

# 45C Series

## Spray Safe Dry-Fall Universal Tie Coat Primer



45C Series is an extremely fast drying modified acrylic Primer. Its overspray is designed to dry to a powder 10-20 feet from point of application. This allows painting to continue without the worry of paint overspray damage to equipment and vehicles. 45C Series has a combination of rust inhibitors making it an excellent choice for painting large plants, tanks, trailers, equipment, and vehicles. 45C was specifically formulated as a tie coat for priming existing coatings without lifting. 45C can also accept a variety of topcoats including urethanes.

### Tech Specs

<b>Heat Resistance:</b>	For Ambient Services Only	<b>Wet Film Thickness:</b>	4.8-7.1 mils WFT
<b>Vehicle Type:</b>	Modified Oil Based Acrylic	<b>Dry-time:</b>	<b>Normal</b>
<b>Reducer:</b>	Required for Dry-Fall Effect	<b>To Touch:</b>	5 Minutes
<b>In Summer:</b>	Highland #30-E Reducer	<b>Tack Free:</b>	10 Minutes
<b>In Winter:</b>	Highland #32-E Reducer	<b>To Topcoat:</b>	20 Minutes
<b>Mix Ratio:</b>	Single Package	<b>To Handle:</b>	1-2 Hours
<b>Pot Life:</b>	N/A	<b>Put in Service:</b>	12 Hours
<b>Volume Solids:</b>	42%	<b>Shelf Life:</b>	2 Years Minimum
<b>Theoretical Coverage:</b>	672ft <sup>2</sup> /gal. @ 1 mil DFT	<b>Finish:</b>	Flat
<b>VOC:</b>	<400 g/L	<b>Color:</b>	Gray
<b>Flash Point:</b>	-4°F (Lowest Flashing Component)	<b>Packaging:</b>	5 Gallon Pails
<b>Dry Film Thickness:</b>	2-3 mils DFT	<b>Storage Temperature:</b>	20°F - 110°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-SP6/NACE 3 Commercial Cleaning is recommended for maximum coating performance and longevity.

**Good:** A SSPC-SP3 or SSPC-SP2 Power Tool or Hand Tool Cleaning provides good results. Also, water jetting in accordance with SSPC-SP12 is acceptable.

#### **Galvanized Steel or Aluminum:**

Contact a Highland representative as recommendation will vary depending on substrate and exposure conditions.

### Mixing & Application

**Mixing:** Highland 45C Series needs to be thoroughly mixed using mechanical agitation.

**Reduction:** To achieve the Dry-Fall effect Highland 45C Series must be reduced by 10%-15% with one of the following Highland reducers:

    #30-E Highland Warm Weather Dry-Fall Reducer for temperatures 80°F and above

    #32-E Highland Cold Weather Dry-Fall Reducer for temperatures below 80°F

**Note:** 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.

To assure Dry-Fall effect, do not apply in temperatures below 45°F, on surfaces below 40°F, or humidity above 85% Rh. 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. Do not apply in temperatures that are 5°F or less from the dew point. Do not use whip lines.

Highland 45C Series is designed for spray application. To ensure optimal performance, apply according to the following recommendations.

**Airless Gun:** Graco 205-591 (or equivalent)

**Pressure:** Apply at 1800psi allowing +/- 25 psi for surges.

**Tip sizes:** 3.011 – 4.013

**Airless Pumps:** 30:1, 45:1, 60:1

**Hose:** 3/8 inch ID

**Brush or Roller:** Both are acceptable – Requires reduction with Highland #105 Brush & Roll Reducer.

**Conventional Gun:** DeVilbiss MBC-510 (or equivalent)

**Fluid Tip:** E

**Air Cap:** 704

**Atomizing Pressure:** 60-80 psi

**Pot Pressure:** 15-20 psi

**Hose:** 1/2 inch ID

**Clean Up:** Clean all equipment with Highland #901 Cleaning Solvent

## Typical Systems

Highland 45C Series may topcoated with variety of Highland Topcoats:

Apply 1 coat of 45C Series at 2-3 mils DFT as a primer then topcoat with one of the following options.

65-R Series	Dry-Fall Gloss Acrylic Topcoat
68-R Series	Dry-Fall High Gloss Urethane Topcoat
150 Series	Gloss Alkyd Enamel Topcoat
865-LH Series	Gloss Silicone Alkyd Topcoat
36-HF Series	Ultra-High Gloss Urethane Topcoat

Highland 45C Series may be topcoated with a wide variety of topcoats. For more options please call your Highland representative.

## 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