



Highland International, Inc.



Technical Data Sheet

68 Series Dry-Fall High Performance 2-K Aliphatic Acrylic Urethane Topcoat

68 Series is a High Performance 2-Component aliphatic urethane topcoat designed for overspray to powder dry 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. 68 Series offers a deep automotive "wet look." The "wet look" is maintained in combination with color purity, flexibility, and UV & corrosion protection even when exposed to a variety of harsh climatic and chemical environments.

Vehicle Type:	Aliphatic Acrylic Urethane	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Varies with color (Lead Free)	To Touch	10-15 Minutes	N/A
Reduction:	Reduce 20%	Tack Free	1 Hour	N/A
Dry-Fall Application:	30-E for 80°F and above	To Recoat	1 Hour	N/A
	32-E for 80°F and below	Dry Hard	6-8 Hours	N/A
Mixing Ratio:	3:1 Base to Activator	Complete Cure	5-7 Days	N/A
Pot Life:	3 Hours @ 77°F	Put in Service	12 Hours	N/A
	(Decreases at higher temps)	V.O.C.:	3.5 lbs. per gallon (419 grams/liter)	
Volume Solids:	54% (+/- 1%)	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	864 Sq. Ft. per gallon @ 1 mil DFT	Finish:	High Gloss, Semi-Gloss, & Satin	
Flash Point:	-4°F (lowest flashing component)	Color:	Selected Range	
Recommended DFT:	A) 2-3 mils for very good durability even in severe chemical and atmospheric conditions (1 coat).			
	B) 4-6 mils for maximum durability even in severe chemical and atmospheric conditions (2 coats).			
Recommended WFT:	for A) 4.5-7 mils wet after reduction will achieve 2-3 mils DFT			
	for B) 9-13 mils wet after reduction will achieve 4-5 mils DFT			

Preparation: All surfaces should be dry and free of contaminants. Apply over Highland #475C Dry-Fall Epoxy Primer, #84-DF Dry-Fall Phenolic Modified Primer, #325 Series HiZinc Dry-Fall 2-K Zinc Rich Epoxy Primer or #335 Hi-Zinc Inorganic Zinc Primer.

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.

Do not apply in temperatures that are 5°F or less from the dew point.

Reduction: Mix 1 Gallon Part "A" Activator with 3 Gallons Part "B" Base. **Allow a 15 minute induction period before reduction.**

For Dry-Fall effect you must reduce activated material 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.**

QUV Data 0.77 Irradiance (UVA -340 Bulb) Cycle: 8 Hrs. UV exposure @ 60°C 4 Hrs. UV exposure @ 50°C
Initial Gloss = 94 Gloss after exposed 500 Hrs. = 92 Gloss after exposed 1000 Hrs. = 89

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: 3.011
Atomizing Pressure:	60 psi	Pressure: 1800 psi allowing +/- 25 psi for surges
Pot Pressure & Hose:	15-20 psi 3/8" ID	Hose: 3/8 inch ID (Do not use whip lines)
Brush or Roller:	Both are acceptable when reduced with Highland #105 B&R Reducer	Clean Up: 30-E or 32-E or 1:1 Blend MEK & Xylene

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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