



Highland International, Inc.



Technical Data Sheet

325-SC-DF45 Series HiZinc Dry-Fall 2-K Zinc Rich Epoxy Primer

325-SC-DF45 Series HiZinc is a High Performance 2-Component Zinc Rich Epoxy Primer that has been limited to 100 grams per liter VOC. Its overspray is designed to dry to a powder 10-20 feet from the point of application, allowing painting to continue without the worry of paint overspray damaging nearby vehicles and equipment. 325-SC-DF45 Series offers outstanding abrasion resistance and protection against undercutting and corrosion by cathodic protection.

Vehicle Type:	Zinc Rich Epoxy Primer	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Zinc Dust	To Recoat	Min 2-3 Hrs (Max 28 Days)	N/A
Reducers for		To Touch	30 Minutes	N/A
Dry-Fall Application:	30-E for 80°F and above	To Handle	3 Hours	N/A
	32-E for below 80°F	Complete Cure	5-7 Days @ 77°F	N/A
Mixing Ratio:	9:1 Base to Acitvator	Topcoats	Epoxies and/or Urethanes only	
Pot Life:	4 Hours @ 77°F(decreases at higher temps)	V.O.C.:	100 grams per liter	
Volume Solids:	50% (+/- 1%)	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	800 Sq ft. per mil per gallon	Finish:	Flat	
Flash Point:	lowest flashing component -8°F	Color:	Yellow-Gray	
Recommended DFT:	3-4 mils for very good corrosion protection in moderate conditions			
Recommended WFT:	7.5-10 mils wet after reduction will achieve 3-4 mils DFT			

Preparation: For immersion, a SSPC-SP5 White Metal Blast is required. A minimum Commercial Blast, SSPC-SP6 is recommended.

Where blast cleaning is not practical, SSPC-SP3 Powertool or SSPC-SP2 Wire Brushing is acceptable and provides excellent results. Also, water jetting to WJ4 in accordance with SSPC-SP12 is acceptable. All surfaces to be painted should be dry and free of all foreign contaminants.

Application: To assure Dry-Fall effect, do not apply in temperatures below 45°F, on surfaces below 40°F, or humidity above 85%.

Make sure the equipment you are using to spray with will give you accurate PSI readings so that the pressure from the pump can be maintained at 1800 psi allowing a maximum +/- 25 psi for surges.

The product will continue curing to temperatures of 30°F. Do not apply in temperatures that are 5°F or less from the dew point.

Reduction: Mix .5 Gallon Part "A" Activator with 4.5 Gallons Part "B" Base. Allow a 20 minute induction period **before reduction**.

For Dry-Fall effect you must reduce activated material 10-20%. Reduce with one of the following Highland Exempt Reducers:

#30-E Highland VOC Exempt Warm Weather Dry-Fall Reducer for temperatures 80°F and above

#32-E Highland VOC Exempt Cold Weather Dry-Fall Reducer for temperatures below 80°F

If "fingering" occurs during the spray application, increase the amount of thinner, which decreases the viscosity of the paint. **Do not increase the pump pressure. Maintain 1800 psi allowing +/- 25 psi for surges.**

The following spray equipment is suitable for applying this coating. * It is also necessary to keep the material under mild agitation during the application. If spraying stops for more than 10 minutes, recirculate the material remaining in the spray line. Do not leave mixed primer in the hoses during work stoppages.**

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: .015" to .019" @ 1800 psi
Atomizing Pressure:	70 psi	Hose: 3/8 inch ID (Do not use whip lines)
Pot Pressure & Hose:	15-20 psi 1/2" ID	
Brush or Roller:	touch up only	Clean Up: 30-E or 32-E or 1:1 mix of Xylene & MEK

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.

The technical data listed herein has been compiled for your convenience and guidelines and is based upon our experience and knowledge. However, since we have no control over the use of this information or this product, no warranty express 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 of products recommended herein.

However, when applied according to manufacturers specifications, these products will perform as indicated.

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