



Highland International, Inc.



Technical Data Sheet

815 Series HiTemp 500°F Acrylic Silicone Topcoat

815-HA Series HiTemp 500°F Acrylic Silicone DTM for Hot Surface Application to 400°F

Reducer Selection Allows for Ambient or Hot Surface Application

815 Series is an air dry single package acrylic silicone copolymer paint designed to provide excellent color stability and corrosion protection at continuous surface temperatures up to 500°F. It will withstand short term temperature excursions up to 600°F.

815-HA is a modified version designed for application to hot surfaces up to 400°F (when reduced with Highland #101 Reducer).

Vehicle Type:	Acrylic Silicone Copolymer	Dry-Time:	Normal Application	Hot Application
Pigmentation:	Lead Free, Zinc Phosphate	To Touch	15 Minutes	N/A
Reducers for:		Tack Free	1 Hour	N/A
Normal Application	Not Normally Required	To Recoat	1-2 Hours	Immediately
Hot Application	#101 Hot Application Reducer (20%)	To Handle	1-2 Hours	N/A
Mixing Ratio:	Single Package	Put in Service:	12 Hours	12 Hours
Pot Life:	Not Applicable	V.O.C.:	3.49 lbs. per gallon (418 grams/liter)	
Volume Solids:	50%	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	800 Sq. Ft per Gallon @ 1 Mil DFT	Finish:	Flat	
Flash Point:	65°F (Lowest Flashing Component)	Color:	Selected Range	
Recommended DFT:	Topcoat - 2 to 3 mils	Cure Time:	4 Hr. @ Minimum 250°F to Maximum 500°F or	
	DTM - 4 to 5 mils		1 Hour Minimum 475°F to Maximum 500°F	

WHEN USING AS A TOPCOAT:

Preparation: All surfaces to be painted should be dry and free of contaminants. Apply over #860 HiTemp primer (up to 450°F), #74-HF (up to 500°F), #15-ZN Modified Silicone Zinc Primer, or #335 Series Hi-Zinc Inorganic Zinc Primer.

Application Requirements: (1) Stir product thoroughly prior to use. (2) Apply at a rate of 266 to 400 square feet per gallon to obtain the recommended film thickness.

FOR HOT SURFACE APPLICATION AS A DTM: Pay attention to dry times for ambient vs. hot surface application.

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 Mil) is preferred.

Application Requirements: (1) Special formula 815-HA may be applied to hot surfaces not exceeding 400°F. (2) Stir product thoroughly prior to use. (3) Reduce 20% with Highland # 101 Reducer. (4) Apply in multiple successive coats not exceeding 1 mil DFT to achieve the recommended film thickness when applied to hot surfaces over 200°F.

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

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:	3.011 - 3.015 @ 1800 psi minimum
Atomizing Pressure:	60 psi	Hose:	3/8 inch ID
Pot Pressure:	20 psi		
Hose:	1/2 inch ID		
Brush or Roller:	Touch Up Only		
Clean Up:	After use, clean all equipment with #101 Reducer		

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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