

Application Guide

HS-1450 Insulating Coating for Aerospace and Industrial uses

- Clean-up _____ with water while a wet liquid
- Application temp. _____ 60°F to 110°F
- Storage temp. _____ Do not allow to freeze
- Shelf life _____ One year un-opened container
- Est. Coverage _____
 - 625 sq/ft/gal @ 2 mil / 58.1 sq/m 3.79 liter @ 0.5 mm
 - 30 sq/ft/gal @ 40 mil / 2.8 sq/m 3.79 liter @ 1 mm



The surface must be: dry and free from grease, dirt or rust. Light sanding could aid in increased adhesion in most cases.

Note! Applying over foam, cork, vinyl, or rubber mats, etc. is not recommended.

Dry time: at room temperature is approximately 30 minutes to 1 hour, (dependent on layer thickness and the relative humidity) but the time can be reduced by use of a warm air flow (110°F max) Warning using space heater or similar equipment tend to raise the relative humidity, which will tend to slow or increase the dry time. Colder air or surface temperatures will also increase dry time.

Curing process: is a 2 (two) step process, the water dissipates from the applied coating during the first period of time, allowing the material to become dry to the touch, at this point the internal chemistry starts a reaction the initiates the 2nd curing step over the next 24 to 48 hrs

Application Equipment: Easy application with and by spray, plastic spreader tool, brush or roller.

Coating application thickness: maximum performance is seen with the product when applied at an approximate 40-50 mil thickness. If a specific thickness differs from this, as always, testing to be sure the resulting properties achieve the desired properties is strongly suggested.

Best results will come from applying several 10-12 mil coating layers vs. 1 or 2 thicker coating applications to achieve the desired thickness.

Drying & curing time will increase as each coating thickness increases.

Several thin coats are always better.

Note! - Applying a second or third coat over a half or partially cured previous coating may cause blisters, delamination or failure of the coating, as a result of expansion of entrapped moisture or other vapors within the coating layers, (i.e.; at elevated temperatures).

- **Mixing:** always use a low speed mixer blade (“Jiffy Mixer” or similar) or stir stick.
Product will appear to be a thick semi-dry material, once mixing is initiated it should start to liquefy.
If the consistency is too viscous for a specific application method; to achieve desired viscosity add, small amounts of filtered or distilled water until desired consistency is achieved.
Always keep the container closed when not in use as evaporation will take place, thickening the product quickly.

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HS-1450 Continued:

- **Application options:**
 - Brush or Plastic spreader:** when using a nylon bristle brush or plastic spreader, use short strokes applying a thick 10-12 mils per coat. Resist using a “back and forth” brush motion as this will tend to thin out the coating thickness.
- **Spray application options:**
 - Use of a pressure pot system,** such as Binks 2001 spray gun with a large orifice (tip of 565, air nozzle of 66SD, a fluid nozzle of 66SS or a gel tip) Use about 30-35 psi at the pressure pot. Hold the gun tip approx. 14” from the surface, this should allow for a 10-12 mil coating thickness to be applied per coat.
- **Roller application:** use a thin foam roller; use a slight to little down pressure to achieve the 10-12 mil product thickness. Back brushing with a fine bristle brush maybe used if needed to lay down any stippling left behind by the roller, if it is not desired.