



Highland International, Inc.

Engineered Paint Systems

90-PT Series Pre-Treatment Etching Primer

90-PT Series is a two component modified epoxy pre-treatment primer designed to promote adhesion and corrosion resistance for problematic substrates such as galvanealed or galvanized steel, and aluminum. This fast dry, VOC compliant (<3.5 lbs/gal; 420 g/L) primer provides long term adhesion and will enhance the corrosion protection of subsequent primer/topcoat systems.

Vehicle Type:	Modified Epoxy
Pigmentation:	Lead Free
Reducer:	No Reduction Necessary
Volume Solids:	30%
Theoretical Coverage:	481 ft ² /gal. @ 1mil DFT
VOC:	3.32 lbs/ gallon (398 g/L)
Flash Point:	16°F (Lowest Flashing Component)
Recommended DFT:	.5 – 1 mil DFT (1.6 – 3.3 mils wet)
Pot Life:	6+ hours at 77°F
Dry-time (at 77°F):	
To Touch:	15 minutes
Tack Free:	30 minutes
Topcoat:	2 hours; 30 days maximum
Shelf Life:	1 Year from DOM
Finish:	Flat
Color:	Translucent Dark Green

Compatible Substrates

90-PT is formulated for use on:

Galvanized, galvanealed, cold rolled steel, aluminum, or as a tie coat for previously painted surfaces.

Typical Systems

OEM

<u>Primer</u>	<u>Topcoat</u>
90-PT (.5-1 mil DFT)	36 or 61 Series Urethane (3-4 mils DFT) OR
90-PT (.5-1 mil DFT)	77 or 97 Series Epoxy Midcoat (2-3 mils DFT) +
	36 or 61 Series Urethane Topcoat (2-3 mils DFT)

Maintenance

<u>Primer</u>	<u>Topcoat</u>
90-PT (.5-1 mil DFT)	77 or 97 Series Epoxy Midcoat (2-3 mils DFT) +
	36 or 61 Series Urethane Topcoat (2-3 mils DFT)

90-PT may also be topcoated with Highland HiGlo Series and HiTemp Series Primers and Topcoats. Consult a sales representative for further information.

The technical data listed herein has been compiled for your convenience and guidelines are based upon our experience and knowledge. However, since we have no control over the use of this information or this product, no warranty expressed or implied is intended or given. Highland assumes no responsibility whatsoever for coverage, performance or any other damage, including injuries from use of this information or products recommended herein.

Surface Preparation

New Substrate: Solvent clean surface with lint-free/dye-free cloth using the wipe on/wipe off method as not to allow solvent to dry over surface. Apply 90-PT as soon as possible after cleaning to minimize further contamination. Tack cloths are not recommended.

Previously Coated Substrate: Existing coatings should be tested for lifting. If lifting occurs, removal of the existing coating will be required prior to application. If existing coatings are in-tact, scuff the surface with 220-grit sandpaper to remove gloss and achieve a uniform surface. Solvent clean the surface with lint-free/dye-free cloth using the wipe on/wipe off method as not to allow solvent to dry over surface. Apply 90-PT as soon as possible after cleaning to minimize further contamination. Tack cloths are not recommended.

All surfaces should be clean, dry and free of all foreign contaminants.

Application Requirements

- 1) Mix product thoroughly before activation.
- 2) Combine all of Part A with all of Part B and agitate for 5 minutes.
- 3) Reduction is not recommended.
- 4) Spray-apply in one uniform wet coat at a rate of 481 – 962 square feet per gallon to achieve 0.5 – 1 mil DFT (1.5-3.0 wet mils)
- 5) Subsequent primer/topcoat systems can be applied after 2 hours @ 77F and up to 30 days without scuffing the surface.

Method of Application

Conventional Gun:	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	15-20 psi
Hose:	½ inch ID
Airless Gun:	Graco 205-591
Pump:	30:1/45:1/60:1, Gas pump acceptable
Tip Range:	3.011 – 4.011
Pump Pressure:	1800 psi minimum
Hose:	3/8 inch ID
Brush or Roller:	Natural or synthetic bristle
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.