



Highland International, Inc.



Technical Data Sheet

335-DF Series HiZinc Dry-Fall Inorganic Zinc Rich Primer

335-DF Series HiZinc is a High Performance 2-Component Inorganic Zinc primer that cathodically protects steel. Its overspray is designed to dry to a powder within 20 feet from point of application, allowing painting to continue without the worry of paint overspray damaging nearby equipment and vehicles. 335-DF Series offers outstanding abrasion resistance and protection against undercutting and corrosion in normal to severe atmospheric conditions.

Vehicle Type:	Solvent Based Inorganic Zinc	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Zinc Dust	To Topcoat	18 Hours	N/A
Dry Temp Resistance w/:		To Touch	15 Minutes	N/A
No Topcoat:	750°F Continuous - 800°F Excursions	To Handle	2 Hours	N/A
Recom. Silicone Topcoat:	1000°F Continuous	Complete Cure	7 Days @ 77°F	N/A
Zinc Content in Dry Film:	79%	Topcoats	Epoxies, Urethanes, 100% Silicones	
Pot Life:	7-8 Hrs @ 77°F (shorter at higher humidity)	V.O.C.:	2.8 lbs per gallon (333 grams/liter)	
Volume Solids:	52% (+/- 1%)	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	832 Sq ft. per mil per gallon	Finish:	Flat	
Flash Point:	lowest flashing component 40°F	Color:	Yellow-Gray	
Mixing Instructions:	2 components; mix all zinc content (component B) to base (component A)			
Recommended DFT:	2 - 3 mils for excellent corrosion protection in moderate and severe conditions			
	Do not exceed 3 dry mils. Mudcracking of the coating could occur.			
Recommended WFT:	4 - 5.5 mils wet will achieve 2-3 mils DFT			

Preparation: Minimum surface preparation should be in accordance with SSPC-SP6 Commercial Blast cleaning. Obtain a 1-3 mil angular blast profile. For best results and immersion applications, an SSPC-SP5 White Metal Blast is recommended. 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's curing will slow drastically in temperatures below 40°F.

Do not apply in temperatures that are 5°F or less from the dew point.

Reduction: Must Reduce 10-20% with:

#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.

Application: When applying a topcoat over #335 Inorganic Zinc Primer, first apply a mist coat over the #335 and wait for the solvents to flash off. Then apply a regular coat of the recommended topcoat in accordance with the manufacturer's instructions.

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:	.017" to .021" @ 2100-2500 psi
Atomizing Pressure:	70 psi	Hose:	3/8 inch ID (Do not use whip lines)
Pot Pressure & Hose:	15-20 psi 3/8" ID (min.)		
Brush or Roller:	#105 Reducer	Clean Up:	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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