



815-DF 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. Paint overspray from 815-DF is powder dry within 10-20 feet from point of application and eliminates overspray damage.

- Vehicle Type:** Acrylic Silicone Copolymer
- Pigmentation:** Lead Free, Zinc Phosphate
- Reducers for Dry-Fall Applications:**
 - Below 80°F: Highland #32-E Reducer 15-20%
 - Above 80°F: Highland #30-E Reducer 15-20%
 - To Maintain Wet Edge: Highland #36-E Blending Reducer up to 5%
- Mix Ratio:** Single Package
- Pot Life:** Not Applicable
- Volume Solids:** 50% +/- 2%
- Theoretical Coverage:** 800 ft² /gal. @ 1 Mil DFT
- Flash Point:** 18°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:**
 - Tack Free:** 1 Hour
 - To Handle:** 12 Hours
 - Put in Service:** 24 Hours
- VOC:** 3.49 lbs per gallon (418 grams/liter)
- Shelf Life:** 1 Year from DOM
- Finish:** Satin
- 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) 815-DF Series may be applied over intact, previously painted surfaces or any of the following Highland International primers:
 - a) 827-HB Multipolomeric Matrix DTM (6-16 mils) Ambient - 500°F
 - b) 15-ZN-DF Silicone Zinc Primer (2-4 mils) 250-500°F
 - c) 335 Inorganic Zinc Primer (2-4 mils) 500°F
 - d) 830 Series HiTemp Dry-Fall Primer (2-3 mils) 400°F

Mixing 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.
- 3) For standard applications, reductions is not necessary. For Dry-Fall Applications, reduce 15-20% with the proper Exempt Reducer:

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

32-E Cold Weather Dry-Fall Reducer for temperatures below 80°F.

36-E Highland Blending Reducer for extremely hot temperatures (>90 °F), to help overspray blend in. (DO NOT EXCEED 5% REDUCTION with 36-E)

If “fingering” occurs during the spray application, increase the amount of thinner which will decrease the viscosity of the coating. **Do not increase the pump pressure. Maintain 1800 psi allowing +/- 25 psi for surges.**

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.** Do not apply in temperatures that are 5°F or less from the dew point. 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 – 4.015
Pump Pressure:	1800 psi +/- 25 psi for surges
Hose:	3/8 inch ID

Brush or Roller:	Touch Up Only
Clean Up:	Clean all equipment with #101 Reducer

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

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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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