

# HCF®

## FLEXIBLE ACRYLIC WATER BASE COATING

### DESCRIPTION:

HCF® is a flexible acrylic, water base coating. It's very low V.O.C.'s, non-flammable and high solids content make it an Emission Control Coating System, eccs®, that can be air dried or heat cured to meet production demands.

HCF® can be sprayed, dipped or brushed, is available in a wide variety of colors and exhibits excellent petroleum, chemical, UV, corrosion and abrasion resistance. Typical applications include protecting and color coding transformers, coils, tools, fixtures and brackets, oil handling equipment, heavy machinery, and chain link fence components. HCF® bonds to metal, wood, concrete and plastics without primers. HCF® has the safety of water base with the performance of solvent base coatings. Use HCF® F -688'S' for spray applications.

### SPECIFICATIONS:

Solids: (wt.) 36%

Abrasion: (ASTM D -4060) 0.0005 inches/100 cycles

Tensile: (ASTM D -2370) 1584psi

Weather ability: (ASTM G -53) Excellent 7 -10 years

Permeability: Limited

Temperature use range: -0°F to 250°F.

Viscosity range: 4,000 -10,000cps

Finish: Semi gloss

Shelf life: 1 year at 77°F

Coverage: 100 sq.ft. per gallon at 5 mils

Chemical resistance:

petroleum: Excellent

acid, alkaline: Good

alcohol, ketone, chlorinated solvent: Limited

Ultimate elongation: (ASTM D -2370-82) 280%

Dielectric: (ASTM D -149) 1,100 v/mil

### ALTERNATIVE PRODUCTS:

Contact technical service for alternatives.

**DIRECTIONS: Use Adequate Ventilation. Mix Well Before Use.** All surfaces to be coated must be free of all oils, grease, dirt, wax, and loose rust. A sandblasted or rough surface improves adhesion. Use PLASTI DIP® PRIMER for best results on smooth metal surfaces.



Unit 1 Harvesting Lane  
East Meon  
Petersfield  
Hampshire  
GU32 1QR

**SPRAYING - F-688'S ONLY:** Pressure pot/conventional sprayers may be used. Gently mix before spraying. Apply wet, overlapping coats, holding gun 6" -12" from surface, using a 4" - 6" pattern. Allow to completely dry before applying additional coats to de sired thickness.

**RECOMMENDED EQUIPMENT AND SETTINGS:**

Gun: Binks® model 95  
Nozzle: 63B  
Cap: 63PB or 66SD-3 for heavier build up  
Needle: 663A  
Material: 25psi  
Atomization: 15 -25psi  
Dilution: none required  
Clean up: water, mild solvent if all owed to dry

**Industrial/commercial airless equipment** may be used. Use as described above.

Tip sizes: .011 - .019  
Pressure: as needed  
Dilution: as needed

**DIPPING - F-688 ONLY:** Gently mix before each use. Do not introduce air bubbles. Insert i item 1" every 5 seconds. Remove at same rate. Allow to completely dry before applying additional coats to desired thickness.

**BRUSH/ROLLER - F-688 ONLY:** Gently mix before each use. Apply wet overlapping coats using a foam brush, pad or roller. Allow to completely dry before applying additional coats to desired thickness.

**HINTS:**

For storage or dip tank containers, use only poly or galvanized steel. A dry film thickness of 6 -8 mils is recommended for best results. Allow overnight drying whenever poss ible. To speed drying, mild heat (95°F -110°F) and air flow may be used. Do not stack or store parts in contact with each other if not fully cured. Avoid excessive air movement, heat or humidity. Always use proper ventilation and protection.

## ADDITIONAL APPLICATION IDEAS

Coils  
Transformers  
Tools  
Brackets  
Fixtures  
Oil hanging equipment  
Lapboard siding  
Playground equipment  
Docks  
Heavy machinery  
Chain link fences  
Wrought iron components  
Concrete / Brick  
Plastic  
Steel

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**TECHNICAL DATA SHEET #10**  
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HCF