

N-Hance Process Sheets

Process Sheet: XB – Hardener Process

(Add only into White or Deep XB-Primer)

Process Steps:

a. Required Items prior to mixing.

- i. Safety glasses or face shield, rubber gloves, and long sleeves.
- ii. Work in well-ventilated space.
- iii. Rag for cleanup.
- iv. Drill, with paddle mixer.
- v. Clean open top container to measure out product into.
- vi. Measuring device, recommend syringe or other appropriately marked container.

b. Adding Hardener to Primer:

- i. Don proper safety gear.
- ii. Drip product into primer while mixing @ 1000 RPM.
 1. Quart = drip for a minimum of 30 seconds, continue mixing for a total of 2 minutes.
 2. Gallon = drip for a minimum of 2 minutes, continue mixing for 15 seconds after hardener is added.
- iii. Add 3-5% volume of XB - Hardener to XB-
 1. quart (32 ounces) = 1 to 1.5 ounces (28 to 47 ml).
 2. gallon (128 ounces) = 3.5 to 6.5 ounces (113 to 189 ml).

c. Additional Considerations:

- i. Once mixed, the product has a usable time frame of 4 hours. Add up to 5% water if the product becomes difficult to spray.
- ii. Dry times of primer will be extended.
- iii. The useable life of primer after the harder is added is approximately 4 hours.
- iv. Review SDS for Cautions and other product information.
- v. Clean up tools and equipment with warm water and soap.

Note: Mixed Product inside of the gun will not harden to the point it will not flow even after long periods of time if it is not exposed to oxygen. It will simply not spray well.