



Highland International, Inc.



Technical Data Sheet

77-HF Series HiGrip High Solids Epoxy DTM/Primer (HAPS Free)

77-HF Series HiGrip is a 2-Component Direct to Metal Epoxy specifically formulated to alleviate extensive surface preparation. HiGrip may be applied over minimally prepared surfaces (rusty steel and deteriorated previously painted surfaces). HiGrip dries to a flat finish that may be applied up to 6 dry mils per coat. A complex rust inhibitor & resin system serves to assure excellent corrosion protection in the HiGrip Single Coat System or when using it as a primer. HiGrip serves as an excellent tie coat between zinc rich primers and the topcoat of your choice. It may be topcoated with alkyds, silicone alkyds, acrylics, urethanes, & epoxies.

Vehicle Type:	Polyamide Adduct Epoxy	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Lead Free	To Touch	1-2 hours	N/A
Reducers:	Highland #100 if desired	Tack Free	2-3 hours	N/A
Mixing Ratio:	1:1 (1 Part Base to 1 Part Activator)	To Recoat	2 hours	N/A
Pot Life:	6 Hours @ 77°F	To Topcoat	4-6 hours	N/A
	(Decreases at higher temps)	To Handle	8 hours	N/A
Volume Solids:	55%	Put in Service	12 hours or 1 week for immersion	
Theoretical Coverage:	880 Sq. Ft. per Gallon @ 1 mil DFT	V.O.C.:	2.76 lbs per mixed gallon (331 grams/liter)	
Flash Point:	54°F lowest flashing component	Shelf Life:	2 year minimum	
Recommended DFT (DTM):	6-8 mils for normal conditions or	Finish:	Flat	
	8-10 mils for immersion or severe	Color:	Selected Range	
	chemical or atmospheric conditions	Weight:	10.5 lbs. per gallon	
Recommended DFT (primer):	2-3 mils for normal conditions or	Cure Time:	Full Cure in 7 days	
	4-6 mils for immersion or severe			
	chemical or atmospheric conditions			

Preparation: 1) Minimum surface preparation should be in accordance with SSPC-SP6 Commercial Blast cleaning. When blast cleaning is not an option, SSPC-SP3 Powertool or SSPC-SP2 Wire Brushing is acceptable and provides good results. Also, water jetting in accordance with SSPC-SP12 is acceptable. Surfaces should be dry and free of contaminants.

2) Minimum surface preparation should be in accordance with SSPC-SP5 White Metal Blast for immersion.

Application Requirements: 1) Mix entire contents of part "A" Activator with Part "B" Base (1 to 1 by volume) **2)** Mixed material is ready for use after a 30 minute induction period. **3)** Apply at a rate of 110 to 147 square feet per gallon to obtain the recommended film thickness for normal use. **4)** Apply at a rate of 88 to 110 square feet per gallon to obtain the recommended film thickness for immersion. **5)** May see normal service after 24 hours. **6)** Allow one week before being put into service for immersion.

Method of Application: Conventional Spray

Airless Spray:

Gun:	DeVilbiss MBC-510	Gun:	Graco 205-591
Fluid Tip:	E	Pump:	30:1
Air Cap:	704	Tip Range:	3.011 to 4.015 @ 1800 psi minimum
Atomizing Pressure:	60 psi	Hose:	3/8 inch ID
Pot Pressure:	15-20 psi		
Hose:	1/2 inch ID		
Brush or Roller:	Natural or synthetic bristle recommended		
Clean Up:	After use, clean all equipment with lacquer thinner		

Safety Precautions: (a) Use normal precautions such as gloves, facemasks, and barrier creams.

(b) Adequate ventilation must be maintained. In confined areas, workmen must wear constant flow airline respirators. **(c)** If product comes into contact with skin, wash thoroughly with lukewarm

water or diluted Boric Acid, and obtain immediate medical attention. **(d)** This product contains **FLAMMABLE** materials. Keep away from sparks and open flames. Observe **NO SMOKING** regulations.

(e) All electrical equipment and installations should conform to NEC regulations. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools, and to wear conductive, non sparking shoes. **(f)** Observe low flash regulations. **(g)** Refer to Material Safety Data Sheet (MSDS) for complete safety instructions.

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