

77-SP Series

HiGrip 2K Epoxy Surfacing Primer



HiGrip 77-SP is a 2-component epoxy surfacing primer specifically formulated for rugged OEM applications where ultimate protection, beauty, and fast topcoat times are desired. HiGrip 77-SP dries to a high semi-gloss finish that allows for optimal topcoat holdout and overall system appearance. 77-SP may be applied up to 6 dry mils per coat and can accept subsequent coats and topcoats 30 minutes after application. A complex rust inhibitor and resin system serves to assure excellent corrosion protection and adhesion. HiGrip 77-SP also serves as an excellent tie-coat between Highland zinc-rich primers and Highland topcoats. It may be topcoated with a variety of Highland topcoats, with Highland's Route 66 Series Polyurethane Topcoat being the preferred finish for heavy duty OEM applications.

Tech Specs

Heat Resistance:	200°F Constant
Vehicle Type:	Polyamide Epoxy
Reducer:	Not normally required
In summer if desired:	Highland #100 Reducer
In Winter if desired:	Highland #120 Reducer
Mix Ratio:	1:1 Base to Activator
Base:	77-SP-####
Activator:	77-ASP-100
Pot Life:	4 Hours @ 77°F (Decreases in higher temperatures)
Volume Solids:	52 +/-2%
Theoretical Coverage:	802-866 ft ² /gal. @ 1 mil DFT
VOC:	<385 g/L (<3.2 lbs/mixed gal.)
Flash Point:	60°F (Lowest Flashing Component)

Dry Film Thickness:	2-3 mils DFT for normal conditions 4-6 mils DFT for immersion or other severe conditions
Wet Film Thickness:	4-6 mils WFT per coat
Dry-time:	Normal
To Touch:	30 minutes
Tack Free:	45 minutes
To Topcoat:	30 minutes
To Handle:	4 hours
Shelf Life:	2 Years Minimum
Finish:	Semi-Gloss
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 water jetting 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: Hi-Grip 77-SP needs to be thoroughly mixed using mechanical agitation. Mix entire contents of Part "A" Activator (77-ASP-100) with Part "B" Base (77-SP-####) (1:1 by volume). Mixed material is ready for use after a 15 minute induction period.

Reduction: Reduction is not required for standard applications. If desired, reduce by 0% - 10% with Highland 100 or 120 reducer.

Hi-Grip 77-SP 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 2100 psi to achieve an even fan pattern.

Tip sizes: 3.013-4.015

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

Hose: 1/2 inch ID

Brush or Roller: Both are acceptable for touch up. Highland #100 Reducer may be used for a smoother film appearance.

Conventional

Gun: DeVilbiss MBC-510 (or equivalent)

Fluid Tip: 1.6-1.8 mm

Atomizing Pressure: 50-70 psi

Pot Pressure: 15-20 psi

Hose: 1/2 inch ID

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

Typical Systems

Hi-Grip 77-SP may be topcoated with a variety of Highland Topcoats:

Apply 1 coat of 77-SP at 2-3 mils DFT followed by one of the following topcoats:

66 Series Topcoat (preferred)

150 Series Topcoat

865 Series Topcoat

840-G Series Topcoat

65R Series Topcoat

68R Series Topcoat

Ultra-High Gloss Heavy Duty 2K Polyurethane

High gloss single component alkyd

High gloss single component silicone alkyd

Dry-Fall gloss silicone alkyd

Dry-Fall gloss acrylic

Dry-Fall high gloss urethane

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 instructions