



Dry-Fall 2-K Epoxy Primer (High-Build Surface Tolerant)

475R-CA Series is a 2-K surface tolerant modified polyamine epoxy primer that meets California VOC requirements of 250 g/L or less. Its overspray is designed to dry to a powder 10 feet from the point of application when reduced and within 20 feet without reduction. This allows painting to continue without worry of paint overspray damaging nearby equipment and vehicles. 475R-CA Series may be applied over tightly bonded rust or mill scale and offers outstanding chemical, water, weathering, and corrosion protection. Topcoat within 60 days or surface will need to be scuffed.

Vehicle Type:	Polyamine Epoxy
Pigmentation:	Varies with Color (Zinc Phosphate)
Reducers for:	
Dry-Fall outside 20 ft:	No Reduction Necessary
Dry-Fall within 10-20 ft:	10% with #32-E Reducer up to 80°F 10% with #30-E Reducer above 80°F
Mix Ratio:	10:1 Base to Activator
Pot Life:	3 Hours @77°F (Decreases in higher temps)
Volume Solids:	45%
Theoretical Coverage:	720 ft ² /gal. @ 1 mil DFT
VOC:	<250 g/L
Flash Point:	24°F (Lowest Flashing Component)
Recommended DFT:	
Moderate Conditions:	2-3 mils DFT = 4.5 - 7 mils wet mils 1-1.5 mil jagged profile is recommended
Severe Chemical & Atmospheric Conditions:	4-6 DFT applied in 1-2 Coats over a 2-3 mil jagged profile
Dry-time:	
Recoat/Topcoat	Min: 1-2 hrs. Max: 60 Days
Tack Free:	45 Minutes
Dry Hard:	4-6 Hours
Complete Cure:	5-7 Days @ 77°F
Put in Service	24 Hours
Shelf Life:	1 Year Minimum
Finish:	Flat
Color:	Off-White

Surface Preparation

- 1) For immersion or under insulation (CUI), a SSPC-SP5 White Metal Blast is recommended. Commercial Blast SSPC-SP6 is recommended for steel when practical. Where blast cleaning is not practical, SSPC-SP3 Power Tool or SSPC-SP2 Hand Tool Cleaning 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

Mix 2 Parts “A” Activator with 9 Parts “B” Base. Allow a minimum 15 minute induction period before reduction. No reduction is necessary to achieve Dry-Fall properties at 20 feet. For Dry-Fall effect within 10-20

feet, you must reduce **activated** material 10%. 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.

OR:

32-E Highland VOC Exempt Cold Weather Reducer for temperatures below 80°F.

In extremely hot weather (+90°F), **#36-E** Blending Reducer may be used to help overspray blend in. Do not exceed 5% reduction.

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.

Apply up to 6 mils per coat to achieve recommended TDFT.

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. When humidity is above 50%, take caution to observe the dry-fall range as it may extend slightly past the 20 foot mark, up to 50 feet depending on other weather variables. **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.** The product will continue curing to temperatures of 30°F. Do not apply in temperatures that are 5°F or less from the dew point. Contact a Highland representative to further review your specific spray conditions.

Method of Application

Airless Gun:	Graco 205-591
Pump:	30:1/45:1/60:1, Gas Pump Acceptable
Tip Range:	3.011 – 4.015
Pump Pressure:	1800 psi allowing +/- 25 psi for surges
Hose:	3/8 inch ID
Brush or Roller:	Reduce 10% min with #105 B&R Reducer
Clean Up:	#30-E, #32-E or 1:1 Blend MEK & Xylene

NOTE: **Electric pumps are NOT recommended. Contact a Highland Representative to review the use of conventional guns.**

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.

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- 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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