



Highland International, Inc.



Technical Data Sheet

74-HF Series Chem-Temp High Temperature Epoxy Lining (HAPS Free)

Chem-Temp is a high build 2-K novolac epoxy specifically formulated to provide exceptional temperature and chemical protection. It may be applied by conventional or airless spray up to 16 mils DFT.

Chem-Temp may be used as a DTM liner to withstand acidic, caustic and high heat environments.

Vehicle Type:	Epoxy Novolac	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Lead Free	To Touch	4 hours	n/a
Reducers:	Not normally required (Max 5%)	Tack Free	6 hours	n/a
for Hot Application:	Highland #101 Reducer	To Recoat	3 hours - 5 days (max)	30 seconds
Mixing Ratio:	4:1 (4 parts base to 1 part activator)	To Topcoat	6 hours - 5 days (max)	n/a
Pot Life:	3 Hours @ 77°F	To Handle	6 hours	n/a
	(Decreases at higher temps)	Put in Service	After topcoating wait 3 hours before heating	
Volume Solids:	70%	V.O.C.:	2.06 lbs. per gallon (247 grams/liter)	
Theoretical Coverage:	1120 Sq. Ft. per gallon @ 1 mill DFT	Shelf Life:	1 year minimum	
Flash Point:	24°F lowest flashing component	Finish:	Eggshell	
Recommended TDFT:	8-16 mils TDFT	Color:	yellow, aluminum	
Weight:	14 lbs/gal	Cure Time:	5-7 days @ 77°F for full cure. Forced cure schedule available upon request.	

Preparation:

1) Minimum surface preparation should be in accordance with SSPC-SP5 White Metal Blast for immersion.

All surfaces to be coated should be dry and free of all foreign contaminants.

Application Requirements: **1)** Mix entire contents of part "A" Activator with Part "B" Base (4 to 1 by volume) **2)** Mixed material is ready for use after a 30 minute induction period. **3)** Apply at a rate of 70 to 280 square feet per gallon to obtain the recommended film thickness when using as a primer. **4)** Apply at a rate of 70 to 140 square feet per gallon to obtain the recommended film thickness when using as a DTM. **5)** Allow one week before being put into service for immersion.

The second coat or topcoat must be applied within 5 days @ 77°F or the surface will need to be scuffed.

Special Notes for Hot Application: 74-HF Hot Application formula may be applied directly to hot surfaces not exceeding 400°F.

1) Mix entire contents of part "A" Activator with Part "B" Base (4 to 1 by volume) **2)** Mixed material is ready for reduction after 30 minute induction period. **3)** Reduce 20% with Highland #101 Hot Application Reducer and apply in multiple successive coats not exceeding 2 mil DFT to achieve the recommended film thickness.

Method of Application:

Conventional Spray

Airless Spray:

Gun:	DeVilbiss MBC-510	Gun:	Graco 205-591
Fluid Tip:	E	Pump:	30:1, 56:1, Plural
Air Cap:	704	Tip Range:	3.013 - 4.017 @ 1800 psi minimum
Atomizing Pressure:	70 psi	Hose:	3/8" ID
Pot Pressure:	15-20 psi		
Hose:	1/2 inch ID		
Brush or Roller:	Natural or synthetic bristle recommended		
Clean Up:	After use, clean all equipment with 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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