

68R Series

Spray Safe Dry-Fall Aliphatic Urethane Topcoat



68R 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 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.

Tech Specs

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| Heat Resistance: | For Ambient Services Only |
| Vehicle Type: | Aliphatic Urethane |
| Reducer: | No Reduction Necessary |
| In Summer if desired: | Highland #30-E Reducer |
| In Winter if desired: | Highland #32-E Reducer |
| To Maintain Wed Edge: | Highland #36-E Reducer |
| Mix Ratio: | 4:1 Base to Activator |
| Pot Life: | N/A |
| Volume Solids: | 41% |
| Theoretical Coverage: | 657ft ² /gal. @ 1 mil DFT |
| VOC: | <340 g/L |
| Flash Point: | -4°F (Lowest Flashing Component) |
| Dry Film Thickness: | 2-3 mils DFT |

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|-----------------------------|--------------------------|
| Wet Film Thickness: | 4.9-7.3 mils WFT |
| Dry-time: | Normal |
| To Touch: | 10-15 Minutes |
| Tack Free: | 1 Hour |
| To Recoat: | 1 Hour |
| Complete cure: | 5-7 Days |
| Put in Service: | 12 Hours |
| Shelf Life: | 2 Years Minimum |
| Finish: | Gloss, Semi-Gloss, Satin |
| Color: | Standard & Custom Colors |
| Packaging: | 5 Gallon Kits |
| Storage Temperature: | 20°F - 110°F |

Surface Preparation

All surfaces should be clean, dry and free of all foreign contaminants. Apply over Highland approved primer. Consult Highland technical data sheet for recoat windows on approved primer before application. See typical systems for primer options.

Mixing & Application

Mixing: Highland 68-R Series needs to be thoroughly mixed using mechanical agitation. Mix entire contents of Part "A" Activator with Part "B" Base (4:1 by volume). Allow a minimum 15 minute induction period before application.

Reduction: No reduction is necessary to achieve Dry-Fall properties. If desired, reduce up to 5% with one of the following Highland VOC Exempt 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

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

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 68R 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 – 5.011

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.

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

Typical Systems

Highland 68-R Series may applied over with variety of Highland primers:

Apply 1 coat of 68-R Series at 2-3 mils DFT over one of the following options.

475R Series Primer

Dry-Fall 2K Epoxy Primer

84-DF Series Primer

Dry-Fall Phenolic Modified Alkyd Primer

97 Series Primer

Non Dry-Fall Epoxy Mastic Primer

Highland 68R 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