



Product Bulletin

technicalservice@hubbardhall.com

P.O. Box 790 • Waterbury, CT 06720-0790 • Tel: (203) 756-5521 • Fax: (203) 756-9017
P.O. Box 969 • Inman, SC 29349-0969 • Tel: (864) 472-9031 • Fax: (864) 472-2117

HUBLAC A

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HUBLAC A is a water base coating formulated to form a clear coating on metal fabrications (plated or unplated) such as zinc, brass, copper, cadmium or silver.

HUBLAC A may be applied on the fabrications by either immersion or spray. The **HUBLAC A** coating may be air-dried. For rapid drying, oven dry at 160-180F.

FDA STATUS

HUBLAC A meets the requirements of CFR 21, subchapter B, subparts.

TSCA COMPLIANCE

HUBLAC A complies with the toxic substances control act PL 94-469.

HUBLAC A will dry to a clear, abrasive resistant coating which will also provide resistance to humidity, salt spray and hydrogen sulfide corrosion. The **HUBLAC A** coating will provide finger print protection which is a problem when the parts are being assembled or packed.

ADVANTAGES

- Inhibited to prevent discoloration or corrosion of brass and copper
- Combustible, rather than flammable
- Corrosion and abrasive resistant
- Non-blushing, even in a humid atmosphere.
- Non-bridging, coats intricate parts and filigrees
- Economical to use, coverage ranges from 700 to 1160 square feet per gallon of concentrate
- Dries to a water-resistant coating. Will not water spot.
- Work may be stripped in an alkaline cleaner, Cleaner 159 (8 oz/gal, 160-180F)
- Flexible coating

TYPICAL APPLICATIONS

Tubular Furniture	Bezels – Clocks
Strip and wire goods	Control devices, etc.
Appliances parts	Luggage hardware
Jewelry	Architectural hardware

NOTE: All of the work must be cleaned to a no water break surface to insure removal of all organic soils before work is immersed or sprayed with a **HUBLAC A** solution. Improper cleaning will lead to poor or no adhesion of the **HUBLAC A** solution.

OPERATING CONDITIONS

IMMERSION APPLICATIONS

Concentration Range: 40 to 100% (Volume) – an average range of 40 to 60% (Volume) for wire goods.

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Drying Temperature: Room temperature to 180F (82C)

Drying Time: 5 to 9 minutes at 180F. Bulk work may be dried in a centrifugal spin drier (room or elevated temperature).

ROOM TEMPERATURE DRYING will require 30 to 60 minutes – depending on the concentration of the **HUBLAC A** solution.

Immersion Time: 15 to 30 seconds

Operating Temperature Range Of **HUBLAC A** Solution: 60 – 100F

EQUIPMENT

Tanks: Stainless steel (316), PVC, polypropylene, polyethylene, ceramic or glass lined. Do not use steel tanks.

CONTROLS

The **HUBLAC A** can be controlled either by specific gravity, using a hydrometer, or by determining the resin content.

METHOD FOR DETERMINING RESIN CONTENT

Concentrated **HUBLAC A** contains approximately 20% (WGT) of resin.

1. To determine the resin content of the **HUBLAC A** bath, take a 10-ml sample.
2. Pour the 10-ml sample into a tarred aluminum-weighing dish.
3. Accurately weigh the sample to determine the weight of **HUBLAC A** in dish.
4. Place the dish into an oven, which is at 212-275F. (100-135C.) and evaporate to dryness.
5. Cool dish to room temperature and reweigh (final weight).

$$\% \text{ Resin} = \frac{\text{Final weight} - \text{weight of aluminum dish} \times 100}{\text{weight of } \mathbf{HUBLAC A} \text{ sample}}$$

NOTE: Ideally do not allow the % resin to fall below 2 to 3% of original makeup.

SPECIFIC GRAVITY/BAUME CONTROL METHOD

Use a hydrometer with a range of 1.00 to 1.05 to determine specific gravity.

<u>% CONC.</u>	<u>SPECIFIC GRAVITY</u>	<u>BAUME</u>
100	1.03	3.7
90	1.0235	3.3
80	1.0209	3.0
70	0.0182	2.6
60	1.0156	2.3
50	1.0130	1.9
40	1.0105	1.5
30	1.0079	1.2
20	1.0053	0.8
15	1.0040	0.6

NOTE: Use ordinary tap water to make up **HUBLAC A** solution also, avoid drag in of acids.

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SPRAY APPLICATION

Operating concentration range of **HUBLAC A** is 50 to 60% (Volumes).

EQUIPMENT

A binks spray gun number 18, 19, 62 or 29. Hand spray with fluid nozzle 63ASS and an orifice of 0.040" with an air nozzle of 63P or equivalent.

SPRAY PATTERN

The pattern size will be roughly 10 inches when sprayed from a distance of 8 inches from the part.

FLUID PRESSURE

Fluid pressure should be 10 to 40 PSI. Air hose size and number from the binks catalog are 5/16 inches and number 71-106.

RECOMMENDED PROCEDURE

Use 25 to 40 PSI air pressures with a fine spray. Ideal results are obtained by spraying 2 to 8 inches from the part. Care must be taken not to over spray, which will cause dripping or sags. These heavy areas will be cloudy in appearance.

DRYING OF WORK

Air dry. Elevated temperature 150-300F (66-149C) for 2 to 7 minutes.

STORAGE

Do not store in the open sun or below 32F (0C). Below 32F will cause freezing. If this happens, warm to room temperature, 70F (21C) and mix well.

CAUTION

Even though **HUBLAC A** is a neutral product, avoid skin, eye and oral contact. Wear protective clothing, gloves and goggles when handling the product. Flush exposed areas immediately with clean, cold water. Contact a doctor immediately in case of injury.

WASTE DISPOSAL

Dispose bath in accordance with local, state and federal regulations.

WARRANTY

THE QUALITY OF THIS PRODUCT IS GUARANTEED ON SHIPMENT FROM OUR PLANT. IF THE USE RECOMMENDATIONS ARE FOLLOWED, DESIRED RESULTS WILL BE OBTAINED. SINCE THE USE OF OUR PRODUCTS IS BEYOND OUR CONTROL, NO GUARANTEE EXPRESSED OR IMPLIED IS MADE AS TO THE EFFECTS OF SUCH USE, OR THE RESULTS TO BE OBTAINED.