



Highland International, Inc.

Engineered Paint Systems

HiGrip 77-LH Series 2-K Epoxy Primer

HiGrip 77-LH Series is a 2-component epoxy specifically formulated to alleviate extensive surface preparation. It may be applied over minimally prepared surfaces (rusty steel and deteriorated previously painted surfaces). HiGrip dries to a flat finish that may be applied up to 6 dry mils per coat. A complex rust inhibitor and resin system serves to assure excellent corrosion protection and adhesion. HiGrip 77-LH Series also serves as an excellent tie-coat between Highland zinc-rich primers and Highland topcoats. It may be topcoated with Highland alkyds, silicone alkyds, acrylics, epoxies, and urethanes.

| | |
|------------------------------|--|
| Vehicle Type: | Polyamide Adduct Epoxy |
| Pigmentation: | Lead Free |
| Reducer: | Not Normally Required Highland #100 Reducer if desired |
| Mix Ratio: | 1:1 (1 Part Base to 1 Part Activator) |
| Pot Life: | 6 Hours @ 77°F (Decreases at higher temperatures) |
| Volume Solids: | 55% +/- 1% |
| Theoretical Coverage: | 882 ft ² /gal. @ 1mil DFT |
| VOC: | <2.76 lbs/mixed gal. (331 g./L.) |
| Flash Point: | 54°F (Lowest Flashing Component) |
| Recommended DFT: | 2-3 mils DFT for normal conditions 4-6 mils DFT for immersion or severe chemical or atmospheric conditions. |
| Dry-time: | |
| To Touch | 3-4 Hours |
| Tack Free: | 4 Hours |
| To Recoat: | 3 Hours |
| To Topcoat: | 4 hours |
| To Handle | 6-8 Hours |
| Put in Service: | 12 Hours |
| Shelf Life: | 2 Year from DOM |
| Finish: | Flat |
| Color: | Selected Range |

Recommended Systems

| <u>Primer</u> | <u>Topcoat</u> |
|--------------------------------|---|
| 77-LH Series (2-6 mils DFT) | AeroShield 61 Series Urethane (2-3 mils DFT) |
| | Or |
| | HiShield 36 Series Urethane (2-3 mils DFT) |

Preparation

- 1) Surface preparation should be in accordance with SSPC-SP6 Commercial Blast Cleaning. When abrasive blast cleaning is not an option, SSPC-SP3 Power Tool or SSPC-SP2 Wire Brushing are acceptable and provide good results. SSPC-SP12 Water-jetting is also acceptable.
- 2) Minimum surface preparation for immersion or under insulation should be in accordance with SSPC-SP5 White Metal Blast.
- 3) All surfaces to be painted should be clean, dry and free of all foreign contaminants.

Mixing and Application Requirements

- 1) Mix 1 Part "A" Activator with 1 part "B" Base (1:1 by volume)
- 2) Mixed material is ready for use after a 30 minute induction period.
- 3) For normal conditions, apply at a rate of 294-441 square feet per gallon to obtain the recommended dry film thickness of 2 to 3 mils DFT. For immersion service or severe conditions, apply at a rate of 147 to 220 square feet per gallon to obtain 4-6 mils DFT per coat.

Method of Application

| | |
|--------------------------|-------------------|
| Conventional Gun: | DeVilbiss MBC-510 |
| Fluid Tip: | E |
| Air Cap: | 704 |
| Atomizing Pressure: | 70 psi |
| Pot Pressure: | 15-20 psi |
| Hose: | ½ inch ID |

| | |
|---------------------|---------------------------------|
| Airless Gun: | Graco 205-591 |
| Pump: | 30:1/45:1/60:1, gas driven pump |
| Tip Range: | 3.011 – 4.015 |
| Pump Pressure: | 1800 psi minimum |
| Hose: | 3/8 inch ID |
| Brush or Roller: | Natural or synthetic bristle |
| Clean Up: | Clean all equipment with MEK |

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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 (MSDS) for complete safety instructions.

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