

68R Series Spray-Safe Dry-Fall 2-K 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

Heat Resistance:	Up to 250°F	Wet Film Thickness:	4.4-6.6 mils WFT
Vehicle Type:	Aliphatic Urethane	Dry-time:	Normal
Reducer:	No Reduction Necessary	To Touch:	10-15 Minutes
In Summer if desired:	Highland #30-E Reducer	Tack Free:	1 Hour
In Winter if desired:	Highland #32-E Reducer	To Recoat:	1 Hour
To Maintain Wet Edge:	Highland #36-E Reducer	Complete cure:	5-7 Days
Mix Ratio:	4:1 Base to Activator	Put in Service:	12 Hours
Base:	68-R-####	Shelf Life:	2 Years Minimum
Activator:	68-R-100	Finish:	High-Gloss, Semi-Gloss, Satin
Pot Life:	3 Hours @77°F	Color:	Standard & Custom Colors
Volume Solids:	41%	Packaging:	1 & 5 Gallon Kits
Theoretical Coverage:	721ft ² /gal. @ 1 mil DFT	Storage Temperature:	20°F - 110°F
VOC:	<340 g/L	Application Temp:	
Flash Point:	-4°F (Lowest Flashing Component)	Ambient:	45°F Minimum
Dry Film Thickness:	2-3 mils DFT	Substrate:	40°F - 100°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 1 Part "A" Activator (68-R-100) with 4 Parts "B" Base (68-R-####). Allow a 5 minute induction period before reduction.

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%)

Dry-Fall Application Instructions: To assure Dry-Fall effect, do not apply in temperatures below 45°F, on surfaces below 40°F, or humidity above 85% Rh. When humidity is above 50%, take caution to observe the dry-fall range as it may extend slightly past the 20 foot mark, up to 50 feet depending on other weather variables. 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. Whip lines are not allowed unless they are 3/8 inch ID. Swivels are acceptable.

Highland 68R Series is designed for spray application. To ensure optimal performance, apply according to the following recommendations.

Airless Applications

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.

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

Typical Systems

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

475R Series Primer

VOC Compliant 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

The technical data listed herein has been compiled for your convenience and guidelines are based upon our experience and knowledge. However, since we have no control over the use of this information or this product, no warranty expressed or implied is intended or given. Highland assumes no responsibility whatsoever for coverage, performance or any other damage, including injuries from use of this information or products recommended herein.