



Highland International, Inc.



Technical Data Sheet

475-C Series Dry-Fall High Performance 2-K Epoxy Primer High Build Surface Tolerant

475C Series is a High Performance 2-Component surface tolerant modified polyamine epoxy primer. Its overspray is designed to dry to a powder 10-20 feet from point of application, allowing painting to continue without the worry of paint overspray damaging nearby equipment and vehicles. 475C Series may be applied over tightly bonded rust or mil scale and offers outstanding chemical, water, weathering, and corrosion protection. Topcoat within 28 days or surface will need to be scuffed.

Vehicle Type:	Polyamine Epoxy	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Varies with color (Zinc Phosphate)	Recoat/Topcoat	Min. 1-2 Hrs. (Max 28 Days)	N/A
Reducers for		Tack Free	30 Minutes	N/A
Dry-Fall Application:	30-E for 80°F and above	Dry Hard	2-3 Hours	N/A
	32-E for 80°F and below	Complete Cure	5-7 Days @ 77°F	N/A
Mixing Ratio:	9:1 Base to Activator	Put in Service	24 Hours	N/A
Pot Life:	3 Hours @ 77°F (decreases at higher temps)	V.O.C.:	2.84 lbs. per gal. (340 grams/liter)	
Volume Solids:	50% (+/- 1%)	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	800 Sq. Ft. per gallon @ 1 mil DFT	Finish:	Flat	
Flash Point:	-4°F Lowest Flashing Component	Color:	Off-White	

Recommended DFT:	A) 2-3 mils for very good corrosion protection in moderate conditions			
	B) 4-8 mils for maximum corrosion protection even in severe chemical & atmospheric conditions			
Recommended WFT:	for A) 5-7.5 mils wet after reduction will achieve 2-3 mils DFT			
	for B) 10-20 mils wet after reduction will achieve 4-8 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: To assure Dry-Fall effect, do not apply in temperatures below 45°F, on surfaces below 40°F, or humidity above 85%.
Make sure the equipment you are using to spray with will give you accurate PSI readings so that the pressure from the pump can be maintained at 1800 psi allowing a maximum +/- 25 psi for surges.
The product will continue curing to temperatures of 30°F.
Do not apply in temperatures that are 5°F or less from the dew point.

Reduction:
Mix .5 Gallon Part "A" Activator with 4.5 Gallons Part "B" Base. **Allow a minimum 20 minute induction period before reduction.**
For Dry-Fall effect you must reduce activated material 10-20%. Reduce with one of the following Highland Exempt Reducers:
#30-E Highland VOC Exempt Warm Weather Dry-Fall Reducer for temperatures 80°F and above
#32-E Highland VOC Exempt Cold Weather Dry-Fall Reducer for temperatures below 80°F
If "fingering" occurs during the spray application, increase the amount of thinner, which decreases the viscosity of the paint.
Do not increase the pump pressure. Maintain 1800 psi allowing +/- 25 psi for surges.

Gun:	DeVilbiss MBC-510	Gun:	Graco 205-591
Fluid Tip:	E	Pump:	30:1
Air Cap:	704	Tip Range:	.011 - .015
Atomizing Pressure:	60 psi	Pump Pressure	1800 psi allowing +/- 25 psi
Pot Pressure & Hose:	15-20 psi 1/2" ID	Hose:	3/8 inch ID (Do not use whip lines)
Brush or Roller:	Reduce 10% Min #105 Reducer	Clean Up:	30-E or 32-E or 1:1 Mix or Xylene & MEK

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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