



Highland International, Inc.



Technical Data Sheet

#810-DF Series Dry-Fall HiTemp 1300°F Topcoat/DTM

810-DF HiTemp Series is the result of extensive research and testing into maximum paint performance under extremely elevated temperatures. It will adhere to metal and provide corrosion protection on surfaces up to 1300°F. Its overspray is designed to dry to a powder 10-20 feet from point of application allowing spray application without the worry of paint overspray damage to nearby vehicles or equipment. **NOTE: This product will not completely cure until exposed to proper heat requirements (see Cure Time below).** Also, excessive DFT could result in bubbles or delamination of the coating.

| | | | | |
|--------------------------------|------------------------------------|-----------------------|--|------------------------|
| Vehicle Type: | Silicone Copolymer | Dry-Time: | Normal Application | Hot Application |
| Pigmentation: | Special heat resistant extenders | To Touch | 30 Minutes | N/A |
| Reducers for | | Tack Free | 1 Hour | N/A |
| Dry-Fall Application: | 30-E for 80°F and above | To Recoat | 1-2 Hours | N/A |
| | 32-E for below 80°F | To Handle | 1-2 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 per liter) | |
| Volume Solids: | 36% | Shelf Life: | 1 Year Minimum | |
| Theoretical Coverage: | 576 Sq. Ft. per Gallon @ 1 Mil DFT | Finish: | Flat | |
| Flash Point: | 40°F (Lowest Flashing Component) | Color: | #810 Black, #808 Gray or #807 Aluminum | |
| Recommended DFT: | | Weight: | 10.5 Lbs. Per Gallon | |
| When used as a DTM: | 3-5 mils | Cure Time: | 4 Hr. @ Minimum 250°F to Max. 500°F or | |
| When used as a Topcoat: | 2-3 mils | | 1 Hour Minimum 475°F to Maximum 500°F | |

Preparation: Minimum acceptable surface preparation should be in accordance with SSPC-SP6 Commercial Blast. A low profile blast (1.5 Mil., no more than 2 Mils) is preferred. Apply directly to steel in two coats to achieve the proper DFT or apply over #830 or #860 HiTemp Primers up to 450°F. For extra durability and corrosion protection, apply over #74 AcidTemp 500°F Epoxy Hybrid up to 500°F, #15-ZN Silicone-Zinc Primer up to 1000°F or #335 Series HiZinc Inorganic Zinc Rich Primer up to 1000°F.

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 to temperatures below 40°F. (see Cure Time for complete heat curing requirements)

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

Reduction: Must Reduce 10% 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.**

| 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: 0.011 |
| Atomizing Pressure: | 60 psi | Hose: 3/8 inch ID (Do not use whip lines) |
| Pot Pressure: | 15-20 psi | Pump Pressure 1800 psi allowing +/- 25 psi for surges |
| Hose: | 3/8 inch ID | |
| Brush or Roller: | Reduce 10% min. with #105 Reducer | Clean Up: Use 30-E or 32-E Reducer or 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.

P. O. Box 3564 Boone, NC 28607

800-444-1438

www.highland-international.com