



HBEF Self-etching Metal Treatment

74 780SP

Matthews' HBEF is a light-toned, two-component, self-etching metal treatment surfacer.

It provides excellent paint adhesion and corrosion resistance while providing superior filling properties to metal surfaces, and only metal surfaces.



Features:

- 1 to 1 Reduction
- 14 Day Potlife
- Self Etching

Benefits:

- Easy Mixing Ratio
- Great Adhesion Over Bare Metal

Compatible Surfaces:

HBEF 74 780SP may be applied directly over:

- Sanded Aluminum
- Sanded Steel

Required Products:

74 781SP HBEF Activator

74 780SP

Directions for Use

Surface Preparation:

- Wipe/clean substrate using 45 330SP Speed Prep Cleaner (refer to MPC111 Technical Bulletin) or 6405SP Low VOC Cleaner (refer to MPC172 Technical Bulletin).
- Do not allow to air-dry.
- Remove any residue with clean, lint free cloth.
- *All surfaces must be free of oil, grease or any other contaminants prior to coating.*
- *Aluminum and carbonated steel must be primed immediately after cleaning.*

Mix Ratios:



Mix Ratios (by volume)

74 780SP HBEF	74 781SP HBEF Activator
1 part	1 part



- Always thoroughly mix and strain activated material prior to use.
- Store mixed materials in an acid resistant plastic container.
- Pot life is 14 Days

Additives:



None required, but the following may be used for specific application or project needs:

- 45 127SP Pre-treatment Retarder, up to 5% (6oz./gallon) by volume, may be added for use in very hot and humid weather.
- *No other additives or reducers should be used in 74 780SP.*

Spray Set Up:



Air Pressure:

Conventional:	55 - 60 psi at the gun
HVLP:	10 psi at cap
Pot Pressure:	15 - 18 psi

Gun Set Up:

Siphon Feed:	1.3 mm 0.050 fluid tip
HVLP:	1.3 mm 0.050 fluid tip
Pressure Pot:	1.2 mm 0.046 fluid tip

Application:



Apply: 2 to 3 full wet coats
Flash 3 - 5 minutes between coats

Recommended
Wet Film Thickness: 5.0 - 7.0 mils per coat

Recommended
Dry Film Thickness: 1.0 - 2.0 mils

Do not exceed 2.5 mils DFT

Directions for Use

Drying Times:



Dry Times at 70°F (21°C)	
Dust Free	30 - 45 minutes
Dry to Handle	60 - 90 minutes
Tack Free*	60 minutes
Tape Free	16 hours

*74 780SP/74 781SP HBEF may be sanded or topcoated when tack-free

Note: A finish coat must be applied before exposing HBEF to weather

Equipment Cleaning:

Clean equipment promptly with an all-purpose clean up solvent or any compliant general cleaner.
Do not leave mixed material in equipment.

Technical Data:

VOC Information Package

74 780SP HBEF	5.42
74 781SP HBEF Activator	6.66
Ready to Spray (1:1)	6.04*

* Local regulations may exempt limited use of acid activated metal treatments from VOC considerations

Performance Characteristics

Volume solids	22.5%
Volume solids RTS	6.4%
Theoretical Coverage (1.5 mils @ 100% Transfer efficiency)	102 sq.ft./gal.
Application Conditions	55°F (13°C) Min. 100°F (38°C) Max.
Relative Humidity	85% Max. 5°above dew point
Flash Point (Tag closed cup)	53°F (12°C)

74 780SP

HBEF
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Important:

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION - US (412) 434-4515; CANADA (514) 645-1320; MEXICO 01-800-00-21-400

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Matthews Paint. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Matthews Paint warrant freedom from patent infringement in the use of any formula or process set forth herein.

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