins.
- For applications on MDF two coats of primer are recommended. Sand between coats.
- Do not expose to freezing temperatures. The liquid coating will not handle any freeze/thaw cycles.
- Apply under recommended LORCHEM topcoat. Please contact your LORCHEM representative for system recommendations.
- Total film thickness of systems must not exceed 7.0 mils dry film because heavier films may show cracking tendencies.
- Very low temperature application (less than 12°C) may cause poor mechanical and chemical film properties.

CAUTIONS

TESTING

Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

PDS

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

CONTACT

PH: +1(450)424-4000
F: +1(450) 424-9134
http://www.lorchemintl.com

LORCHEM INTERNATIONAL
150,Rue Aimé-Vincent Vaudreuil, Dorion,
QC J7V5V5