



Highland International, Inc.

Technical Data Sheet



485-SC Series Dry-Fall High Performance 2-K Epoxy Direct to Metal (DTM) High Build Surface Tolerant

485-SC Series is a High Performance 2-Component epoxy DTM designed for overspray to dry to a powder within 10-20 feet from the point of application, allowing painting to continue without the worry of paint overspray damage to nearby vehicles or equipment. 485-SC Series may be applied over tightly bonded rust or mil scale and offers outstanding chemical, water, weathering, and corrosion protection. If desired, the Dry-Fall effect may be eliminated or controlled with the proper reducer selection.

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| 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.: | 100 grams/liter | |
| Volume Solids: | 50% (+/- 1%) | Shelf Life: | 1 Year Minimum | |
| Theoretical Coverage: | 800 Sq. Ft. per gallon @ 1 mil DFT | Finish: | Satin | |
| Flash Point: | -4°F Lowest Flashing Component | Color: | Selected Range | |
| Recommended DFT: | A) 4-6 mils for very good corrosion protection in moderate conditions B) 6-10 mils for maximum corrosion protection even in severe chemical & atmospheric conditions | | | |
| Recommended WFT: | for A) 10-15.5 mils wet after reduction will achieve 4-6 mils DFT for B) 15.5-25.5 mils wet after reduction 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: 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 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.

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| Method of Application: | Conventional Spray | Airless Spray: |
| 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 | Hose: 3/8 inch ID (Do not use whip lines) |
| Pot Pressure & Hose: | 15-20 psi 1/2" ID | Pump Pressure 1800 psi allowing +/- 25 psi |
| Brush or Roller: | Reduce 10% Min #105 Reducer | Clean Up: 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.

The technical data listed herein has been compiled for your convenience and guidelines and is based upon our experience and knowledge. However, since we have no control over the use of this information or this product, no warranty express or implied is intended or given. Highland assumes no responsibility whatsoever for coverage, performance or any other damage, including injuries from use of this information of products recommended herein. However, when applied according to manufacturers specifications, these products will perform as indicated.

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