



Highland International, Inc.

Engineered Paint Systems

HiTemp 815-HA Series

Hot Application 500°F Acrylic Silicone Topcoat/DTM

815-HA Series is an air dry single package acrylic silicone copolymer topcoat designed to provide excellent color stability and corrosion protection for surfaces up to 500°F for all standard and custom colors. It will provide dry temperature resistance and color stability to 800°F for black, aluminum, and a limited number of gray colors. 815-HA Series is a modified version of 815 Series specifically formulated for application directly to hot surfaces up to 450°F.

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| Vehicle Type: | Acrylic Silicone Copolymer |
| Pigmentation: | Lead Free, Zinc Phosphate |
| Reducer: | 20% with #101 Reducer |
| Mix Ratio: | Single Package |
| Pot Life: | Not Applicable |
| Volume Solids: | 50% |
| Theoretical Coverage: | 800 ft ² /gal. @ 1 Mil DFT |
| Flash Point: | 65°F (Lowest Flashing Component) |
| Recommended DFT: | Topcoat 2-3 mils |
| Dry Temp Resistance: | 800°F |
| Color Stability: | 500°F (for standard & custom colors) 800°F (black, aluminum, some grays) |
| Dry-time: | |
| To Touch: | N/A |
| Tack Free: | N/A |
| To Recoat: | Immediately |
| To Handle | N/A |
| Put in Service: | N/A |
| VOC: | 3.49 lbs per gallon (418 grams/liter) |
| Shelf Life: | 1 Year from DOM |
| Finish: | Flat, satin, semi-gloss |
| Color: | Selected Range |
| Cure Time: | Air Dry |

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-SP10 Near White Metal Blast.
- 3) A low profile blast (1.0 to no more than 1.5 mils) is preferred.

- 4) Apply directly to steel in multiple 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 Epoxy Hybrid for temperatures up to 500°F, #15-ZN Modified Silicone-Zinc Primer or #335 HiZinc Primer for temperatures up to 1000°F.

Mixing and Application Requirements

- 1) Stir product thoroughly prior to use
- 2) Apply at a rate of 266 to 400 square feet per gallon to obtain the recommended film thickness of 2-3 mils.

Method of Application

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| Conventional Gun: | DeVilbiss MBC-510 |
| Fluid Tip: | E |
| Air Cap: | 704 |
| Atomizing Pressure: | 60 psi |
| Pot Pressure: | 20 psi |
| Hose: | ½ inch ID |
| Airless Gun: | Graco 205-591 |
| Pump: | 30:1/45:1/60/1, Gas Pump is Acceptable |
| Tip Range: | 3.011 – 4.015 |
| Pump Pressure: | 2100 psi minimum |
| Hose: | 3/8 inch ID |
| Brush or Roller: | Touch Up Only |
| Clean Up: | Clean all equipment with #101 Reducer |

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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