

HB48 Primer

Information Sheet

Version 1 7 February 2023

HMG HB48 Primer is an alkyd based, quick drying primer offering outstanding adhesion, moisture resistance and corrosion protection due to incorporation of modified Zinc Phosphate.

Suitable for use to suitably prepared structural steel, chassis, steel fabrication by airless or conventional spray. Easy to apply, at high wet film thickness without fear of runs or sags.

- Suitable under HMG QAD Enamel.
- Quick drying
- Available in Black, Buff, Lt Grey, Dk Grey, Red Oxide, and White.
- Coverage: 10m² per ltr at 55 microns DFT
- Touch dry: 20 – 30 mins at 20°C
- Thinner: HMG 2621

Manufactured under the auspices of an ISO 9001 management system.

Information

Theoretical Coverage (approx) at 20 microns DFT	10m ² per Litre	Number of Coats (Guide Only)	1 - 2 Coats
Drying time at 20°C (May vary with film build and temperature)	Touch Dry - 20 - 30 mins Hard Dry - 3 Hours Full Dry - 24 Hours	Application	Compliant or Airless
Suggested Primer	N/A	Spray Gun Setup	Compliant 1.8 - 2.0 Airless 13-15 Thou 40/50°
Thinner	2621	Wet Film (WFT)	70-220 microns
Thinning	Compliant Spray up to 5% Airless RFU	Dry Film (DFT)	39-121 microns
Flash Point	38°C	Pot Life	N/A
Volume Solids	55%	Recoat / Overcoat	After 1 Hour at 20°C
Maximum VOC (RFU)	<450g/l	Finish	N/A
Regulation / Compliance		Available Pack Sizes	5L, 15L & 20L

Important Information Before Use

Read and follow SDS, TDS, and label instructions. Stir paint thoroughly before use. Always use the same batch number on the same job. Check colour and sheen, HMG will not accept any discrepancies arising after use. Filter the product immediately before use. Reduce emissions and maintain quality by replacing tin lid after use. If in doubt, contact HMG Technical Service Department on 0161 205 7631.

Substrates

HMG HB48 Primer is suitable as a primer coat for suitably prepared metals, clean and free of grease, oils and other contaminants. Not suitable for coating over bitumen or chlorinated rubber coatings.

Application Climate

Substrate temperature should be 5°C or above for application and during cure, and a minimum of 3° above the dew point. Adequate dry air ventilation should be supplied during drying.

Application Information

Thinning should only take place after material is thoroughly mixed. Application and use should always conform with the codes of practice described in BS 6150 and BS 5493.

Surface Preparation

Ensure surfaces are clean, dry and free from grease, oils, dust and other contamination prior to application. Thoroughly clean and degrease using suitable HMG Prep Clean 2802, 2803 or 2804.

Rust/corrosion to be removed to Sa or St standards, remove to clean metallic appearance with little or no rust/corrosion present. Areas where blast cleaning is not cost effective or practical, then the use of Ferrozinc is an alternative. Though Ferrozinc is not an equivalent alternative to shot blasting, it does offer a far superior performance than conventional coatings applied to slightly rusted surfaces. FERROZINC is used after simple wire brushing to remove surface rust, prior to application of primer.

General Specification

Bare Substrates

Mild Steel – Remove millscale and thoroughly degrease using suitable HMG Prep Clean. Abrade with P80 – P180 if necessary, prior to application of primer.

Shot Blasted Steel – Remove all traces of blast grit/sand prior to application of primer.

Aluminium – Abrade with P180 – P320, degrease with suitable HMG Prep Clean prior to application of primer.

Galvanised Steel – Degrease with suitable HMG Prep Clean, apply HMG Mordant Wash, apply HMG Etch Primer and if required HMG Primer.

Previously Painted

High pressure wash to remove all loose debris and poorly adhered previous coatings to remove all salts and other contaminants.

Degrease using suitable HMG Degreaser 2800 to remove grease and oils not removed with pressure washing alone.

Existing coatings to be well adhered with all edges tight and well feathered. Rust/corrosion to be removed back to clean metallic appearance.

Abrade to provide good adhesion.

Wipe over with degreaser to remove loose debris from abrasion.

Substrate to be clean, free of grease, oils, dust and completely dry prior to application.

For full surface preparation please refer to our web site for Knowledge Base article Prep Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide. If in doubt speak to HMG Technical Department on 0161 205 7631.

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Health And Safety

Refer to SDS and tin label prior to use. Suitable respiratory equipment should be worn when spraying. Contaminated rags, spray booth filters or other substrates should be segregated from other chemical waste, soaked with water or disposed of in a non-combustible container with tight fitting lid.

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use For professional use only.