



# Highland International, Inc.

## Engineered Paint Systems

### HiTemp 15-ZN Series Silicone Copolymer Primer

**HiTemp 15-ZN 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.**

<b>Vehicle Type:</b>	Silicone Copolymer
<b>Pigmentation:</b>	Zinc Dust
<b>Reduce:</b>	Not Normally Required
<b>In summer if desired:</b>	Highland #100 Reducer
<b>In winter if desired:</b>	Highland #120 Reducer
<b>Mix Ratio:</b>	Two-Component
<b>Pot Life:</b>	N/A
<b>Volume Solids:</b>	41%
<b>Theoretical Coverage:</b>	656 ft <sup>2</sup> /gal. @ 1 mil DFT
<b>VOC:</b>	<420 g/L
<b>Flash Point:</b>	-4°F (Lowest Flashing Component)
<b>Recommended DFT:</b>	2-3 mils DFT
<b>Dry-time:</b>	
<b>To Touch:</b>	1 Hour
<b>Tack Free:</b>	30 Minutes
<b>To Recoat:</b>	1-2 Hours
<b>To Handle:</b>	2 Hours
<b>Put in Service:</b>	12 Hours
<b>Shelf Life:</b>	2 Years from DOM
<b>Finish:</b>	Eggshell
<b>Color:</b>	Yellow, Gray
<b>Cure Requirements:</b>	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 1-2 mil angular blast profile.
- 4) All surfaces to be painted should be dry and free of all foreign contaminants.

#### Mixing and Application Requirements

- 1) 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!)**
- 2) All surfaces should be clean, dry and contaminant free.
- 3) No reduction is necessary.
- 4) Spray-apply in 1 coat at a rate of 218-328 square feet per gallon to obtain recommended DFT.

- 5) Under constant agitation, apply in one coat to achieve 2-3 mils DFT. Wait 2-3 hours before applying proper Highland topcoat.
- 6) 15-ZN should **ONLY** be used with Highland 805 Series Topcoat. Contact a Highland representative for approval of alternative topcoat.

#### 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.**

<b>Conventional Gun:</b>	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	15-20 psi
Hose:	3/8 inch ID
<b>Airless Gun:</b>	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)
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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