



Highland International, Inc.

Technical Data Sheet



335 Series HiZinc Inorganic Zinc Rich Primer

335 Series HiZinc is a High Performance 2-Component Inorganic Zinc primer that cathodically protects steel. 335 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:	<u>Normal Application</u>	<u>Hot Application</u>
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 Requirements: 1) Mix entire contents of part "B" zinc content with Part "A" Base 2) Stir mixed material thoroughly. Mixed material is ready for use immediately. 3) **Reduction:** If desired, reduce up to 10% with the proper reducer (30-E or 32-E). 4) Apply at a rate of 277 to 416 square feet per gallon to obtain the recommended film thickness.

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.

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