



HIGH TECK TECHNICAL DATA SHEETS

1K PRIMER/SEALER NR/SC COMPLIANT

HIT.77750-1(4) Black
HIT.77751-1(4) White
HIT.77752-1(4) Grey
HIT.77753-1(4) Red

Description

HIT 77750 Series 1K Sealer is a 1K low VOC, high performance Sealer with built in corrosion resistance and excellent adhesion onto properly prepared hot or cold roll steel and over properly prepared 2K painted surfaces. It is available in black, white, gray, and red.

Suggested Uses

As a wet on wet sealer or primer surfacer.

Over hot roll or cold roll steel, fiberglass and sanded 2K coatings where:

- High level of corrosion resistance is needed.
- Excellent adhesion is needed.
- High productivity is required.
- Excellent performance when applied with airless, air-assist airless, airless, pressure pot, cup gun, brush or rolled.

Components

- #77750-1(4) 1K Sealer Black
- #77751-1(4) 1K Sealer White
- #77752-1(4) 1K Sealer Gray
- #77753-1(4) 1K Sealer Red

Field Applications

- Structural steel
- Work panel trucks
- Trailers and frames
- Construction equipment
- Many OEM applications
- Oil Field Equipment



Mixing Ratio

77750 Series 1K Sealers are pre-reduced and ready-to-spray (RTS)

Application

Apply:	One to two medium wet coats, allow 5-10 minutes flash between coats.	
Spray Gun:	HVLP Gravity Feed	1.4 – 1.7mm tip and needle
	Pressure Pot HVLP	1.0 – 1.2mm tip and needle
	Air Assist Airless	1.0 – 1.2mm tip and needle
	Conventional	1.5 – 1.8mm tip and needle
	Airless	310 – 610 – 313 – 613 nozzle
Film Build:	50-75 microns	(2.0 – 3.0 mils.)



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Dry Times

Dust Free: 20-30 minutes @ 20° C (68° F)
Dry to Topcoat: Force 30-45 minutes @ 20° C (68° F)
Dry: 30 minutes @ 60° C (140° F) light sanding needed.

Surface Preparation

Ferrous metals: Best

Case Sandblast - Blow all dust and contaminates off and apply primer within 8 hours.
Second Best Case Hot Phosphate wash system, blow dry and apply primer. Within 8 hours.
Third Best Case Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply primer within 4 hours.

Aluminum: Only if suitable Epoxy Primer is applied first

Galvanized Steel: Only if suitable DTM Primer is applied first.

VOC

Regulatory VOC Actual	BLACK	WHITE
VOC	535.56 g/l (1.98 lbs / gl) 476.05 g/l (3.97 lbs /gl)	546.59 g/l (4.56 lbs / gl) 485.85 g/l (4.05 lbs /gl)
	GRAY	RED
	536.47 g/l (4.48 lbs / gl) 480.66 g/l (4.01 lbs /gl)	536.91 g/l (4.48 lbs / gl) 477.26 g/l (3.98 lbs /gl)

Solids

By Volume **Black** 32.41% **White** 31.47% **Gray** 32.92% **Red** 31.63%
By Weight **Black** 49.99% **White** 52.09% **Gray** 52.78% **Red** 48.28%

Specific Gravity **RANGE** from 1.07 kg/l (9.24 lbs./gl.) to 1.21 kg/l (10.12 lbs/gl)

Coverage 304.86 square feet per gallon @ 100% transfer efficiency @ 50 microns (2 mils.) 28.3 square meters per gallon @ 100% transfer efficiency @ 50 microns (2 mils)

Repainting After 24 hours @ 20° C (68° F) light sanding needed.

Storage Stability One year, stored in closed package, in cool dry place, away From any sources of heat.

All technical advice, recommendations and services are rendered by the seller gratis. They are based on technical data which they believe to be reliable, and are intended for use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for the results obtained or damages incurred from their use by Buyer in whole or part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.