



Highland International, Inc.

Technical Data Sheet



80 Series High Solids Structural Primer (One Coat)

80 Series is a single package phenolic modified alkyd primer that is limited to under 3.5 lbs. VOC per gallon and features an elaborate system of rust inhibitors to assure outstanding corrosion protection even in rugged climatic environments. It also offers maximum adhesion and corrosion protection even in limited surface preparation areas. 80 Series may be topcoated with a wide range of topcoats (silicone alkyds, alkyds, urethanes, and acrylics). Its light color allows lead-free orange, yellow and red topcoats to be applied in only "One Coat" for proper hiding. This light color scheme is also designed to show shadows in steel surfaces until proper film thickness has been reached to further assure maximum corrosion protection.

Vehicle Type:	Phenolic Modified Alkyd	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Zinc Phosphate (Lead & Chromate Free)	To Touch	1-2 Hours	N/A
Reducers:	Not Normally Required	Tack Free	2-3 Hours	N/A
Summer if Desired:	Highland #100	To Topcoat	2 Hours	N/A
Winter if Desired:	Highland #120	To Handle	4-6 Hours	N/A
Mixing Ratio:	Single Package	Put in Service	12 Hours	N/A
Pot Life:	Not Applicable	V.O.C.:	3.5 lbs. per gallon (419 grams/liter)	
Volume Solids:	52%	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	832 Sq. Ft. per Gallon @ 1 Mil DFT	Finish:	Flat	
Flash Point:	63°F (Lowest Flashing Component)	Color:	Off White	
Recommended DFT:	2-3 Mils	Weight:	11.5 lbs. per gallon	

Preparation: 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.

Application Requirements: (1) Stir product thoroughly prior to use. (2) Apply at a rate of 277 to 416 square feet per gallon to obtain the recommended film thickness. (3) Topcoat with Highland 865 Series, 840 Series, 150C Series, 65C Series, 36 Series or 37 Series.

Method of Application: Conventional or Airless

Conventional Spray

Airless Spray:

Gun:	DeVilbiss MBC-510	Gun:	Graco 205-591
Fluid Tip:	E	Pump:	30:1
Air Cap:	704	Tip Range:	3.013 - 4.015 @ 1800 psi minimum
Atomizing Pressure:	60 psi	Hose:	3/8 inch ID
Pot Pressure:	20 psi		
Hose:	1/2 inch ID		
Brush or Roller:	Both are acceptable		
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.

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.

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