



HiShield 68R-CA Series Dry-Fall 2-K Aliphatic Urethane Topcoat

HiShield 68R-CA Series is a high performance 2-K aliphatic urethane topcoat designed to be powder dry within 10-20 feet from the point of application, allowing painting to continue without the worry of overspray damage to nearby vehicles or equipment. 68R-CA Series offers the perfect combination of color purity, flexibility, and UV & corrosion protection even when exposed to a variety of harsh climatic and chemical environments. This product meets SSPC-Paint 36 specifications for 2-K weatherable aliphatic urethanes. **68R-CA is specifically formulated to meet VOC requirements in California.**

Vehicle Type:	Aliphatic Urethane
Pigmentation:	Varies with Color (Lead Free)
Reducer:	No Reduction necessary, if desired:
Below 80°F	Highland #32-E Reducer
Above 80°F	Highland #30-E Reducer
To Maintain Wet Edge:	Highland #36-E Blending Reducer (Maximum 5%)
Mix Ratio:	4:1 Base to Activator
Pot Life:	3 Hours @77°F
Volume Solids:	45% +/- 1%
Theoretical Coverage:	720 ft ² /gal. @ 1 mil DFT
VOC:	<250 g/L
Flash Point:	-4° (Lowest Flashing Component)
Recommended DFT:	2-3 mils DFT = 5 - 7.5 mils WFT

Dry-time:

To Touch	10-15 Minutes
Tack Free:	1 Hour
To Recoat:	1 Hour
Dry Hard:	6-8 Hours
Complete Cure:	5-7 Days
Put in Service	12 Hours

Shelf Life:	1 Year from DOM
Finish:	Gloss, Semi-Gloss, Satin
Color:	Selected Range

Typical Systems

Primer	Topcoat
475R Series Dry-Fall Epoxy (2-6 mils DFT)	68R Series (2-3 mils DFT)
84-DF Series Dry-Fall Phenolic Modified Alkyd (2-3 mils DFT)	68R-CA Series (2-3 mils DFT)
325 Series Dry-Fall Zinc Rich Epoxy (3-4 mils DFT)	68R 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

Mix 1 Part “A” Activator with 4 Parts “B” Base. Allow a 5 minute induction period before reduction. Reduction of this product is not normally required. If desired, reduce with one of Highland’s 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 Dry-Fall Reducer for temperatures below 80°F.

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

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 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.
- 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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