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PRODUCT DATA SHEET:

Black High Heat Base Coat (HHBK)

PRODUCT DESCRIPTION:

HHBK is a metallic ceramic coating capable of providing extremely high levels of thermal protection in very thin films. When applied to exhaust systems **HHBK** will withstand substrate temperatures of over 2000f. In addition direct flame will not cause delamination as long as substrate temperatures do not exceed this temperature. Due to its unique ceramic nature, the coating also functions as a very effective thermal barrier, with reduced thermal radiation characteristics. Requires a 500f cure with maximum hardness achieved with a 650f cure. After curing the coating requires no burnishing, to be sealed apply one of our clear top coats or another coating such as BLACK SATIN and cure again. The coating cures out to a very hard surface with excellent adhesion. The water based solvent system provides for an environmentally friendly material with a bake/cure cycle that is not as hazardous as other thermally cured resin systems. Has excellent "hiding" characteristics where surface flaws need to be covered. Single coat coverage. **HHBK** is flat black in color, the finished material can be used with a clear top coat to achieve a semi-gloss appearance.

RECOMMENDED USES:

Base coat for BHK, TXBK, CGBK, and other high heat top coats.

NOT RECOMMENDED FOR:

Materials that cannot endure the cure temperature. Magnesium.

APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. Those instructions should be followed closely to obtain the maximum service from the materials.

SURFACE PREPARATION: All parts must be absolutely free of all oils, grease, moisture, dust, scale or corrosion.

METALS: For steel, sandblast with 80-100 grit aluminum oxide or similar. Softer metals, such as aluminum, use 100-120 grit aluminum oxide or similar at 35-40 PSI using a suction type blaster.

*NOTE: Phosphating may be performed in lieu of sandblasting or in conjunction with the above mechanical etch.

FINAL CLEAN: Before spraying the part must be thoroughly cleaned using air blast, hot water rinse, solvent base rinse, DO NOT USE any method that does not provide a clean dry surface.

MIXING: Stir and shake well. Disperse all solids that may have settled to the bottom of the container.

SPRAY: Apply coating in light fog passes (approximately 10% overlap) to achieve a thickness of .001" to .002". Use sufficient air volume for correct operation of equipment. (Minimum 40 PSI to a maximum of 65 PSI) Minimum part temperature should be 70f, if below warm up part. Spray at a right angle to part with a 1mm or smaller nozzle size.

GUN & Mfr.: Any conventional unit. Recommended gravity feed type touch-up gun.

DRYING TIME: Allow coating to air dry completely before baking.

FINAL CURE: As soon as the coating is dry, 500f for 1 hour at temperature. Uncured dry parts can absorb moisture from the air, cure the parts as soon as they are dry.

Top Coating:

Top coat with the desired coating after the base coat of HHBK has been cured. No additional etching will be required as the HHBK is porous and absorbs the top coat into itself. Make sure of full coverage of the top coat and then follow the curing instructions for the top coat.

VENTILATION AND SAFETY: When used in enclosed areas, thorough air circulation must be provided during and after application until the coating is cured. The ventilating system should be capable of preventing fine particulate matter from exceeding TLV limits. In addition to proper ventilation, fresh air respirators or fresh air hoods must be used by all application personnel.

CLEAN UP: Water

STORAGE CONDITIONS: (Store indoors)

Temperature: 10-43°C Humidity: 0-100%

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Note: N/E = Not Established
N/A = Not Applicable