

250-TC Series

HiTemp 250°F Epoxy Ester Topcoat



Highland 250-TC high solids heat resistant coatings are based on a one-component specially modified epoxy resin. The coatings air dry by polymerization and oxidation to form a tough, durable, heat, chemical, and moisture vapor resistant film. They do not require any complex heat-curing schedule to obtain their heat resistant properties.

Tech Specs

Heat Resistance:	500°F Constant
Color Stability:	250°F for Standard and Custom 500°F for Black and Silver
Vehicle Type:	Epoxy Ester
Reducer:	Highland 250 Reducer
Mix Ratio:	Single Package
Pot Life:	N/A
Volume Solids:	46%
Theoretical Coverage:	737ft ² /gal. @ 1 mil DFT
VOC:	less than 3.5 lbs/gal (420 g/l)
Flash Point:	40°F (Lowest Flashing Component)
Dry Film Thickness:	1-2 mils DFT
Wet Film Thickness:	2.2 – 4.3 mils WFT

Dry-time:	Normal
To Touch:	30 Minutes
To Recoat:	30 Minutes to 1½ Hours If 1½ hours or more have passed wait 7 days before topcoating
Cure Requirements:	Air Dry
Hot Application:	N/A
Shelf Life:	2 Years Minimum
Finish:	Gloss
Color:	Standard & Custom Colors
Packaging:	1, 5, & 55 gallon containers
Storage Temperature:	40°F - 100°F

Surface Preparation

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

A SSPC-SP1 Solvent Cleaning with Highland 901 Cleaning Solvent is recommended before blasting or other cleaning method.

Carbon Steel:

Best: A SSPC-SP 10 Near White Metal Blast to achieve a low blast profile of 1.0-1.5 mils is recommended

Good: A SSPC-SP6 Commercial Blast will provide good results in most situations.

Acceptable: While abrasive blast cleaning is preferred, when it is not an option, Hand or Power Tool Cleaning per SSPC-SP3 may be used and will provide good results.

Stainless Steel:

Surface must be clean and dry. Remove all oil, grease, soil, drawing and cutting compounds and other foreign matter by solvent cleaning per SSPC-SP1.

Mixing & Application

Mixing: Highland 250-TC Series needs to be thoroughly mixed using mechanical agitation. It is ready to spray after proper mixing.

To ensure optimal performance, apply according to recommendations below.

Airless Applications

Airless Gun: Titan 740 Impact or equivalent
Pump Pressure: 2700 – 3100 PSI
Manifold Filter: 60 Mesh
Gun Filter: 60 Mesh

Hose: 1/4 inch ID
Gun: LX-8011 or equivalent
Tip Range: .015 - .021

Recommended Uses

Highland 250-TC is recommended for use wherever resistance to heat, humidity and corrosive atmospheric conditions is required. Can be used as a protective and decorative coating on metal parts, mufflers, hot water and steam lines, where operating temperatures will not exceed 500°F

Typical Systems

Apply 1 coat of 250-TC Series at 1-2 mils DFT in a single uniform coat over one of the following primer options:

250-PR Series Primer 500°F Phenolic Alkyd Primer.

Safety Information

- Use normal precautions such as gloves, facemasks and barrier creams.
- Adequate ventilation must be maintained. In confined areas, applicators must wear constant flow airline respirators.
- If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention.
- This product contains FLAMMABLE materials. Keep away from sparks and open flames. Observe NO SMOKING regulations.
- All electrical equipment and installations should conform to NEC regulations. In areas where explosion hazards exist, applicators should be required to use nonferrous tools, and to wear conductive, non sparking shoes.
- Observe low flash regulations.
- Refer to Safety Data Sheet (SDS) for complete safety instruction