

hydraBOND®

New!

500
Series



Introducing the New! 500 Series Low VOC 2K Urethane Primers and Hardeners

Discover the Innovation: hydraBOND® 500 Series Low VOC 2K Urethane Primer/Surfacer

The hydraBOND® team is excited to unveil the 500 Series Low VOC 2K Urethane Primers and Hardeners, a line of advanced coating solutions crafted to exceed the performance needs on a variety of surfaces. At the heart of this launch is the HB520 Low VOC 2K Urethane Primer/Surfacer, designed for professionals seeking superior adhesion, ease of sanding, and a high-build formula. Accompanied by a selection of hardeners tailored for varying project requirements, this series promises to revolutionize the way you approach surface preparation and finishing.

Advantages and Application

- **Adaptability and Performance:** The HB520 primer ensures that every surface, whether steel, aluminum, iron, or fiberglass, is perfectly prepared for the next layer, offering unparalleled adhesion and surface smoothness.
- **Tailored Mixing and Drying:** Depending on the project's specifics and ambient conditions, select the hardener that best fits your timeline and work process, adjusting the mix ratio for ideal application and curing times.
- **Surface Prep Made Easy:** A well-prepared surface is crucial for the success of any painting project. The HB520 series emphasizes the importance of cleanliness and proper preparation to achieve a flawless finish.

Scan QR code to see TDS on the:
New! 500 series Low VOC
Value Refinish System Solvent System



Scan QR code to see TDS for:
New! HB520 Low VOC
2K Urethane
Primer/Surfacer



hydraBOND® 500 Series Low VOC 2K Urethane Primer and hardener.

HB520 Low VOC 2K Urethane Gray Primer-Surfacer

- -Part Number: HB520
- -Packaging: 1 Gallon per can, 4 cans per case
- -Weight per Case: 44 lbs (20 kg)
- -Case Dimensions: 13.5"x13.5"x7.75"
- -VOC: Regulatory VOC: 238.3 g/l (1.98 lbs./gl.)
- -Actual VOC: 131.3 g/l (1.09 lbs./gl.)
- -Solids: By Volume: 51.7%, By Weight: 40.6%
- -Specific Gravity: 1.51 kg/l (12.66 lbs./gl.)
- -Coverage: 304.86 square feet per gallon @ 100% transfer efficiency @ 50 microns (2 mils))



HB521 Low VOC Fast Hardener

- -Part Number: HB521
- -Packaging: 1 Quart per can, 4 quarts per case
- -Weight per Case: 8 lbs (3.6 kg)
- -Case Dimensions: 7"x7"x8"



HB522 Low VOC Medium Hardener

- -Part Number: HB522
- -Packaging: 1 Quart per can, 4 quarts per case
- -Weight per Case: 9 lbs (4 kg)
- -Case Dimensions: 7"x7"x8"



HB523 Low VOC Slow Hardener

- -Part Number: HB523
- -Packaging: 1 Quart per can, 4 quarts per case
- -Weight per Case 10 lbs (4.53 kg)
- -Case Dimensions: 7"x7"x8"



GENERAL GUIDELINES FOR USE

- -Preparation: Surface must be clean, dry, and properly prepared.
- -Mixing Ratios: Primer to hardener at 4:1. For sealer, mix at 4:1:1 with appropriate reducer.
- -Application: Apply in well-ventilated areas with suitable protective gear.
- -Repainting: Light sanding required after 24 hours at 20°C (68°F) before repainting.

These specifications provide a comprehensive overview of the hydraBOND® 500 Series Low VOC 2K Urethane Primer and its associated hardeners, including details on packaging, VOC content, and application guidelines. For more information: Please read the TDS and SDS

hydraBOND® 500 Series Low VOC 2K Urethane Primer and hardener.

Hardeners for Every Need

- HB521 Low VOC Fast Hardener 2.1 VOC (Quart 32oz)**: Speeds up drying times for rapid project progression.
- HB522 Low VOC Medium Hardener 2.1 VOC (Quart 32oz)**: Provides a perfect balance of workability and efficiency.
- HB523 Low VOC Slow Hardener 2.1 VOC (Quart 32oz)**: Allows extended work time for detailed or high-temperature projects.

Best Practices for Storage and Safety

Maintaining the integrity of your products is as important as the application process itself. Store your HB520 series products in a controlled environment and adhere to all recommended safety guidelines to ensure not just the quality of your work, but also the well-being of those involved.

This introduction aims to spotlight the hydraBOND® 500 Series as a cornerstone in surface preparation and finishing technologies, with the HB520 Low VOC 2K Urethane Primer/Surfacer leading the charge towards achieving superior finishes across a multitude of surfaces..

These specifications provide a comprehensive overview of the hydraBOND® 500 Series Low VOC 2K Urethane Primer and its associated hardeners, including details on packaging, VOC content, and application guidelines. For more information: Please read the TDS and SDS

Description: HB520 is a 2K high build, high production acrylic urethane primer with excellent hold out and easy to sand properties. Light gray color makes it easy to achieve opacity with a minimal number of coats.

Suggested Uses: As a wet on wet sealer or a full-bodied sandable primer, where body repair, scratches or imperfections

- Minimal shrinkage is desired
- Excellent sandability and hold out are needed
- High productivity is required
- Components: HB520 Primer
- Hardener: HB521/HB522/HB523 Fast/Medium/Slow Hardener
- Reducer" HB771/HB772/HB773: Reducer Fast/Medium/Slow Reducer

•Mixing Ratio: 4:1

- As a primer: Mix four (4) parts HB520 Primer to one (1) part selected hardener (4:1)
- As a sealer: Mix four (4) parts HB520 Primer to one (1) part selected hardener to 25-35% selected reducer (4:1:25-35%)

•Application:

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

*****Note there is a minimum*** Please contact your distributor for Special Orders!**

Scan QR Code
To Download SDS



Technical Data Sheet

HB520

**Low VOC 2K Urethane
Primer/Surfacer**

01102025.HB520.TDS

Description: HB520 is a 2K high build, high production acrylic urethane primer with excellent hold out and easy to sand properties. Light gray color makes it easy to achieve opacity with a minimal number of coats.

Suggested Uses: As a wet on wet sealer or a full-bodied sandable primer, where body repair, scratches or imperfections need to be filled.

Best if used when :

- Minimal shrinkage is desired
- Excellent sandability and hold out are needed
- High productivity is required.

Components:

HB520	Primer
HB521/HB522/HB523	Fast/Medium/Slow Hardener

Mixing Ratio:

As a primer:	Mix four (4) parts HB520 Primer to one (1) part selected hardener (4:1)
As a sealer:	Mix four (4) parts HB520 Primer to one (1) part selected hardener to 25-35% selected reducer (4:1:25-35%)

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

Film Build: 50 - 100 microns (2.0 - 5.0 mils.) when applied as directed

Dry Times:

Dust Free:	10 minutes at 68°F (20°C)
Dry to Touch:	
Dry to Sand:	
Force Dry:	

VOC:

Regulatory VOC:	577.68 g/l (4.82 lbs/gl)
Actual VOC:	579.4 g/l (4.8 lbs/gl)

Technical Data Sheet

HB520

**Low VOC 2K Urethane
Primer/Surfacer**

01102025.HB520.TDS

Solids: **By Volume:** **33.80%**
 By Weight: **55.60%**

Specific Gravity: 10.9 lbs/gal (1.3 kg/l)

Coverage: 280 square feet per gallon at 100% transfer efficiency, 50 microns (2 mils) (26.1 square meters per gallon at 100% transfer efficiency, 50 microns (2 mils))

Repainting: **After 48 hours @ 68°F(20°C) light sanding is needed**

Storage Stability: One year stored in closed package, in a cool and dry place, away from any heat source.

Surface Preparation:

Ferrous Metal:

Best Case: **SA2 sandblast Blow all dust and contaminants off and apply epoxy primer within 8 hours. Allow epoxy primer to fully cure then sand before applying HB520 primer.**

2nd Best Case: **Hot Phosphate wash system, blow dry and apply epoxy primer within 8 hours.**

2nd Best Case: **Careful mechanical abrasion. Clean dust, oil, residue, finger prints and contaminants before and after mechanical abrasion with a clean drying residue is removed. Then apply epoxy primer within 4 hours. Allow epoxy primer to fully cure then sand before applying HB520 primer.**

Aluminum: **Sand surface, then clean surface with clean drying wax and grease Remover, apply epoxy primer and let flash fully as per TDS, then apply HB520 primer.**

Galvanized Steel: **Clean all dust, oil residue, and contaminants from surface using a Clean drying wax and grease**

remover, light sanding (320P grit) Clean again with clean drying wax and grease remover using a wipe process. Apply epoxy primer let flash as per TDS then Apply HB520 primer.