

### 68 Series Dry-Fall High Performance 2-K Aliphatic Acrylic Urethane High Solids "One Coat Topcoat"

68 Series is a High Performance 2-Component aliphatic urethane topcoat designed for overspray to dry to a powder within 10-20 feet from point of application allowing painting to continue without the worry of paint overspray damage to nearby vehicles or equipment. 68 Series offers ultimate gloss retention, durability, and corrosion protection. Dry-Fall can be controlled with reducer selection.

<b>Vehicle Type:</b>	Aliphatic Acrylic Urethane	<b>Dry-Time:</b>	<b>Normal Application</b>	<b>Hot Application</b>
<b>Pigmentation:</b>	Varies with color (Lead Free)	<b>To Touch</b>	10-15 Minutes	N/A
<b>Reducers for</b>		<b>Tack Free</b>	1 Hour	N/A
<b>Dry-Fall Application:</b>	30-E for 80°F and above	<b>Dry Hard</b>	6-8 Hours	N/A
	32-E for 80°F and below	<b>Complete Cure</b>	5-7 Days	N/A
<b>Mixing Ratio:</b>	3:1 Base to Activator	<b>Put in Service</b>	24 Hours	N/A
<b>Pot Life:</b>	3-4 Hours @ 77°F	<b>V.O.C.:</b>	3.2 Lbs. per Gal. (400 Grams/Liter)	
<b>Volume Solids:</b>	54% (+/- 1%)	<b>Shelf Life:</b>	1 Year Minimum	
<b>Theoretical Coverage:</b>	864 Sq. Ft. per gallon @ 1 mil DFT	<b>Finish:</b>	High Gloss (Semi Gloss available upon request)	
<b>Flash Point:</b>	-4°F Lowest Flashing Component	<b>Color:</b>	Selected Range	
<b>Recommended DFT:</b>	<b>A)</b> 2-3 mils for very good durability even in severe chemical and atmospheric conditions.			
	<b>B)</b> 4-5 mils for maximum durability even in severe chemical and atmospheric conditions.			
<b>Recommended WFT:</b>	<b>for A)</b> 4.5-7 mils wet after reduction will achieve 2-3 mils DFT			
	<b>for B)</b> 9-11.5 mils wet after reduction will achieve 4-5 mils DFT			

**Preparation:**

To assure Dry-Fall effect, do not apply in temperatures below 45°F or on surfaces below 40°F.

Above 90% humidity Dry-Fall may be effected.

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

The product will continue curing to temperatures of 25°F.

Prime with Highland 475C Series Dry-Fall Epoxy Primer or 45C Series Dry-Fall Acrylic Primer

All surfaces should be dry and free of contaminants.

Mix 1 Gallon Part "A" Activator with 3 Gallons Part "B" Base. **Allow a minimum 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

**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

**\*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:**

<b>Gun:</b>	DeVilbiss MBC-510	<b>Gun:</b>	Graco 205-591
<b>Fluid Tip:</b>	E	<b>Pump:</b>	30:01:00
<b>Air Cap:</b>	704	<b>Tip Range:</b>	3.011 @ 1800 psi
<b>Atomizing Pressure:</b>	60 psi	<b>Hose:</b>	3/8 inch ID (Do not use whip lines)
<b>Pot Pressure &amp; Hose:</b>	15-20 psi    3/8" ID		
<b>Brush or Roller:</b>	Both are acceptable	<b>Clean Up:</b>	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.

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