

97 Series

HiGrip Epoxy Mastic Primer/DTM



HiGrip 97 Series is a surface tolerant 2-component Direct to Metal Epoxy Mastic Primer/DTM specifically formulated to alleviate extensive surface preparation. HiGrip may be applied over slightly damp and minimally prepared surfaces (rusty steel and deteriorated previously painted surfaces). HiGrip dries to a semi-gloss finish and may be applied up to 8 dry mils per coat. A complex rust inhibitor and resin system serves to assure excellent chemical and atmospheric corrosion protection in a single coat system. 97 Series may be topcoated with urethanes, epoxies, alkyds, silicone alkyds and acrylics.

Tech Specs

Heat Resistance:	For Ambient Services Only
Vehicle Type:	Polyamide Adduct Epoxy
Reducer:	Not Normally Required
If desired:	Highland #901 Reducer
Mix Ratio:	1:1 Base to Activator
Base:	97-HF-####
Activator:	97-AHF-100
Pot Life:	4 Hours @ 77°F (Decreases in higher temperatures)
Volume Solids:	70%
Theoretical Coverage:	882ft ² /gal. @ 1 mil DFT
VOC:	<331 g/L (<2.76 lbs/mixed gal.)
Flash Point:	54°F (Lowest Flashing Component)
Dry Film Thickness:	4-8 mils DFT for normal conditions 8-14 mils DFT for immersion or other severe conditions.
Wet Film Thickness:	5.7-11.4 mils WFT per coat

Dry-time:	Normal
To Touch:	1-2 Hours
Tack Free:	2-3 Hours
To Recoat:	2 Hours; Maximum 5 days
To Topcoat:	2 Hours; Maximum 5 days
To Handle:	6 Hours
Complete Cure:	5 Days @ 77°F
Put in Service:	12 Hours (normal conditions) 24 Hours (mild chemical conditions) 5 days (severe chemical conditions)
Shelf Life:	2 Years Minimum
Finish:	Flat
Color:	Standard & Custom
Packaging:	10 Gallon Kits
Storage Temperature:	20°F - 110°F
Application Temperature:	
Ambient:	45°F Minimum
Substrate:	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 - Immersion:

Obtain a 2-3 mil angular blast profile using one of the recommended methods below.

Best: A SSPC-SP5/NACE 1 White Metal Blast Cleaning is recommended for maximum coating performance and longevity.

Good: A SSPC-SP10/NACE 2 Near White Metal Blast Cleaning provides good results.

Carbon Steel - Non-Immersion:

Obtain a 2-3 mil angular blast profile using one of the recommended methods below.

Best: A SSPC-SP6/NACE 3 Commercial Blast Cleaning provides good results.

Good: A SSPC-SP3 Power Tool Cleaning, SSPC-SP2 Hand Tool Cleaning, or waterjetting per SSPC-SP 12 to WJ-4 will provide good results.

Galvanized Steel:

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

Mixing & Application

Mixing: Highland 97 Series needs to be thoroughly mixed using mechanical agitation. Mix entire contents of Part "A" Activator (97-AHF-100) with Part "B" Base (97-HF-####) (1:1 by volume). Mixed material is ready for use after a 30 minute induction period.

Reduction: Reduction is not required for standard applications, If desired, reduce by 0% - 20% with Highland 901 reducer.

Highland 97 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 minimum to achieve an even fan pattern.

Tip sizes: 3.011-5.017

Airless Pumps: 30:1, 45:1, 60:1 (Gas Pumps are acceptable)

Brush or Roller: Both are acceptable for touch up

Conventional

Gun: DeVilbiss MBC-510 (or equivalent)

Fluid Tip: E

Atomizing Pressure: 60 psi

Pot Pressure: 15-20 psi

Hose: 3/8 inch ID

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

Typical Systems

Highland 97 Series may be topcoated with a variety of Highland Primers:

Apply 1 coat of 97 Series at 4-8 mils DFT as a primer then topcoat with one of the following options.

36 Series Topcoat	Ultra-High gloss 2K urethane
150 Series Topcoat	High gloss single component alkyd
865 Series Topcoat	High gloss single component silicone alkyd
840 Series Topcoat	Dry-Fall satin finish silicone alkyd
65R Series Topcoat	Dry-Fall gloss acrylic
68R Series Topcoat	Dry-Fall high gloss urethane

Highland 97 Series may be topcoated with a variety of Highland Topcoats. Contact your Highland representative for more details.

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

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