



# Highland International, Inc.



## Technical Data Sheet

### 185 Series "Fast Dry" High Performance 2-K Epoxy DTM High Build Surface Tolerant

185 Series is a fast drying High Performance 2-Component surface tolerant epoxy DTM. It is an ideal choice for OEMs where quick handling is needed to speed the production process. It may be applied over tightly bonded rust or mil scale and offers outstanding chemical, water, weathering, and corrosion protection. 185 Series is a high build DTM epoxy that can be applied up to 10 mils DFT, allowing it to provide great corrosion protection even in the most severe chemical & atmospheric conditions.

<b>Vehicle Type:</b>	Polyamine Epoxy	<b>Dry-Time:</b>	<b>Normal Application</b>	<b>Hot Application</b>
<b>Pigmentation:</b>	Varies with color (Zinc Phosphate)	<b>Recoat/Topcoat</b>	min. 1-2 hrs (max 28 Days)	N/A
<b>Reducers:</b>	Not normally required	<b>Tack Free</b>	30 Minutes	N/A
<b>If desired (up to 20%):</b>	30-E for 80°F and above	<b>Dry Hard</b>	2-3 Hours	N/A
<b>If desired (up to 20%):</b>	32-E for below 80°F	<b>Complete Cure</b>	5-7 Days @ 77°F	N/A
<b>Mixing Ratio:</b>	9:1 Base to Activator	<b>Put in Service</b>	24 Hours	N/A
<b>Pot Life:</b>	3 Hours @ 77°F (decreases at higher temps)	<b>V.O.C.:</b>	2.8 lbs. per gal. (335 grams/liter)	
<b>Volume Solids:</b>	50% (+/- 1%)	<b>Shelf Life:</b>	1 Year Minimum	
<b>Theoretical Coverage:</b>	800 Sq. Ft. per gallon @ 1 mil DFT	<b>Finish:</b>	Satin	
<b>Flash Point:</b>	-4°F Lowest Flashing Component	<b>Color:</b>	Selected Range	
<b>Recommended DFT:</b>	<b>A)</b> 4-6 mils for very good corrosion protection in moderate conditions			
	<b>B)</b> 6-10 mils for maximum corrosion protection even in severe chemical & atmospheric conditions			
<b>Recommended WFT:</b>	<b>for A)</b> 8-12 mils wet will achieve 4-6 mils DFT			
	<b>for B)</b> 12-20 mils wet will achieve 6-10 mils DFT			

**Preparation:** For immersion, a SSPC-SP5 White Metal Blast is required. Commercial Blast, SSPC-SP6 is recommended for steel when practical. Where blast cleaning is not practical, SSPC-SP3 Powertool or SSPC-SP2 Wire Brushing is acceptable and provides excellent results. Also, water jetting in accordance with SSPC-SP12 is acceptable. Surfaces should be dry and free of contaminants.

**Application Requirements:** **1)** Mix entire contents of part "A" Activator with Part "B" Base (9 to 1 by volume) **2)** Mixed material is ready for use after a 20 minute induction period **3) Reduction:** If desired, reduce up to 20% with the proper reducer **after** the 20 minute induction period. **4)** Apply at a rate of 133 to 200 square feet per gallon to obtain the recommended film thickness for normal conditions. **5)** Apply at a rate of 80 to 133 square feet per gallon to obtain the recommended film thickness for severe conditions. **6)** If topcoating, use #36-HF Series, #37 Series, #64 Series, #150 Series, or #865 Series. **7)** May see normal service after 24 hours.

Method of Application:	Conventional Spray	Airless Spray:
<b>Gun:</b>	DeVilbiss MBC-510	<b>Gun:</b> Graco 205-591
<b>Fluid Tip:</b>	E	<b>Pump:</b> 30:1
<b>Air Cap:</b>	704	<b>Tip Range:</b> 3.011 - 4.015
<b>Atomizing Pressure:</b>	60 psi	<b>Pump Pressure</b> 1800 psi minimum
<b>Pot Pressure &amp; Hose:</b>	15-20 psi 1/2" ID	<b>Hose:</b> 3/8 inch ID
<b>Brush or Roller:</b>	Reduce 10% Min #105 Reducer	<b>Clean Up:</b> Use 30-E or 32-E Reducer or lacquer thinner.

**Safety Precautions:** **(a)** Use normal precautions such as gloves, facemasks, and barrier creams. **(b)** Adequate ventilation must be maintained. In confined areas, workmen must wear constant flow airline respirators. **(c)** If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention. **(d)** This product contains **FLAMMABLE** materials. Keep away from sparks and open flames. Observe **NO SMOKING** regulations. **(e)** All electrical equipment and installations should conform to NEC regulations. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools, and to wear conductive, non sparking shoes. **(f)** Observe low flash regulations. **(g)** Refer to Material Safety Data Sheet (MSDS) for complete safety instructions.

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However, when applied according to manufacturers specifications, these products will perform as indicated.

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