



# Highland International, Inc.



## Technical Data Sheet

### 55 Series High Solids Acrylic DTM (Urethane Modification Optional)

55 Series is a single package Direct to Metal Acrylic Alkyd that may be applied over marginally prepared surfaces (light rust and mill scale) when 34-ALH-100 Urethane Modifier is added. Its quick dry times make it an excellent choice for OEMs that are looking for ways to save time during the production process. As a single package, 55 Series will exhibit very good gloss and color retention as well as corrosion protection. However, these qualities are greatly enhanced when 34-ALH-100 Urethane Modifier is added.

Vehicle Type:	Acrylic Alkyd	Dry-Time:	Normal Application	Urethane Modified
Pigmentation:	Lead Free	To Touch	30 Minutes	10 Minutes
Reducers:	Not normally required	Tack Free	1 Hour	1 Hour
In Summer if desired:	Highland #100	To Recoat	1 Hour	30 Minutes
In Winter if desired:	Highland #120	To Handle	1-2 Hours	1-2 Hours
Mixing Ratio:	Single Package	Put in Service	12 hours	12 hours
For Enhanced Durability:	Add 1 quart (4:1) 34-ALH-100 per gal.	V.O.C.:	2.9 lbs. per gallon (350 grams/liter)	
Pot Life:	3 Hours @ 77°F (when 34-ALH-100 is added)	Shelf Life:	1 Year Minimum	
Volume Solids:	50%	Finish:	Gloss, Semi-Gloss, Satin	
Theoretical Coverage:	800 Sq. Ft. per Gallon @ 1 mil DFT	Color:	Selected Range	
Flash Point:	45°F (lowest flashing component)	Weight:	10 Lbs. per Gallon	
Recommended DFT:	4-6 Mils			

#### Preparation:

1) 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 when using with the urethane modifier. Also, water jetting in accordance with SSPC-SP12 is acceptable. All surfaces to be painted should be dry and free of all foreign contaminants.

**Application Requirements:** (1) Stir product thoroughly prior to use. (2) Apply at a rate of 133-200 square feet per gallon to obtain the recommended film thickness.

**Special Notes:** 55 Series is a single component product, however, for additional durability you may add #34-ALH-100 Hardener at one quart per gallon. Pot life is then 3-4 Hours at 77°F with considerably shorter pot life at higher temperatures.

*\*To enhance gloss, durability & hardness of this coating add one quart (4:1) of #34-ALH-100 per gallon.*

#### 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:	3.013 - 4.015 @ 1800 psi minimum
Atomizing Pressure:	60 psi	Hose:	3/8 inch ID
Pot Pressure:	20 psi		
Hose:	1/2 inch ID		

**Brush or Roller:** Apply in multiple coats to achieve recommended DFT. When Urethane Modifier is added, a second coat may be applied after 5 minutes.

**Clean Up:** After use, 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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