



HiTemp Dry-Fall 15-ZN-DF Series
Silicone Copolymer Primer

HiTemp 15-ZN-DF Series is a 2-Component special silicone copolymer zinc primer that cathodically protects steel and is designed for heat affected zones up to 1000°F. **This coating requires a heat cure at a minimum temperature of 250°F for 4 hours or a minimum 475°F to maximum 500°F for 1 hour.** Overspray from 15-ZN-DF dries to a powder within 10-20 feet from point of application and eliminates paint overspray damage.

Vehicle Type:	Silicone Copolymer
Pigmentation:	Zinc Dust
Reduce:	10-20% with proper reducer
Below 80°F:	Highland #32-E Reducer
Above 80°F:	Highland #30-E Reducer
To Maintain Wet Edge:	Highland #36-E Blending Reducer
Mix Ratio:	Two- Component
Pot Life:	N/A
Volume Solids:	41%
Theoretical Coverage:	656 ft ² /gal. @ 1 mil DFT
VOC:	<420 g/L
Flash Point:	-4°F (Lowest Flashing Component)
Recommended DFT:	2-3 mils DFT
Dry-time:	
To Touch:	1 Hour
Tack Free:	30 Minutes
To Recoat:	1-2 Hours
To Handle:	2 Hours
Put in Service:	12 Hours
Shelf Life:	2 Years from DOM
Finish:	Eggshell
Color:	Yellow, Gray
Cure Requirements:	4 Hour ambient flash
	4 hour min. @ 250°F to Max 500°F
	1 hour min. @ 475°F to max 500°F

Surface Preparation

- 1) Minimum acceptable surface preparation should be in accordance with SSPC-SP6 Commercial Blast cleaning when practical
- 2) For best results and immersion applications, SSPC-SP5 White Metal Blast is recommended.
- 3) Obtain a 1-3 mil angular blast profile.
- 4) All surfaces to be painted should be dry and free of all foreign contaminants.

Mixing and Application Requirements

To assure Dry-Fall effect, do not apply in temperatures below 45°F, on surfaces below 40°F, or humidity above 85% Rh. When humidity is above 50%, take caution to observe the dry-fall range as it may extend slightly past the 20 foot mark, up to 50 feet depending on other weather variables.

Mix entire contents of Part “B” Zinc Dust with Part “A” Base under constant agitation. **(Zinc Dust must be added to Base. DO NOT ADD BASE TO ZINC DUST!)**

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- Reduction: 15-ZN-DF must be reduced 10-20% with:
 - a) 30E VOC Exempt Warm Weather Reducer for temperatures 80°F and above
 - b) 32E VOC Exempt Cold Weather Reducer for temperatures 80°F and below
 - c) 36E VOC Exempt Blending Reducer to help blend in when temperatures are above 90°F. Do not exceed 5% reduction with 36E.
- All surfaces should be clean, dry and contaminant free.
- Spray-apply at a rate of 218-328 square feet per gallon to obtain recommended DFT.
- Under constant agitation, apply in one coat to achieve 2-3 mils DFT. Wait 2-3 hours before applying proper Highland topcoat.
- 15ZN should **ONLY** be used with Highland 805 Series Topcoat. Contact a Highland representative for approval of alternative topcoat.
- If “fingering” occurs during the spray application, increase the amount of reducer, which decreases the viscosity of the paint. **Do not increase the pump pressure. Maintain 1800 psi allowing +/- 25 psi for surges.**
- 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 will give accurate PSI readings so that the pressure from the pump will maintain 1800 psi allowing a maximum +/-25 psi for surges.**
- Curing will slow drastically in temperatures below 40°F. See “Cure Time” for complete heat curing requirements.
- Do not apply in temperatures 5°F or less from the dew point

Method of Application

The following equipment is suitable for applying this coating. It is also necessary to keep the material under mild agitation during the application. If spraying stops for more than 10 minutes, recirculate the material remaining in the spray line. Do not leave mixed material in the hoses during work stoppages.

Airless Gun:	Graco 205-591
Pump:	30:1/45:1/60:1, Gas Pump Acceptable
Tip Range:	.021 to .025
Pump Pressure:	1800 psi allowing +/-25 psi for surges
Hose:	3/8 inch ID (Do not use whip lines)

Conventional Gun: Consult a Highland Representative

NOTE: Electric driven pumps not recommended



Brush or Roller: Reduce with #105 Brush & Roll
Reducer for touch up only
Clean Up: Clean all equipment with lacquer cleaner

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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