



Highland International, Inc.



Technical Data Sheet

#812 Series HiTemp 600°F High Solids DTM

#812-HA Series HiTemp 600°F DTM for Hot Surface Application

HiTemp #812 Series is a silicone alkyd high heat coating effective on steel surfaces up to 600°F. #812-HA has been modified so that it can be applied directly to hot surfaces up to 325°F.

Vehicle Type:	Silicone Alkyd	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Heat stable black iron oxide	To Touch	30 Minutes	N/A
Reducers for:		Tack Free	2 Hours	N/A
Normal Application:	Not normally required	To Recoat	1 Hour	immediately
#812-HA Hot Application:	#101 Reducer (20%)	To Handle	3-4 Hours	N/A
Mixing Ratio:	Single Package	Put in Service:	12 Hours	12 Hours
Pot Life:	Not Applicable	V.O.C.:	2.84 lbs per gallon (340 grams/liter)	
Volume Solids:	51%	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	816 Sq. Ft. per Gallon @ 1 Mil DFT	Finish:	Flat	
Flash Point:	19°F (Lowest Flashing Component)	Color:	Black	
Recommended DFT:	3-4 Mils	Weight:	11.62 pounds per gallon	

Preparation: All surfaces to be painted should be dry and free of contaminants. 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. May be applied 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 Epoxy Hybrid Coating up to 500°F.

Application Requirements: (1) Stir product thoroughly prior to use. (2) Apply at a rate of 204 to 272 square feet per gallon to obtain the recommended film thickness.

Special Notes: To prevent delamination and/or gas bubbles, do not exceed 5 mils DFT.

Allow 12 hours after application before putting into service.

Special Notes for Hot Application: 812-HA Hot Application formula may be applied directly to hot surfaces not exceeding 325°F.

Reduce and apply in multiple successive coats not exceeding 1 mil DFT to achieve the recommended film thickness for application to hot surfaces.

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:	3.011 to 4.015 @ 1800 psi minimum
Atomizing Pressure:	60 psi	Hose:	3/8" ID
Pot Pressure:	15-20 psi		
Hose:	3/8 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.

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P. O. Box 3564 Boone, NC 28607

800-444-1438

www.highland-international.com