



HiTemp Dry-Fall 805-DF Series
Dry-Fall 1000°F Modified Silicone Copolymer Topcoat

805-DF Series HiTemp Topcoat is a single package modified silicone copolymer coating available in a variety of colors. It is designed to exceed conventional high temperature paint products in temperature cure requirements, heat stability (Thermal Shock), corrosion resistance, color purity, and ease of application. Paint overspray from 805-DF is powder dry within 10-20 feet from point of application and eliminates overspray damage.

NOTE: This product will not completely cure until exposed to proper heat requirements (see Cure Time below). Also excessive DFT may result in bubbles or delamination of the coating.

Vehicle Type:	Modified Silicone Copolymer
Pigmentation:	Lead Free Heat Stable Extenders
Reducer:	
Below 80°F:	Highland #32-E Reducer 10%
Above 80°F:	Highland #30-E Reducer 10%
To Maintain Wet Edge:	Highland #36-E Blending Reducer 10%
Mix Ratio:	Single Package
Volume Solids:	45%
Theoretical Coverage:	800-830 ft ² /gal. @ 1 Mil DFT
Flash Point:	-8°F (Lowest Flashing Component)
Recommended DFT:	3-5 mils
Dry-time:	
To Touch:	15 minutes
Tack Free:	30 Minutes
To Recoat:	1-2 Hours
To Handle	1-2 Hours
Put in Service:	12 Hours
VOC:	<420 g/L
Shelf Life:	1 Year from DOM
Finish:	Flat
Color:	Selected Range
Cure Time:	24 Hour Ambient Flash 4 Hrs. @ minimum 250°F to Max. 500°F or 1 Hr. minimum @ Maximum 500°F

Typical Systems

Primer	Topcoat
15-ZN Silicone Zinc Primer (2-4 mils) 250-1000°F	805-LH Topcoat (2-3 mils)
335 Inorganic Zinc Primer (2-4 mils) 750°F	805-LH Topcoat (2-3 mils)
47 Chem-Temp Epoxy (8-16 mils) 500°F	805-LH Topcoat (2-3 mils)
860 HiTemp Series Primer (2-3) 400°F	805-LH Topcoat (2-3 mils)

Performance Data

Thermal Shock (ASTM D2485)	1200°F	Excellent (Several Cycles)
Pull- Off Adhesion (ASTM D4541)	800 psi	

Surface Preparation

- 1) All surfaces to be painted should be dry and free of all foreign contaminants.
- 2) Apply over desired primer (See Typical Systems)

Mixing Instructions and Reduction

- Stir product thoroughly prior to use
- For Dry-Fall effect, you must reduce 15-20% using:

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

OR

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

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

SPECIAL NOTES: When using as a topcoat apply no more than 2-3 mils DFT. To prevent delamination and/or gas bubbles do not exceed a total dry film thickness of 5 mils when applying as a topcoat or DTM. Allow 12 hours after application before heat cure.

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. **Make sure the equipment being used will give accurate psi readings so the pressure from the pump can be maintained at 1800 psi allowing a maximum +/- 25 psi for surges.** The product will continue curing to temperatures of 30°F. Do not apply in temperatures that are 5°F or less from the dew point. Do not heat cure between coats. Contact a Highland representative to further review your specific spray conditions.

Method of Application

Airless Gun:	Graco 205-591
Pump:	30:1/45:1/60:1, Gas Pump is Acceptable
Tip Range:	3.011 – 4.013
Pump Pressure:	1800 psi minimum
Hose:	3/8 inch ID

Brush or Roller:	Touch Up Only
Clean Up:	Clean all equipment lacquer thinner

NOTE: Electric pumps are NOT recommended. Contact a Highland Representative to review the use of conventional guns.

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.

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- 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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