

HBE-Series

High Build Epoxy Primer

Reduction

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

If temperature is less than 70°F / 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 15-25%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Atomization Pressure (PSI)	Fluid Nozzle
Cup Gun	30 – 45" #2 EZ Zahn	N/A	40 – 60	1.4mm – 1.8mm
Pressure Pot	35 – 55" #2 EZ Zahn	10 – 20	40 – 60	1.4mm – 1.8mm

HVLP - Reduce 15-25%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Atomization Pressure (PSI)	Fluid Nozzle
Cup Gun	30 – 45" #2 EZ Zahn	N/A	50 – 60**	1.4mm – 1.8mm

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

Air-Assisted Airless - Reduce 5-15%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Atomization Pressure (PSI)	Tip
AA	45 – 70" #2 EZ Zahn	1000 – 1500	25 – 40	0.011 – 0.015

Airless – Reduce 0-10%

Equipment	Spray Viscosity	Fluid Pressure (PSI)	Tip
Airless	14 – 22" #3 EZ Zahn	1700 – 2400	0.012 – 0.015