

HIGHLAND INTERNATIONAL

Engineered Paint Systems

#80 Series One Coat High Solids Structural Primer

80 Series is a single package phenolic modified alkyd primer that is limited to under 3.5 lbs. VOC per gallon. 80 Series features an elaborate system of rust inhibitors to assure outstanding corrosion protection even in rugged climatic environments. It also offers maximum adhesion and corrosion protection even in limited surface preparation areas. 80 Series may be topcoated with a wide range of topcoats (silicone alkyds, alkyds, urethanes, and acrylics). Its light color allows lead-free orange, yellow and red topcoats to be applied in only "one coat" for proper hiding. This light color scheme is also designed to show shadows in the steel surface until proper film thickness has been reached to further assure maximum corrosion protection.

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|------------------------------|--|--------------------|---|
| Vehicle Type: | Phenolic Modified Alkyd | Dry Time: | To Topcoat – 2-3 Hours Tack Free – 1-2 Hours |
| Pigmentation: | Zinc Phosphate (Lead & Chromate Free) | Recommended | |
| Thinner: | Summer – if desired – Highland #100 Winter – if desired – Highland #120 | DFT: | 2 –3 Mils |
| Mixing Ratio: | Single Package | Color: | Off White & Gray |
| Pot Life: | Not Applicable | Finish: | Flat |
| Flash Point: | 63°F (Lowest Flashing Component) | Shelf Life: | 1 Year Minimum |
| Volume Solids: | 52% | VOC: | 3.5 Lbs. per Gallon (419 grams/ltr) |
| Theoretical Coverage: | 832 Sq. Ft. per Gallon @ 1 Mil DFT | | |

Application Requirements: (1) Minimum surface preparation should be in accordance with SSPC-SP6 Commercial Blast Cleaning. (2) In highly corrosive areas, a Near White Metal Blast in accordance with SSPC-SP10 is recommended. When abrasive Blast Cleaning is not practical, SSPC-SP3 Powertool or Wire Brushing is acceptable and provides good results. (3) Stir product thoroughly prior to use. (4) Apply at a rate of 266 to 400 square feet per gallon to obtain recommended film thickness in one coat. (5) Topcoat with Highland 865 Series, 835 Series, 150 Series, or 36 Series.

Method of Application: Conventional Spray or Airless

CONVENTIONAL SPRAY

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

AIRLESS SPRAY

| | |
|-----------|---|
| Gun | Graco 205-591 |
| Pump | 30:1 |
| Tip Range | 3.013 – 3.015 or 4.013 – 4.015 @ 1800 p.s.i. |
| Hose | 3/8 inch ID |

Brush or Roller: Both are acceptable

Safety Precautions: (a) Use normal precautions such as gloves, face masks, 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 the skin, wash thoroughly with lukewarm water and soap. If eyes are contaminated, flush with 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.

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