



# Highland International, Inc.

## Engineered Paint Systems

### 325 Series 2-K Zinc Rich Epoxy Primer

**325 Series** is a high performance 2-component zinc rich epoxy primer with 84% zinc dust in dry film offering outstanding abrasion resistance and protection against undercutting and corrosion by cathodic protection.

<b>Vehicle Type:</b>	Zinc Rich Epoxy
<b>Pigmentation:</b>	Zinc Dust
<b>Reducer:</b>	Not Necessary
<b>Reduce if Desired:</b>	Use 901 (Up to 10% for spray application)
<b>Mix Ratio:</b>	9:2 Base to Activator
<b>Pot Life:</b>	3 Hours @77°F (Decreases in higher temps)
<b>Volume Solids:</b>	50% (+/- 1%)
<b>Theoretical Coverage:</b>	800 ft <sup>2</sup> /gal. @ 1 mil DFT
<b>VOC:</b>	2.84 lbs/gal. (340 g/L)
<b>Flash Point:</b>	70° (Lowest Flashing Component)
<b>Recommended DFT:</b>	3-4 mils DFT = 6-8 mils WFT
<b>Package Size:</b>	5.5 Gallon Kit (4.5 base, 1 activator)

#### Dry-time:

<b>Recoat</b>	Min: 2-3 hrs. Max: 28 Days
<b>To Touch:</b>	30 Minutes
<b>To Handle:</b>	3 Hours
<b>Complete Cure:</b>	5-7 Days @ 77°F

<b>Topcoats:</b>	Epoxies & Urethanes only
<b>Shelf Life:</b>	1 Year Minimum
<b>Finish:</b>	Flat
<b>Color:</b>	Gray-Green

#### Surface Preparation

1) For immersion, an SSPC-SP10 Near White Metal Blast is recommended. 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 good results. Also, water jetting in accordance with SSPC-SP12 is acceptable.

2) All surfaces to be painted should be dry and free of all foreign contaminants.

#### Mixing Instructions and Reduction

Mix 2 Parts "A" Activator with 9 Parts "B" Base. Allow a minimum 15 minute induction period before application. For spray application, reduce up to 10% with # 901 Reducer, if desired.

#### Application Requirements

It is necessary to keep the material under mild agitation during application. If spraying stops for more than 30-45 minutes, recirculate the material remaining in the spray lines.

#### Method of Application

<b>Conventional Gun:</b>	DeVilbiss MBC-510
Fluid Tip:	E
Air Cap:	704
Atomizing Pressure:	60 psi
Pot Pressure:	15-20 psi
Hose:	½ inch ID
<b>Airless Gun:</b>	Graco 205-591
Pump:	30:1/45:1/60:1, Gas Pump Acceptable
Tip Range:	3.011 – 4.015
Pump Pressure:	2100 psi allowing +/- 25 psi for surges
Hose:	3/8 inch ID
<b>Brush or Roller:</b>	Reduce 10% minimum with #105 B&R Reducer
<b>Clean Up:</b>	#901 or 1:1 Blend MEK & Xylene

#### 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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