



Highland International, Inc.

Engineered Paint Systems

HiShield 64 Series Copolymer Urethane Topcoat

HiShield 64 Series is a two component copolymer urethane topcoat specifically designed to meet low VOC requirements. Its deep automotive wet look exceeds conventional polyurethane enamels as it maintains its wet look, durability and film flexibility for years. HiShield 64 also provides outstanding coverage rates. These qualities make it the product of choice for the transportation industry.

Vehicle Type:	Copolymer Urethane
Pigmentation:	Varies with Color (Lead & Chromate Free)
Reducer:	No Reduction necessary, if desired:
Below 80°F	#26 Reducer
Above 80°F	#64 Reducer
Mix Ratio:	3:1 Base to Activator
Pot Life:	3 Hours @77°F (Decreases in higher temps)
Volume Solids:	55% +/- 1%
Theoretical Coverage:	880 ft ² /gal. @ 1 mil DFT
VOC:	373 g/L (3.3 lbs/Gal.)
Flash Point:	64° (Lowest Flashing Component)
Recommended DFT:	2-3 mils

Dry-time @ 77°F: (64 Accelerator may be added to enhance drying times)

To Touch	30 Minutes
Tack Free:	2 Hours
To Recoat:	30 Minutes
To Tape:	6-8 Hours
To Decal:	8-12 Hours
Full Cure:	5 Days

Shelf Life:	1 Year Minimum
Finish:	High Gloss of 95+
Color:	Selected Range

Surface Preparation

All surfaces to be painted should be dry and free of all foreign contaminants. Apply over #26 Fast Dry Primer/Sealer, #35 HiBond Sanding Primer, #475R Dry-Fall Epoxy Primer, #77 HiGrip Epoxy Primer or 97 HiGrip Polyamide Epoxy Mastic.

Mixing and Application Requirements

1) Stir Base thoroughly prior to use. 2) Mix entire contents of Part "A" Activator with Part "B" Base (3:1 by volume). 3) There is no induction period, product may be sprayed immediately. 4) Reducer is not needed; however, if desired, use #26 Fast Reducer or #64 Slow Reducer depending on air temperature. 5) Entire mixture should be strained prior to use. 6) Apply at a rate of 293 to 440 square feet per gallon to obtain the recommended film thickness.

Method of Application

Conventional Gun:	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	15-20 psi
Hose:	1/2 inch ID

Airless Gun:	Graco 205-591
Pump:	30:1/45:1/60:1, gas driven pump acceptable
Tip Range:	3.011 – 5.013
Pump Pressure:	1800 psi minimum
Hose:	3/8 inch ID

Brush or Roller:	Touch-up only
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.

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