

# HIGHLAND INTERNATIONAL

## Engineered Paint Systems

### #854 Series DTM High Solids Silicone Alkyd (Urethane Modification Optional)

854 Series is a single package Direct-to-Metal silicone alkyd. 854 Series may be applied over marginally prepared surfaces (light rust & mil scale), when the 854A100 Urethane Modifier is added. As a single package 854 Series will exhibit very good gloss and color retention as well as corrosion protection. However, these qualities will be greatly enhanced when the 854A100 Urethane Modifier is added.

				<u>Urethane Modified</u>
<b>Vehicle Type:</b>	Silicone Alkyd	<b>Dry Time:</b>	Set to Touch – 30 Minutes	5 Minutes
<b>Pigmentation:</b>	Lead Free		Tack Free – 2 Hours	1 Hour
<b>Thinner:</b>	Summer – if desired – Highland #100 Winter – if desired – Highland #120		To Recoat – 3 hours	5 Minutes
<b>Mixing Ratio:</b>	Single Package – Urethane modification optional (Mix 1 qt 854A100 Urethane Modifier per 1 gal. Of 854 Series Base)	<b>Recommended DFT:</b>	Handling – 4-5 Hours	2-3 Hours
<b>Pot Life:</b>	Not applicable as a single component when activated – 3-4 hrs	<b>Color:</b>	4 - 6 Mills	
<b>Flash Point:</b>	81°F (Lowest Flashing Component)	<b>Finish:</b>	Selected Range	
<b>Volume Solids:</b>	60% +/-1	<b>Shelf Life</b>		1 Year Minimum
<b>Theoretical Coverage:</b>	960 Sq. Ft. per Gallon @ 1 Mil DFT	<b>VOC:</b>		335 Grams Per Liter (Unactivated) 352 Grams Per Liter (With Urethane Modifier)

**Application Requirements:** (1) All surfaces to be painted should be clean, dry, and free of all foreign contaminants. However, when urethane modified, it may be applied over tightly bonded rust & mil scale (2) Stir product thoroughly prior to use. (3) Apply at a rate of 160 to 240 square feet per gallon to achieve recommended film thickness.

**Method of Application:** Conventional or Airless Spray. Brush and Roller

#### 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 psi min.
Hose	3/8 inch ID

**Brush or Roller:** Apply in one coat @ 7 to 10 mils wet to achieve recommended dry film thickness. When urethane modifier is added a second coat may be applied in 5 Minutes.

**Clean Up:** After use, clean all equipment with lacquer thinner

**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 International, Inc. assumes no responsibility whatsoever for coverage, performance, or any other damage, including injuries from use of this information of products recommended herein. jw 09-23-03

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