



45C Series is an extremely fast drying modified acrylic Primer. 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, tanks, trailers, equipment, and vehicles. 45C was specifically formulated as a tie coat for priming existing coatings without lifting. 45C can also accept a variety of topcoats including urethanes.

Vehicle Type:	Modified Oil Based Acrylic
Pigmentation:	Varies with color - Zinc Phosphate (Lead & Chromate Free)
Reducers for:	
Summer (above 80°F):	#30-E Exempt Warm Weather Reducer
Winter (below 80°F):	#32-E Exempt Cold Weather Reducer
Mix Ratio:	Single Package
Pot Life:	Not Applicable
Volume Solids:	42%
Theoretical Coverage:	672 ft ² /gallon @ 1 mil DFT
VOC:	3.2 lbs/gallon (400 g/L)
Flash Point:	-4° (Lowest Flashing Component)
Recommended DFT:	2-3 mils
Dry-time:	
To Touch	5 Minutes
Tack Free:	10 Minutes
To Topcoat:	20 Minutes
To Handle:	1-2 Hours
Put In Service:	12 Hours
Shelf Life:	1 Year Minimum
Finish:	Flat
Color:	Gray

Surface Preparation

- 1) Commercial Blast SSPC-SP6 is recommended for steel when practical. Where blast cleaning is not practical, SSPC-SP3 Power Tool or SSPC-SP2 Wire Brushing is acceptable and provides excellent results. Also, Water Jetting in accordance with SSPC-SP12 is acceptable.
- 2) All surfaces to be painted should be dry and free of all foreign contaminants.

Mixing Instructions and Reduction

45C Series must be reduced 10-15% with one of the following:

#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 will decrease the viscosity of the coating. Do not increase the pump pressure. Maintain 1800 psi allowing +/- 25 psi for surges.

The technical data listed herein has been compiled for your convenience and guidelines are based upon our experience and knowledge. However, since we have no control the use of this over information or this product, no warranty expressed 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 or products recommended herein.

Application Requirements

To assure Dry-Fall effect, do not apply in temperatures below 45°F, on surfaces below 40°F, or humidity above 85% Rh. **Make sure the equipment being used will give accurate psi readings so 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. Do not use whip lines.

Typical Systems

Primer/Tie-Coat	Topcoat
45C Series (2-3 mils)	68R Series Dry-Fall Aliphatic Urethane (2-3 mils)
45C Series (2-3mils)	720 Series Dry-Fall Modified Silicone Alkyd (2-3 mils)
45C Series (2-3 mils)	65R Series Dry-Fall Modified Acrylic (2-3 mils)

Method of Application

Conventional Gun:	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 -80 psi
Pot Pressure:	15-20 psi
Hose:	½ inch ID
Airless Gun:	Graco 205-591
Pump:	30:1/45:1/60:1, Gas Pump Acceptable
Tip Range:	3.011 – 4.013
Pump Pressure:	1800 psi allowing +/- 25 psi for surges
Hose:	3/8 inch ID (Do not use whip lines)
Brush or Roller:	Both are acceptable
Clean Up:	Clean all equipment with Lacquer Thinner

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.