



325R-DF Series
Dry-Fall 2-K Zinc Rich Epoxy Primer

325R-DF Series is a high performance 2-component zinc rich epoxy primer with 84% zinc dust in dry film. Its overspray is designed to dry to a powder 10-20 feet from point of application, allowing painting to continue without the worry of paint overspray damaging nearby vehicles and equipment. 325R-DF offers outstanding abrasion resistance and protection against undercutting and corrosion by cathodic protection.

Vehicle Type:	Zinc Rich Epoxy
Pigmentation:	Zinc Dust
Reducers for:	
Dry-Fall outside 20 ft:	No Reduction Necessary
Dry-Fall within 10-20 ft:	10% with #32-E Reducer up to 80°F 10% with #30-E Reducer above 80°F
Mix Ratio:	9:2 Base to Activator
Pot Life:	3 Hours @77°F (Decreases in higher temps)
Volume Solids:	50% (+/- 1%)
Theoretical Coverage:	800 ft ² /gal. @ 1 mil DFT
VOC:	2.84 lbs/gal. (340 g/L)
Flash Point:	70° (Lowest Flashing Component)
Recommended DFT:	3-4 mils DFT = 6-8 mils WFT

Dry-time:

Recoat	Min: 2-3 hrs. Max: 28 Days
To Touch:	30 Minutes
To Handle:	3 Hours
Complete Cure:	5-7 Days @ 77°F
Topcoats:	Epoxies & Urethanes only
Shelf Life:	1 Year Minimum
Finish:	Flat
Color:	Gray-Green

Surface Preparation

1) For immersion a 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 excellent 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. No reduction is necessary to achieve Dry-Fall properties over 20 ft. For Dry-Fall effect within 20 ft. you must reduce **activated** material 10%. Reduce with one of the following Highland Exempt Reducers:

30-E Highland VOC Exempt Warm Weather Dry-Fall Reducer for temperatures 80°F and above.

OR:

32-E Highland VOC Exempt Cold Weather Reducer for temperatures below 80°F.

In extremely hot weather (+90°F), **#36-E** Blending Reducer may be used to help overspray blend in. Do not exceed 5% reduction.

If “Fingering” occurs during the spray application, increase the amount of thinner which will decrease the viscosity of the coating. Do not increase the pump pressure. Maintain 2100 psi allowing +/- 25 psi for surges.

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. **Make sure the equipment being used will give accurate psi readings so the pressure from the pump can be maintained at 2100 psi allowing a maximum +/- 25 psi for surges.** Do not apply in temperatures that are 5°F or less from the dew point. Do not use whip lines.

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

Method of Application

Conventional Gun: DeVilbiss MBC-510
Fluid Tip: E
Air Cap: 704
Atomizing Pressure: 60 psi
Pot Pressure: 15-20 psi
Hose: ½ inch ID

Airless Gun: 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 (Do not use whip lines)

Brush or Roller: Reduce 10% minimum with #105 B&R Reducer

Clean Up: #30-E, #32-E 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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