



**65R Series Topcoat** is an extremely fast drying single package modified acrylic. Its overspray is designed to be powder dry within 10-20 feet from the point of application. This allows painting to continue without worry of paint overspray damage to equipment and vehicles. 65R Series has outstanding gloss and weathering properties making it an excellent choice for large plants, trailers, equipment and vehicles.

- Vehicle Type:** Modified Solvent Based Acrylic
- Pigmentation:** Varies with color (Lead Free)
- Reducers:** No Reduction Necessary
  - Below 80°F:** Highland #32-E Reducer
  - Above 80°F:** Highland #30-E Reducer
  - To Maintain Wet Edge:** Highland 36-E Reducer (Maximum 5%)
- Mix Ratio:** Single Package
- Pot Life:** Not Applicable
- Volume Solids:** 35% (+/- 1%)
- Theoretical Coverage:** 560 ft<sup>2</sup>/gal. @ 1 Mil DFT
- Flash Point:** -4°F (Lowest Flashing Component)
- Recommended DFT:** 2-3 mils DFT = 5.7 – 8.5 mils WFT
- Dry-time:** **Normal**
  - To Touch:** 5 minutes
  - Tack Free:** 30 Minutes
  - To Recoat:** 20 Minutes
  - To Handle:** 1-2 Hours
  - Put in Service:** 12Hours
- VOC:** <400 g/L
- Shelf Life:** 1 Year Minimum
- Finish:** Gloss, Semi-Gloss, Satin
- Color:** Selected Range

**Typical Systems**

Primer	Topcoat
475R Dry-Fall Epoxy (2-3 mils DFT)	65R Series 2-3 mils DFT
84-DF Series Dry-Fall Phenolic Modified Alkyd 2-3 mils DFT	65R Series 2-3 mils DFT

**Surface Preparation**

- 1) All surfaces to be painted should be dry and free of all foreign contaminants.
- 2) Apply over desired primer (See Typical Systems)

**Mixing Instructions and Reduction**

No reduction is necessary to achieve Dry-Fall properties. If desired, reduce up to 5% with one of the following Highland VOC 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.

36-E Highland Blending Reducer may be used for extremely hot temperatures (90 °F), to help overspray blend in. (Do not exceed 5%)

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.**

**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 – 5.011
- Pump Pressure:** 1800 psi allowing +/- 25 psi for surges
- Hose:** 3/8 inch ID (Do not use whip lines)
- Brush or Roller:** Acceptable when reduced with Highland #105 Brush & Roll 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.
- 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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