



## POR-15 HARDNOSE / WHITECOTE PAINTS

### Application Information

#### PRODUCT DESCRIPTION

Hardnose / Whitecote Paint is a high-gloss extreme durability topcoat that can be applied over a number of surfaces, including heavy-duty vehicle chassis and trailers, floor pans, agricultural machinery, and many marine applications as well, including motors, heat exchangers, pumps, masts, decks, and hand rails. Hardnose / Whitecote coatings can also be used to protect equipment from strong acids, alkali, and other aggressive materials. It can be applied over existing single and two-component primers as well as in a complete POR-15 paint application which would include POR-15 Rust Preventive Paint as a primer and POR-15 Self-Etching Primer as an intermediary coat. Hardnose / Whitecote coatings will not leave brush marks and will dry in less than an hour but will take 3 or 4 days to fully cure. Like many other POR-15 coatings, Hardnose / Whitecote is a moisture-cured coating, which means it is strengthened by exposure to moisture.

#### PRODUCT COMPOSITION

Your Hardnose / Whitecote purchase consists of two items:

- 1) A green paint can, labeled Hardnose / Whitecote a blue can, which contains the basic resin formulation.
- 2) A smaller light blue can, labeled Hardener/Activator.

Warning: Your can of Hardener/Activator is sealed tightly. Remove the lid carefully and cover with a paper towel while prying off inner seal to avoid accidental spillage or splash. Your Hardener/Activator is very sensitive to moisture and humidity, so open it in a dry area. Keep both hardener and resin tightly capped when not in use. This is very important for maximum shelf life.

Mix 1 part Hardener/Activator with 4 parts Hardnose / Whitecote in a separate, re-sealable container. A clean glass jar works well as does a clean paint can with lid. Stir the combined contents thoroughly. When the coating is thoroughly mixed, thin as required.

#### PARTIAL MIXES

You may mix partial quantities of Hardnose / Whitecote for small jobs, and you may use any measuring device you happen to have around (coffee scoop, measuring spoons, cups etc.). All you have to do is follow this formula:

Mix 1 part Hardener/Activator with 4 parts Hardnose / Whitecote.

Hardnose / Whitecote Paint has a long pot life, up to 8 hours, if the lid is kept on the mixed batch when it is not in use.

#### SURFACE PREPARATION

Surface to be coated should be dry and free of grease, oil, and other contaminants. Use POR-15 Marine Clean, diluted 1 part Marine Clean to 8 parts water to remove light contamination. Then rinse with water and allow to dry.

#### APPLYING HARDNOSE / WHITECOTE OVER OTHER PRIMERS

Repeat instructions above, then sand surface lightly with 240 grit sandpaper and wipe clean with dry tack cloth and paint.

#### TO PAINT OVER A CURED POR-15 SURFACE

Clean with Marine Clean as above, then sand with 300 grit sandpaper and apply one light to medium coat of POR-15 Self-Etching Primer. Allow to cure for 30 Minutes at 68° F(20°C), or longer in cooler temperatures. Apply Hardnose / Whitecote as final finish.

#### AS A COMPLETE POR-15 PAINT SYSTEM

Apply two coats of POR15 Rust Preventive Paint over a sandblasted surface or a surface prepared with Marine Clean and Metal Ready. Then apply one light to medium coat of POR15 Self-Etching Primer as soon as POR-15 Rust Preventive Paint has cured to ensure maximum adhesion. Allow POR15 Self-Etching Primer to cure for 30 Minutes at 68°F (20°C), or longer in cooler temperatures. Apply Hardnose / Whitecote as final finish. If surface has any irregularities that you wish to remove, apply a medium coat of TieCoat Primer over the cured POR15 Self Etching Primer. Allow this to cure for 2 to 3 days, then sand smooth and finish with 300 grit. Wipe down with dry tack cloth and apply Hardnose / Whitecote.

#### APPLICATION

Apply a minimum of 2 medium coats for general automotive use, and a minimum of 3 full coats for heavy marine and industrial use. Hardnose / Whitecote may be applied by brush, spray, or roller. You can use any type of brush you prefer; Hardnose / Whitecote will flow out immediately, eliminating brush marks.

•Lay down a medium covering coat, but be careful to avoid runs. A second coat may be applied when dry to the touch, usually 15 – 20 minutes later, though the second coat may be left up to 2 days before re-coating without sanding. Best method: recoat at 2–3 hourly intervals.

## POR-15 Hardnose / Whitecote Continued

•In temperatures below 64°F (18°C), drying times will be extended and consequently runs may be more likely. To minimize this in colder temperatures, small items can be warmed with a heat gun, or air temperature raised for larger items. Do not overheat items above 75°F (24°C).

•Thin only with Xylene, if thinning is needed.

POR15 Solvent or lacquer thinner may be used for cleanup. Hardnose / Whitecote may be thinned up to 25%, though you will need more coats to retain dry film thickness.

**NOTE:** when applying a second or third coat by brush, surface tension may increase between coats. To reduce this tension, add some solvent to the mix so the coating will drop and flow out properly. For best results, apply at 68–75°F (18–24°C) with less than 70% humidity.

**SPRAY PAINTING / SPRAY BOOTHS** – Hardnose / Whitecote prefers low pressure application.

Siphon or Pot Gun application: use approx. 25 psi (180 kpa).

HV or top container gun: use approx. 15–18 psi (120 kpa).

At 60–71°F (16–22°C), thin 5–15%. At 71–82°F (22–28°C), thin 15–25%.

Avoid temperatures over 82°F (28°C) where possible.

Spray booth ideal temperature is 71°F (22°C), 50% humidity, low air flow.

Remember, thinning rates are a guide only. Consider also the type of gun, air temperature, and humidity. Hardnose / Whitecote can be cut with regular compounds if you have a run or imperfections, though it is best if you leave it for a week or two before cutting to make sure coating is hard (runs may take longer to fully cure due to added thickness).

### HUMIDITY CONTROL

Humidity should be 60% or lower when spraying Hardnose / Whitecote because the higher humidity may cause it to set up too quickly and before it has a chance to flow out evenly, thus resulting in a wavy appearance. This is especially true in high-humidity southern climates during the summer. Whenever possible, spray in a humidity-controlled (air conditioned) environment. Best temperature is 68–75°F (18–24°C). If this is not possible, apply Hardnose / Whitecote in the morning when temperatures are at their lowest. Hardnose / Whitecote can be applied successfully in higher humidity, but temperatures must be below 77°F (25°C). In temperatures over 86°F (30°C), the humidity must be low. Avoid high humidity and high temperatures.

### CURING

Remember, Hardnose / Whitecote will not perform as specified until it has cured for a minimum of 4 days at an average temperature of no less than 68°F (18°C). For example: Do not put engine parts into service before the 4 day cure time. Elevated temperatures will not speed up cure. Do not oven-bake parts.

### QUESTIONS & ANSWERS

#### Can I apply Hardnose / Whitecote over metal?

*Yes, you can, but you won't get the same adhesion or leveling as you do with Rust Preventive Paint as a primer.*

#### Can I apply Hardnose / Whitecote directly over POR-15 Rust Preventive Paint without POR-15 Self-Etching Primer?

*Yes, you can, but adhesion problems might occur on edges or corners. Also, runs are more likely.*

#### What if I have different size cans or cans with different batch numbers? I want to make sure my final coat is 100% color uniform.

*Make sure that at least one can will be enough for the entire final coat. If not, you will need to blend some of the resin cans together so you will have enough for the entire final coat.*

***Please remember these instructions are general guide lines only and cannot and do not cover every application and environment. If you remain unsure as how to proceed, please call toll-free for technical advice at 800-457-6715.***

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