

Highland International, Inc.

Technical Data Sheet

45C Series Exterior Dry-Fall High Performance Modified Acrylic Universal Tie Coat Primer

45C Series is an extremely fast drying modified acrylic. Its overspray is designed to dry to a powder 10-20 feet from point of application. This allows painting to continue without the worry of paint overspray damage to equipment and vehicles. 45C Series has a combination of rust inhibitors making it a good choice for painting large plants, trailers, equipment, and vehicles, however, it does not offer the corrosion protection that 475C Series Dry-Fall Epoxy Primer does. 45C Series can be used as a tie coat going over existing coatings without lifting and then accepting a variety of topcoats including urethanes.

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| Vehicle Type: | Modified Acrylic | Dry-Time: | Normal Application | Hot Application |
| Pigmentation: | Varies w/color (Lead Free)Zinc Phosphate | To Touch | 5 Minutes | N/A |
| Dry-Fall Reducers: | #30-E for 80°F and above | Tack Free | 10 Minutes | N/A |
| | #32-E for 80°F and below | To Topcoat | 20 Minutes | N/A |
| Mixing Ratio: | Single Package | To Handle | 1-2 Hours | N/A |
| Pot Life: | Not Applicable | Put in Service | 12 Hours | |
| Volume Solids: | 42% | V.O.C.: | 3.2 Lbs. per Gal. (400 Grams/Liter) | |
| Theoretical Coverage: | 672 Sq. Ft. per mil per Gallon | Shelf Life: | 1 Year Minimum | |
| Flash Point: | -4°F Lowest flashing component | Finish: | Flat | |
| Recommended DFT: | 2-3 mils | Color: | Gray | |
| | | Weight: | 11 lbs. per gallon | |

Application Requirements: To assure Dry-Fall effect, do not apply in temperatures below 45°F or in high humidity.

Commercial Blast, SSPC-SP-6 is recommended for steel surfaces

All surfaces should be dry and free of contaminants

Thinner: Must reduce Minimum 10% and Maximum 15% with: #30-E VOC Exempt for temperatures 80°F and above

#32-E VOC Exempt for temperatures 80°F and below

Apply in one coat at a rate of 224 - 336 Square feet per gallon to obtain 2-3 mils DFT

Electric Airless spray equipment is not recommended. We have found this equipment does not generate proper atomization required for Highland Dry-Fall Products

Method of Application:

Conventional Spray

Airless Spray:

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|----------------------------|-------------------|-------------------|-------------------------------------|
| Gun: | DeVilbiss MBC-510 | Gun: | Graco 205-591 |
| Fluid Tip: | E | Pump: | 30:1 |
| Air Cap: | 704 | Tip Range: | 3.011 - 3.013 @ 1800 psi |
| Atomizing Pressure: | 60 - 80 psi | Hose: | 3/8 inch ID (Do not use whip lines) |
| Pot Pressure: | 15-20 psi | | |
| Hose: | 1/2 inch ID | | |

Brush or Roller: Both may be used for touch-up

Clean Up: Clean all equipment with Highland 30-E, 32-E 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.

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