

HSP-385

Polyester Urethane High Solids Primer

Reduction

If temperature is greater than 70°F / 21°C, reduce with Q160.

If temperature is less than 70°F or 21°C, reduce with Q50.

Non-exempt solvents – Q50, Q160, Q70, etc. will raise VOC. To maintain VOC, use Q30.

Use of Fine Finish tip in airless / air-assisted airless can provide superior atomization and better finish.

Conventional - Reduce 20-30%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Atomization Pressure (PSI)	Fluid Nozzle
Cup Gun	25 – 40" #2 EZ Zahn	N/A	40 – 50	1.4mm – 1.8mm
Pressure Pot	30 – 45" #2 EZ Zahn	20 – 25	40 – 50	1.4mm – 1.8mm

HVLP – Reduce 20-30%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Atomization Pressure (PSI)	Fluid Nozzle
Cup Gun	25 – 40" #2 EZ Zahn	N/A	40 – 50**	1.4mm – 1.8mm

**atomization pressure should read <10 psi at the cap

Air-Assisted Airless - Reduce 15-20%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Atomization Pressure (PSI)	Tip
AA	40 – 60" #2 EZ Zahn	900 – 1300	20 – 40	0.011 – 0.015

Airless – Reduce 5-15%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Tip
Airless	45 – 80" #2 EZ Zahn	1500 – 2200	0.011 – 0.015