



Highland International, Inc.

Technical Data Sheet



84-DF Series Dry-Fall High Performance Structural Rust Inhibitive Primer (Low HAPs)

84-DF Series is a rust inhibitive phenolic modified alkyd surface tolerant primer that is 2.8 lbs. VOC per gallon. It features an elaborate system of rust inhibitors to assure outstanding corrosion protection even in rugged climatic environments. 84-DF also offers maximum adhesion and corrosion protection even in limited surface preparation areas. 84-DF may be topcoated with a wide range of topcoats (silicone alkyds, alkyds, epoxies, urethanes, and acrylics). Its overspray is designed to dry to a powder within 10-20 feet from the point of application. The light color scheme is 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	20-30 Minutes	N/A
Reducers & Reduction:	Reduce 20% With Proper Reducer	Tack Free	1 Hour	N/A
Summer (above 80F):	30-E VOC Exempt Warm Weather Reducer	To Topcoat	Min-1 Hour Max-No Limit	N/A
Winter (below 80F):	32-E VOC Exempt Regular Reducer	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.:	2.8 Lbs. per Gallon	
Volume Solids:	61%	Shelf Life:	1 Year Minimum	
Theoretical Coverage:	976 Sq. Ft. per Gallon @ 1 Mil DFT	Finish:	Flat	
Flash Point:	24°F (Lowest Flashing Component)	Color:	Off White	
Recommended DFT:	2-3 Mils	Weight:	13.51 lbs. per gallon	

Preparation: Commercial Blast, SSPC-SP6 is recommended for steel when practical. Where blast cleaning is not practical, SSPC-SP3 Power tool or SSPC-SP2 Wire Brushing is acceptable and provides excellent results. Also, water jetting in accordance with SSPC-SP12 is acceptable. Surfaces should be dry and free of 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.

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

Reduction: Must reduce 20% 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 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:	.011 - .015
Atomizing Pressure:	60 psi	Hose:	3/8 inch ID (Do not use whip lines)
Pot Pressure:	20 psi	Pump Pressure	1800 psi allowing +/- 25 psi for surges
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.

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