



Highland International, Inc.

Engineered Paint Systems

815 Series HiTemp
500°F Acrylic Silicone Topcoat

815 Series is an air dry single package acrylic silicone copolymer topcoat designed to provide excellent color stability and corrosion protection for surfaces up to 500°F for all standard and custom colors. It will provide dry temperature resistance on surfaces up to 800°F, providing color stability to 800°F for black, aluminum, and a limited number of gray colors.

Vehicle Type:	Acrylic Silicone Copolymer
Pigmentation:	Lead Free, Zinc Phosphate
Reducer:	Not Normally Required
Mix Ratio:	Single Package
Pot Life:	Not Applicable
Volume Solids:	50%
Theoretical Coverage:	800 ft ² /gal. @ 1 Mil DFT
Flash Point:	65°F (Lowest Flashing Component)
Recommended DFT:	Topcoat 2-3 mils
Dry Temp Resistance:	800°F
Color Stability:	500°F (for standard & custom colors) 800°F (black, aluminum, some grays)
Dry-time:	
To Touch:	15 minutes
Tack Free:	1 Hour
To Recoat:	1-2 Hours
To Handle	1-2 Hours
Put in Service:	12 Hours
VOC:	3.49 lbs per gallon (418 grams/liter)
Shelf Life:	1 Year from DOM
Finish:	Flat, satin, semi-gloss
Color:	Selected Range
Cure Time:	Air Dry

Preparation

- 1) All surfaces to be painted should be dry and free of all foreign contaminants.
- 2) 815 Series may be applied over intact, previously painted surfaces or any of the following Highland International primers:
 - a) #860 HiTemp Primer (up to 400°F)
 - b) 47-HF Chem-Temp Primer (up to 500°F)
 - c) #880 HiTemp 1200°F High Build Primer
 - d) #15-ZN HiTemp 1000°F Silicone Zinc Primer

Mixing and 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 of 2-3 mils.

Method of Application

Conventional Gun:	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	20 psi
Hose:	½ inch ID

Airless Gun:	Graco 205-591
Pump:	30:1
Tip Range:	3.011 – 3.015
Pump Pressure:	1800 psi minimum
Hose:	3/8 inch ID

Brush or Roller:	Touch Up Only
Clean Up:	Clean all equipment with #101 Reducer

Safety Precautions

- 1) Use normal precautions such as gloves, facemasks and barrier creams.
- 2) Adequate ventilation must be maintained. In confined areas, workmen must wear constant flow airline respirators.
- 3) If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention.
- 4) This product contains **FLAMMABLE** materials. Keep away from sparks and open flames. Observe **NO SMOKING** regulations.
- 5) 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.
- 6) Observe low flash regulations.
- 7) Refer to Material Safety Data Sheet (MSDS) for complete safety instructions.

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