



Highland International, Inc.

Engineered Paint Systems

HiTemp 812-HA Black

Hot Application 600°F Silicone Copolymer DTM/Topcoat

HiTemp 812-HA Series is a silicone alkyd high heat coating effective on steel surfaces up to 600°F. 812-HA has been modified so that it may be applied directly to hot surfaces up to 325°F.

Vehicle Type: Silicone Alkyd
Pigmentation: Heat Stable Black Iron Oxide
Reducer: #101 Reducer (20%)
Mix Ratio: Single Package
Pot Life: Not Applicable
Volume Solids: 51%
Theoretical Coverage: 816 ft²/gal. @ 1 Mil DFT
Flash Point: 24°F (Lowest Flashing Component)
Recommended DFT: 3-5 mils as a DTM
2-3 mils as a Topcoat

Dry-time:
To Touch: N/A
Tack Free: N/A
To Recoat: Immediately
To Handle: N/A
Put in Service: 12 Hours

VOC: 2.84 lbs per gallon (340 grams/liter)
Shelf Life: 1 Year from DOM
Finish: Flat
Color: Black

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 450°F.
- For extra durability and corrosion protection apply over #47 Chem-Temp Hybrid Epoxy Novolac for temperatures up to 500°F.

Mixing and Application Requirements

- 1) Stir product thoroughly prior to use
- 2) Apply at a rate of 204-272 square feet per gallon to obtain the recommended film thickness when using as a DTM.
- 3) Apply at a rate of 272-408 square feet per gallon to obtain the recommended film thickness when using as a topcoat.

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.

SPECIAL NOTES FOR HOT APPLICATION: 812-HA Hot Application formula may be applied directly to hot surfaces not exceeding 325°F. Reduce 20% 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

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

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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