



# Highland International, Inc.

## Engineered Paint Systems

HiTemp 808-HA

Hot Application 1200°F Silicone Copolymer DTM Gray

**808-HA HiTemp** is the result of extensive research and testing into maximum paint performance under extremely elevated temperatures. It has excellent adhesion to steel surfaces and provides corrosion protection on surfaces with temperatures up to 1200°F.

808-HA has been modified so that it may be applied directly to hot surfaces up to 500°F.

**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.**

<b>Vehicle Type:</b>	Silicone Copolymer
<b>Pigmentation:</b>	Heat resistant gray and extenders
<b>Reducer:</b>	#101 Hot Application Reducer 20%
<b>Mix Ratio:</b>	Single Package
<b>Pot Life:</b>	Not Applicable
<b>Volume Solids:</b>	45%
<b>Theoretical Coverage:</b>	720 ft <sup>2</sup> /gal. @ 1 Mil DFT
<b>Flash Point:</b>	-8°F (Lowest Flashing Component)
<b>Recommended DFT:</b>	2-5 mils as a DTM 2-3 mils as a Topcoat

#### Dry-time:

<b>To Touch:</b>	N/A
<b>Tack Free:</b>	N/A
<b>To Recoat:</b>	Immediately
<b>To Handle</b>	N/A
<b>Put in Service:</b>	N/A

<b>VOC:</b>	3.5 lbs per gallon (419 grams/liter)
<b>Shelf Life:</b>	1 Year from DOM
<b>Finish:</b>	Flat
<b>Color:</b>	Gray
<b>Cure Time:</b>	4 Hrs. @ minimum 250°F to Max. 500°F Or 1 Hr. minimum @ Maximum 500°F

#### Surface Preparation

- 1) All surfaces to be painted should be dry and free of all foreign contaminants.
  - 2) Minimum acceptable surface preparation should be in accordance with SSPC-SP6 Commercial Blast.
  - 3) A low profile blast (1.5 to no more than 2 mils) is preferred.
  - 4) Apply directly to steel in two coats to achieve proper DFT or apply over #830 or #860 HiTemp Primer for temperatures up to 400°F.
- For extra durability and corrosion protection apply over #47 Chem-Temp Hybrid Epoxy Novolac for temperatures up to 500°F, #15-ZN Modified Silicone-Zinc Primer or #335 HiZinc Inorganic Primer for temperatures up to 1000°F.

#### Mixing and Application Requirements

- 1) Stir product thoroughly prior to use
- 2) Apply at a rate of 144-240 square feet per gallon to obtain the recommended film thickness when using as a DTM.
- 3) Apply at a rate of 240-360 square feet per gallon to obtain the recommended film thickness when using as a topcoat.
- 4) Do not heat cure between coats.

**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.

**SPECIAL NOTES FOR HOT APPLICATION:** 808-HA Hot Application formula may be applied directly to hot surfaces not exceeding 500°F. Reduce 20% with Highland #101 and apply in multiple successive coats not exceeding 1 mil DFT to achieve the recommended film thickness for application to hot surfaces.

#### 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:	3/8 inch ID
<b>Airless Gun:</b>	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

#### 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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