



# Highland International, Inc.

## Engineered Paint Systems

### HiBond 35-S Series Phenolic Modified Alkyd Sanding Primer

**35-S Series** is a high-solids, fast drying single package primer specifically formulated to meet 3.5 pounds per gallon VOC. Its off-white or buff color allows single coat coverage when topcoated with bright lead-free colors: oranges, reds, and yellows. HiBond's four rust inhibitors work together to offer outstanding chemical and corrosion resistance. It may be topcoated with a wide variety of topcoats: alkyds, urethanes, epoxies and acrylics.

<b>Vehicle Type:</b>	Phenolic Modified Alkyd
<b>Pigmentation:</b>	Zinc Phosphate, Titanium & Extenders
<b>Reducers for:</b>	Not Normally Required
<b>If desired:</b>	Highland #26 Reducer
<b>Mix Ratio:</b>	Single Package
<b>Pot Life:</b>	Not Applicable
<b>Volume Solids:</b>	48%
<b>Theoretical Coverage:</b>	800 ft <sup>2</sup> /gallon @ 1 mil DFT
<b>VOC:</b>	3.5 lbs/gallon (419 g/L)
<b>Flash Point:</b>	67°F (Lowest Flashing Component)
<b>Recommended DFT:</b>	2-3 mils

#### Dry-time@ 77°F:

<b>To Touch</b>	15-30 Minutes
<b>Tack Free:</b>	1 Hour
<b>To Topcoat:</b>	1-2 Hours
<b>To Handle:</b>	2 Hours
<b>Put In Service:</b>	12 Hours

<b>Shelf Life:</b>	1 Year Minimum
<b>Finish:</b>	Flat
<b>Color:</b>	Off-White or Selected Range

#### Surface Preparation

1) Minimum surface preparation should be in accordance with SSPC-SP6 Commercial Blast cleaning. When blast cleaning is not an option, SSPC-SP3 Power Tool or SSPC-SP2 Wire Brushing is acceptable and provides good results. Also, water jetting in accordance with SSPC-SP12 is acceptable. Etch aluminum or galvanized surfaces prior to priming.

2) All surfaces to be painted should be dry and free of all foreign contaminants.

#### Application Requirements

1. Stir product thoroughly prior to use
2. Reduction is not normally required. If desired use Highland #26 Reducer
3. **Special Note:** If you wait more than 3 days to topcoat, you must sand and then topcoat
3. Apply at a rate of 256 to 384 square feet per gallon to obtain the recommended film thickness in one coat.
4. Topcoat with Highland HiShield 64, HiShield 36, HiShield 68R Dry-Fall , 65R Dry-Fall, or 150C HiGlo.

#### Method of Application

<b>Conventional Gun:</b>	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	15-20 psi
Hose:	½ inch ID
<b>Airless Gun:</b>	Graco 205-591
Pump:	30:1/45:1/60:1, Gas pump acceptable
Tip Range:	3.011 – 5.013
Pump Pressure:	Minimum 1,800 psi
Hose:	3/8 inch ID
<b>Brush or Roller:</b>	Brush may be used for touch-up
<b>Clean Up:</b>	Clean all equipment with Lacquer Thinner, MEK or Acetone

#### Safety Precautions

- 1) Use normal precautions such as gloves, facemasks and barrier creams.
- 2) Adequate ventilation must be maintained. In confined areas, workmen must wear constant flow airline respirators.
- 3) If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention.
- 4) This product contains **FLAMMABLE** materials. Keep away from sparks and open flames. Observe **NO SMOKING** regulations.
- 5) 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.
- 6) Observe low flash regulations.
- 7) Refer to Material Safety Data Sheet (MSDS) for complete safety instructions.

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