



# Highland International, Inc.



## Technical Data Sheet

### 35-S Series HiBond High Solids Sanding Primer

HiBond is a high solids, fast drying single package primer specifically formulated to meet 3.5 pounds per gallon VOC. Its off-white or buff color allows single coat coverage when topcoated with bright lead-free colors: Oranges, Reds, and Yellows. HiBond's four rust inhibitors work together to offer outstanding chemical and corrosion resistance. It may be topcoated with a wide variety of topcoats: alkyds, urethanes, epoxies and acrylics.

<b>Vehicle Type:</b>	Modified Phenolic Alkyd	<b>Dry-Time:</b>	<b>Normal Application</b>	<b>Hot Application</b>
<b>Pigmentation:</b>	Zinc Phosphate, Titanium & Extenders	<b>To Touch</b>	15 Minutes	N/A
<b>Reducers for:</b>	Not Normally Required	<b>Tack Free</b>	45-60 Minutes	N/A
<b>If desired:</b>	#64 Reducer	<b>To Topcoat</b>	1-2 Hours (after 7 days, must sand before topcoating).	N/A
<b>Mixing Ratio:</b>	Single Package			N/A
<b>Pot Life:</b>	N/A	<b>V.O.C.:</b>	3.48 lbs. per gallon (417 grams/liter)	
<b>Volume Solids:</b>	51%	<b>Shelf Life:</b>	1 Year Minimum	
<b>Theoretical Coverage:</b>	816 Sq. Ft. per gallon @ 1 mil DFT	<b>Finish:</b>	Flat	
<b>Flash Point:</b>	81°F (Lowest Flashing Component)	<b>Color:</b>	Selected Range	
<b>Recommended DFT:</b>	2-3 mils	<b>Weight:</b>	13 lbs. per gallon	

**Preparation:** Minimum surface preparation should be in accordance with SSPC-SP6 Commercial Blast cleaning. When blast cleaning is not an option, SSPC-SP3 Powertool or SSPC-SP2 Wire Brushing is acceptable and provides good results. Also, water jetting in accordance with SSPC-SP12 is acceptable. Etch aluminum or galvanized surfaces prior to priming. Surfaces should be dry and free of contaminants.

**Application Requirements:** (1) Stir thoroughly prior to use. (2) Apply at a rate of 272 to 544 square feet per gallon to obtain the recommended film thickness. (3) Topcoat with Highland #64 Series, #37 Series, #865 Series, #840 Series, #150C Series or #65C Series.

**Special Notes:** If you wait more than 7 days to topcoat, you must sand primer and then topcoat.

**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 @ 1800 psi minimum
<b>Atomizing Pressure:</b>	60 psi	<b>Hose:</b>	3/8 inch ID
<b>Pot Pressure:</b>	15-20 psi		
<b>Hose:</b>	1/2 inch ID		

<b>Brush or Roller:</b>	Brush may be used for touch-up
<b>Clean Up:</b>	Clean all equipment with 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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P. O. Box 3564 Boone, NC 28607  
800-444-1438  
www.highland-international.com