

Suggested spray gun set up for painting HMG Topcoat and Primer paint systems.
 This information is given for guidance only and further help can be obtained by
 contacting the spray gun, brush or roller manufacturer directly.

www.binks.com

www.devilbiss.com

BINKS

HVLP Settings

■ Pressure

VISCOSITY	FLUID NOZZLE	AIR NOZZLE (PRESSURE)	AIR VOLUME AT 10 PSI SCFM	OZ. PER MIN. FLOW	PATTERN AT 10'
18 Seconds In a Zahn #2 Cup	92 (.046) 1.2 mm	90P	6	—	12"
		92P	7	10.1	15"
		93P	9	10.1	15"
		94P	13	12.5	17.5"
		95P	21	9.2	12.5"
		97P	21	8.4	16"
		95AP 97AP	21 21	10.6 10.4	16" 16"
44 Seconds In a Zahn #2 Cup	94 (.055) 1.4 mm	92P	7	7.4	12"
		93P	9	7.7	14.5"
		94P	13	11.8	15"
		95P	21	7.6	10"
		97P	21	7.6	12"
		95AP 97AP	21 21	7.4 7.4	12" 12"
		25 Seconds In a Zahn #3 Cup	97 (.07) 1.8 mm	92P	7
93P	9			9.8	15"
94P	13			13.5	14"
95P	21			7.1	9.25"
97P	21			5.5	13"
95AP 97AP	21 21			10.3 9.46	14" 12.5"

NOTE: Flow rates tested at 3 PSI fluid pressure with a 1 quart pressure cup.

Siphon

VISCOSITY	FLUID NOZZLE	AIR NOZZLE (PRESSURE)	AIR VOLUME AT 10 PSI SCFM	OZ. PER MIN. FLOW	PATTERN AT 10'
18 Seconds In a Zahn #2 Cup	94S (.055) 1.4 mm	95AS	22	4.0	13'
	97S (.070) 1.8 mm	95AS	22	7.1	16'

DeVilbiss

FLUID TIP SIZE CHART

Inches	Millimeters	DeVilbiss Letter
.088" =	2.2 mm	D
.078" =	2.0 mm	
.070" =	1.8 mm	EX, E
.062" =	1.6 mm	FW
.059" =	1.5 mm	
.055" =	1.4 mm	FF
.051" =	1.3 mm	
.047" =	1.2 mm	
.042" =	1.1 mm	FX
.039" =	1.0 mm	F
.034" =	0.85 mm	

High Volume Low Pressure Guns

Binks MACH 1 or equivalent pressure pot:

Fluid Nozzle: #91 (.040" Orifice Size)

#92 (.046" Orifice Size)

Fluid Needle: #54-4382

Air Nozzle: #93P

For use with higher viscosity products:

Fluid Nozzle: #94 (.055" Orifice Size) or

#97 (.070" Orifice Size)

Pressure Pot System Guns

Binks or equivalent:

Spray Gun: #95

Fluid Nozzle: #63BSS (.046" Orifice Size)

Fluid Needle: #663A

Air Nozzle: #63PW

Pressure pot gauge should read 8 to 15 lbs. with 50 to 60 lbs. atomization.

Siphon or Cup Gun System

Binks or equivalent:

Spray Gun: #95

Fluid Nozzle: #66SS (.070" Orifice Size)

Fluid Needle: #665

Air Nozzle: #63SK

Atomizing air pressure should be approximately 50 to 60 lbs.

Brushes and Rollers

<http://www.redtreeind.com/products.html>

Natural vs Synthetic Bristles: Natural bristles are meant for oil-based paints. The newer Synthetic bristles can be used for anything but were really designed for water-based paints. Natural bristles will soak up the water and go limp in water-based paints.



Badger or Ox hair Bristle: The softest natural bristle. Best for creating glass-smooth finishes with oil enamels and varnishes.



White China Bristle: For oil-based paint, stain, varnish and polyurethane, as well as shellac and lacquer. Soft natural bristles yeild a smoother finish than a black china bristle.



Black China Bristle: For oil-based paint, stain and varnish. Bristles are stiffer and may require more forceful stroke to get the paint onto the surface but the least expensive natural bristle brush.

Rollers:

Redtree: The Deluxe Mohair R-11PH (3/16th"nap) is for topside enamels

Corona: The Glasskoter™ R101F (1/8th" nap) & R201F (3/8th "nap) are conventional mohair rollers. For topside enamels, we suggest Slicker™ Cat# R-780-012F (1/8th" nap) Foam Rubber roller.

HMG Performance Coatings LLC provides this information without warranty and regard to suitability. It highly appreciates the input of its customers and welcomes any other products and services that might be of value to the general and specialized marine paint user. Please send suggestions to info@hmgmarine.com