Technical Data Sheet

Product	**HGA1x SheenSeries**									
Description	Clear water-based top-coats									
Color	Clear									
Chemical-physical Properties										
CODE	**Density (Kg/l)**			**Density (lb/US gal)**			**Solid content %**			
HGA10	1,030	±	0,030	8,6	±	0,3	31,4	±	2	
HGA11	1,029	±	0,030	8,6	±	0,3	32,2	±	2	
HGA12	1,028	±	0,030	8,6	±	0,3	31,6	±	2	
HGA13	1,031	±	0,030	8,6	±	0,3	32,3	±	2	
HGA14	1,034	±	0,030	8,6	±	0,3	32,6	±	2	
HGA16	1,037	±	0,030	8,7	±	0,3	33,7	±	2	
HGA17	1,050	±	0,030	8,8	±	0,3	36,4	±	2	
	Viscosity (Ford 6 cup)			45	±	4				
USAGE INDICATIONS										
The product, after careful mixing, is ready to use										
READY TO USE PRODUCT PROPERTIES (AVERAGE)										
Code/Sheen	**CODE**			**Sheen level EN ISO 2813 (angle measurement 60°)**						
				applied micron:	150					
				Wet Mils:	5,9					
	HGA10			**Sheen**	78	±	5			
	HGA11			**Sheen**	60	±	4			
	HGA12			**Sheen**	48	±	3			
	HGA13			**Sheen**	30	±	2			
	HGA14			**Sheen**	20	±	2			
	HGA16			**Sheen**	10	±	1			
	HGA17			**Sheen**	5	±	1			
Application				**Quantities**						
	Airmix spray			**gr/m² min-max:**	110	-	140			
				Wet Mils min-max	4,2	-	5,4			
	Hand spray			**gr/m² min-max:**	110	-	140			
				Wet Mils min-max	4,2	-	5,4			

PRODUCT PROPERTIES AFTER APPLICATION					
Drying					
	Room temperature drying (18-22°C / 64 – 72°F e 65-70% relative humidity) complete drying	40 h			
	Dust free	40 min			
	Touch dry	55 min			
	Hard dry	4 h			
	Stackable after room temperature drying	24 h (with spacers)			
	Laminar flow cabinet drying	Temp°C	35		
		Temp°F	95		
		Air speed m/sec	1,5		
		Air speed ft/sec	4,9		
		120 min			
	Stackable after jet hot air drying	4 h (with spacers)			
Additional products		Quantities			
Hardener	HNB3	In weight w/w %		10	
		In volume v/v %		9,8	
	Solid content %	69,0	±	2	
READY TO USE PRODUCT PROPERTIES (AVERAGE)					
	Solid content 1st + 2nd component (%)	34,8	±	2	
	Pot-Life - mixture (maximum pot-life of the product prepared according to usage indications)	3 h			
	Viscosity (Ford 6 cup)	55	±	4	
Code/Sheen	CODE	Sheen level EN ISO 2813 (angle measurement 60°)			
		applied micron:	150		
		Wet Mils:	5,9		
	HGA10	Sheen	80	±	5
	HGA11	Sheen	65	±	4
	HGA12	Sheen	50	±	3
	HGA13	Sheen	30	±	2
	HGA14	Sheen	22	±	2
	HGA16	Sheen	10	±	1
	HGA17	Sheen	5	±	1
Application		Quantities			
	Airmix spray	gr/m² min-max:	110	-	140
		Wet Mils min-max	4,2	-	5,3
	Hand spray	gr/m² min-max:	110	-	140
		Wet Mils min-max	4,2	-	5,3

PRODUCT PROPERTIES AFTER APPLICATION						
Drying						
	Room temperature drying (18-22°C / 64 – 72°F e 65-70% relative humidity) complete drying	48 h				
	Dust free	50 min				
	Touch dry	65 min				
	Hard dry	5 h				
	Stackable after room temperature drying	24 h (with spacers)				
	Laminar flow cabinet drying	Temp°C	35			
		Temp°F	95			
		Air speed m/sec	1,5			
		Air speed ft/sec	4,9			
		120 min				
	Stackable after jet hot air drying	4 h (with spacers)				
Additional products		Quantities				
Properties	Non flammable hardener					
Hardener	HNB40	In weight w/w %	10			
		In volume v/v %	9,6			
	Solid content %	70,0	±	2		
READY TO USE PRODUCT PROPERTIES (AVERAGE)						
	Solid content 1st + 2nd component (%)	34,9	±	2		
	Pot-Life - mixture (maximum pot-life of the product prepared according to usage indications)	2 h				
	Viscosity (Ford 8 cup)	40	±	3		
Code/Sheen	CODE	Sheen level EN ISO 2813 (angle measurement 60°)				
		applied micron:	150			
		Wet Mils:	5,9			
	HGA10	Sheen	85	±	5	
	HGA11	Sheen	70	±	4	
	HGA12	Sheen	55	±	4	
	HGA13	Sheen	35	±	2	
	HGA14	Sheen	25	±	2	
	HGA16	Sheen	15	±	1	
	HGA17	Sheen	5	±	1	

Application		Quantities				
	Airmix spray	gr/m² min-max:	110	-	140	
		Wet Mils min-max	4,2	-	5,3	
	Hand spray	gr/m² min-max:	110	-	140	
		Wet Mils min-max	4,2	-	5,3	
PRODUCT PROPERTIES AFTER APPLICATION						
Drying						
	Room temperature drying (18-22°C / 64 – 72°F e 65-70% relative humidity) complete drying	48 h				
	Dust free	50 min				
	Touch dry	65 min				
	Hard dry	5 h				
	Stackable after room temperature drying	24 h (with spacers)				
	Laminar flow cabinet drying	Temp°C	35			
		Temp°F	95			
		Air speed m/sec	1,5			
		Air speed ft/sec	4,9			
		120 min				
	Stackable after jet hot air drying	4 h (with spacers)				
Additional products		Quantities				
Properties	Hardener useful to reduce COV values during application (<50g/L)					
Hardener	HNB6A16	In weight w/w %				10
		In volume v/v %				9,4
	Solid content %	99,9	±	2		
Thinner	Water	In weight w/w %				5
		In volume v/v %				5
READY TO USE PRODUCT PROPERTIES (AVERAGE)						
	Solid content 1st + 2nd component (%)	37,6	±	2		
	Pot-Life - mixture (maximum pot-life of the product prepared according to usage indications)	2 h				
	Viscosity (Ford 8 cup)	50	±	4		

Code/Sheen	CODE	Sheen level EN ISO 2813 (angle measurement 60°)			
		applied micron:	150		
		Wet Mils:	5,9		
	HGA10	Sheen	85	±	5
	HGA11	Sheen	70	±	4
	HGA12	Sheen	55	±	4
	HGA13	Sheen	35	±	2
	HGA14	Sheen	25	±	2
	HGA16	Sheen	15	±	1
	HGA17	Sheen	5	±	1
Application		Quantities			
	Airmix spray	gr/m² min-max:	110	-	140
		Wet Mils min-max	4,2	-	5,3
	Hand spray	gr/m² min-max:	110	-	140
		Wet Mils min-max	4,2	-	5,3

PRODUCT PROPERTIES AFTER APPLICATION			
Drying			
	Room temperature drying (18-22°C / 64 – 72°F e 65-70% relative humidity) complete drying	48 h	
	Dust free	50 min	
	Touch dry	75 min	
	Hard dry	5 h	
	Stackable after room temperature drying	24 h (with spacers)	
	Laminar flow cabinet drying	Temp°C	35
		Temp°F	95
		Air speed m/sec	1,5
		Air speed ft/sec	4,9
		120 min	
	Stackable after jet hot air drying	4 h (with spacers)	
Shelf life	12 months after production		
SPECIFIC WARNINGS	If required, thin with water up to 5% (maximum) Water-based products viscosity values tend to alter during storage The value indicated in this technical data sheet is the one measured during quality control		

WARNINGS

In a coating process with professional products:

- besides the product quality, the final result also depends on numerous other variables, such as environmental conditions; homogeneity in the quality of the support; the constancy of the application cycle; the plants performance; the proper use of the product, etc.
- in the process of industrial coating a certain waste of product is to be considered normal and therefore not attributable to product quality
- The final colour is influenced by quality and the preparation of the support and the conditions of application, for this reason it is essential to check in advance the result in terms of final use

Our Company cannot ensure the control of the coating process carried out by the user. We cannot, therefore, take on any responsibility for the final result achieved through the use of our products.
On the other hand, we guarantee the consistency of the chemical and physical characteristics of the product indicated in the relevant Technical Data Sheet, pledging to replace it if it does not correspond to the declared features
Data on the chemical and physical characteristics of the product are recorded at 20°C / 68°F and 70% R.U.

For best results, the optimum conditions of application are:

- Ambient temperature between 18 and 22°C (64 - 72 °F)
- ambient relative humidity between 65 and 70%
- support humidity between 8 and 14%

The conditions to be observed scrupulously are:

- Water-based products are particularly sensitive to storage conditions: temperatures below 5 °C / 41°F and above 35 °C / 95°F may affect the product, characteristics, making it unusable. For this reason, a water-based product should be stored indoors at temperatures not below 5 °C / 41°F and not above 35 °C / 95°F, in a properly ventilated place, not exposed to solar radiation
- Always shake the products well before use
- Before use, always shake well the product mixed with any other components such as catalysts, accelerators, thinners
- The application must not take place at a temperature lower than 15 °C / 59°F or above 30 °C / 86°F
- The drying should not take place at a temperature below 15 °C / 59°F
- The ambient relative humidity during drying should be between 50% and '70%
- To decant paints, exclusively use containers made of suitable material, such as polyethylene and stainless steel
- After use, we recommend that you always close the can carefully

The end result of the coating cycle is the sole responsibility of the users, who must make sure that the product matches their needs and that environmental conditions, application or media specifications do not require substantial changes of use

It is the user's responsibility:

- Adhere to the conditions indicated above
- comply with the rules of hygiene and safety during product application, according to the descriptions given in the safety data sheets
- for solvent-based products spark-proof equipment should be used
- It is forbidden to smoke while using the product

At the bottom of each sheet there is a date of validity
The Company invites you to check with their staff that the product data sheet in your possession is the most updated, since the characteristics of the products are subject to adjustments over time
For more information, please contact (see below):

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