



# Highland International, Inc.

## Engineered Paint Systems

### HiTemp 815 Series 500°F Acrylic Silicone Topcoat

**815 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 on surfaces up to 800°F, providing color stability to 800°F for black, aluminum, and a limited number of gray colors.

<b>Vehicle Type:</b>	Acrylic Silicone Copolymer
<b>Pigmentation:</b>	Lead Free, Zinc Phosphate
<b>Reducer:</b>	Not Normally Required
<b>Mix Ratio:</b>	Single Package
<b>Pot Life:</b>	Not Applicable
<b>Volume Solids:</b>	50%
<b>Theoretical Coverage:</b>	800 ft <sup>2</sup> /gal. @ 1 Mil DFT
<b>Flash Point:</b>	65°F (Lowest Flashing Component)
<b>Recommended DFT:</b>	Topcoat 2-3 mils
<b>Dry Temp Resistance:</b>	800°F
<b>Color Stability:</b>	500°F (for standard & custom colors) 800°F (black, aluminum, some grays)

#### Dry-time:

<b>To Touch:</b>	15 minutes
<b>Tack Free:</b>	1 Hour
<b>To Recoat:</b>	1-2 Hours
<b>To Handle</b>	1-2 Hours
<b>Put in Service:</b>	12 Hours

<b>VOC:</b>	3.49 lbs per gallon (418 grams/liter)
<b>Shelf Life:</b>	1 Year from DOM
<b>Finish:</b>	Flat, satin, semi-gloss
<b>Color:</b>	Selected Range
<b>Cure Time:</b>	Air Dry

#### Surface Preparation

- 1) All surfaces to be painted should be dry and free of all foreign contaminants.
- 2) 815 Series may be applied over intact, previously painted surfaces or any of the following Highland International primers:
  - a) 860 HiTemp Primer (up to 400°F)
  - b) 47-HF Chem-Temp Primer (up to 450°F)
  - c) 802 HiTemp Primer (up to 500°F)
  - d) 827-HB HiTemp High Build Primer (up to 500°F)
  - e) 15-ZN HiTemp Silicone Zinc Primer (up to 500°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

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

<b>Airless Gun:</b>	Graco 205-591
Pump:	30:1/45:1/60/1, Gas Pump is
Acceptable	
Tip Range:	3.011 – 4.015
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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